

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: DELUGE VALVE				P.O.DATE:			PAGE 1 OF 3				
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												
1.1	BODY & COVER (C.I. CASTINGS)	i) MECHANICAL	MAJOR	TENSILE	ONE (1) PER HEAT	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	LAB/MFG. TC	√	2	--	1	
		ii) DIMENSION	MAJOR	MEASUREMENT	AT RANDOM (TWO) PER HEAT	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR		2	2	1	
		iii) PHYSICAL OBSVN.	MAJOR	VISUAL	100%	SURFACE FREE FROM HARMFUL DEFECTS	SURFACE FREE FROM HARMFUL DEFECTS	IR		2	2	1	
1.2	CLAPPER , SEAT & CLAMPS (GM CASTINGS)	i) MECHANICAL TEST & CHEMICAL TEST	MAJOR	TENSILE & CHEMICAL ANALYSIS	ONE (1) PER HEAT	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	LAB/MFG. TC	√	2	--	1	
		ii) DIMENSION	MAJOR	MEASUREMENT	AT RANDOM (TWO) PER HEAT	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR		2	2	1	
		iii) PHYSICAL OBSVN.	MAJOR	VISUAL	100%	SURFACE FREE FROM HARMFUL DEFECTS	SURFACE FREE FROM HARMFUL DEFECTS	IR		2	2	1	
1.3	SEAT, RUBBER & DIAPHRAGM	i) MECHANICAL	MAJOR	UTS	ONE (1) PER HEAT	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	LAB/MFG. TC	√	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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										P	W	V			
		ii) POLYMER TEST	MAJOR	CHEMIC AL TEST & FTIR GRAPH	ONE (1) PER HEAT	NEOPRENE RUBBER	NEOPRENE RUBBER	LAB/MFG. TC	√	2	--	1			
2.0	INPROCESS INSPECTION														
2.1	BODY, COVER CLAPPER CLAMPS, SEAT (DURING MACHINING)	i) PHYSICAL OBSVN. DIMN. CHECK	MAJOR	VISUAL & MEASUR EMENT	100%	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR		2	2	1			
2.2	BODY, COVER CLAPPER CLAMPS, SEAT (AFTER FINAL MACHINING)	I) PHYSICAL OBSVN. DIMN. CHECK	MAJOR	VISUAL & MEASUR EMENT	100%	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR		2	2	1			
2.3	BODY & COVER	I) HYDRO TEST	MAJOR	LEAK PROOF TEST	100%	25 KG/CM2 FOR 5 MINS.	NO LEAKAGE	IR		2	2	1			
2.4	BODY & COVER	I) SURFACE CLEANING	MAJOR	PRESSU RE TEST, DRESSI NG/GRIN DING/ FILING	100%	FREE FROM SURFACE DEFECTS	FREE FROM SURFACE DEFECTS	IR		2	2	1			
3.0	FINAL INSPECTION & TESTING														
3.1	DELUGE VALVE (COMPLETE ASSEMBLY)	I) PHYSICAL OBSVN. DIMN. CHECK	MAJOR	VISUAL & MEASUR EMENT	100% FOR 2 & 10% FOR 1	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR	√	2	1	-			

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										P	W	V	
		II) SEAT LEAK TEST	MAJOR	HYDRO TEST (SEAT)	100% FOR 2 & 10% FOR 1	APP TDS/DRG./ SPEC.	NO LEAKAGE	IR	√	2	1	-	
		III) PERFORMANCE CUM FUNCTIONAL CHECK	CRITICAL	PERFORMANCE TEST	100% FOR 2 & 10% FOR 1	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR	√	2	1	-	
		IV) PAINTING & MARKING	MAJOR	VISUAL	100%	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	IR	√	2	2	1	
4.0	PRESERVATION & PACKING												
4.1	DV. ASSY. (PAINTED)	PROPERLY PACKING WITH NECESSARY MARKING	MAJOR	VISUAL	100%	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	PACKING REPORT		2	2	1	
4.2		PRESERVATION MUST BE MAINTAINED AT PROPER PLACE	MAJOR	VISUAL	100%	APP TDS/DRG./ SPEC.	APP TDS/DRG./ SPEC.	PACKING REPORT		2	2	1	

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