

VENDOR'S NAME & ADDRESS:		STANDARD MANUFACTURING QUALITY PLAN							QP. NO.:SQAP/				
		CUSTOMER: BHEL, HYDERABAD – 32.				BHEL P.O.NO.:			REV NO: 00		DATE:		
		PROJECT: PRODUCT: HYDRANT VALVE				P.O.DATE:			PAGE 1 OF 2				
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY P W V			REMARKS
1.0	RAW MATERIALS & BOUGHT OUT ITEMS												
	Body, Bonnet, Female outlet	Chemical, Physical	Major	Analysis Test	One/Lot	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	Lab. /Supp. Certificate	√	2	2	1	
	Spindle	Chemical, Physical	Major	Analysis Test	One/Lot	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	Lab. /Supp. Certificate	√	2	2	1	
	Spring	Chemical	Major	Analysis Test	One/Lot	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	Lab. /Supp. Certificate	√	2	2	1	
	Outer Washer, Seat Washer	Hardness	Minor	Measurement	10%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	Lab. /Supp. Certificate	√	2	2	1	
2.0	INPROCESS INSPECTION												
	Water tightness Seat Test	Leakage	Major	Hydro Test	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IIR	√	2	2	1	
	Hydrostatic Pressure Test	Leakage	Major	Hydro Test	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IIR	√	2	2	1	
	Operation Test	Open-close	Major	Functional	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IIR	√	2	2	1	
	Flow Test	Flow	Major	Flow	One/Lot	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IIR	√	2	2	1	
3.0	FINAL INSPECTION & TESTING												
	Water tightness Seat Test	Leakage	Major	Hydro Test	10%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	1	-	

LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL CQS (OR BHEL NOMINATED INSPECTION AGENCY) & 2 FOR VENDOR/SUB VENDOR AS APPROPRIATE AGAINST EACH COMPONENT /CHARACTERISTIC UNDER P, W & V COLUMNS. * FOR ITEMS MARKED ✓ (TICK) IN COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.	PREPARED BY	APPROVED BY	APPROVED BY
	VENDOR'S SIGNATURE & STAMP	BHEL QA SIGNATURE & STAMP	CUSTOMER'S SIGNATURE & STAMP

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	Hydrostatic Pressure Test	Leakage	Major	Hydro Test	10%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	1	-	
	Operation Test	Open-close	Major	Functional	10%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	1	-	
	Flow Test	Flow	Major	Flow	One/Lot	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	1	-	
4.0	PRESERVATION & PACKING												
	Identification	Marking & Stamping	Major	Verification & Stamping	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	2	1	
	Painting	Final finish & Paint DFT	Major	Visual & Measurement	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	Painting Report	√	2	1	-	
	Packing	Soundness of packing	Major	Verification	100%	Approved BHEL Spec./Drawing/datasheet	Approved BHEL Spec./Drawing/datasheet	IR	√	2	2	1	

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