

		MANUFACTURING QUALITY PLAN							MQP. NO.: SMQP/FPS/23/092013				
		PROJECT ENGINEERING & SYSTEMS DIVISION BHEL, RC PURAM, HYD-502032			PRODUCT: CO2 (PORTABLE & TROLLY MOUNTED FIRE EXTINGUISHER)			REV NO: 00		DATE: 01/09/2013			
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SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	*	AGENCY			REMARKS
									D	P	W	V	
1.0	RAW MATERIALS & BOUGHT OUT ITEMS												
1.1	Body (Cylinder)	Visual & Dimn.	Major	Physical Obsvn. & Measure ment	TC/RMTC Review	IS: 7285	IS:7285	TC/RMTC	√	2	2	1	TC/RMTC to be submitted to "1". BIS & CCE approval over cylinder – Document to be submitted to "1"
1.2	Valve	Visual & Dimn.	Major	Physical Obsvn. & Measure ment	TC/RMTC Review	IS:3224	IS:3224	TC/RMTC	√	2	2	1	
1.3	Hose	Burst Pressure	Major	B. P. Test	1/Lot	IS:2878	IS:2878	TC/RMTC/IIR	√	2	2	1	
1.4	CO2 Gas	Quality of Gas	Major	Quality of Gas	TC/RMTC Review	IS:15222	IS:15222	TC/RMTC/IIR	√	2	2	1	
1.5	Syphon Tube	Chemical	Major	Chemical	TC/RMTC Review	IS:738	IS:738	TC/RMTC/IIR	√	2	2	1	
2.0	INPROCESS INSPECTION												
2.1	Complete Assembly	Visual, Dimn. & Assy. Check	Major	Physical Obsvn. & Measure ment	100%	IS:2878	IS:2878	IR	--	2	2	1	
2.2		Performance Test	Major	Performa nce Test	Random 10%	IS:2878 / IS:2004 Cl. 9.1	IS:2878 / IS:2004 Cl. 9.1	IR	--	2	2	1	
2.3		Leakage Test	Major	Leakage Test	1/Lot	IS:2878 / IS:2004 Cl. 9.3	IS:2878 / IS:2004 Cl. 9.3	IR	--	2	2	1	
3.0	FINAL INSPECTION & TESTING												
3.1	Complete Assembly	Visual & Dimn.	Major	Physical Obsvn. & Measure ment	1/Lot	IS:2878	IS:2878	IR	√	2	2	1	Dimn. Report to be submitted
3.2		Painting & Marking	Major	Visual	100%	IS:2878	IS:2878	IR	--	2	2	1	

LEGEND: P: PERFORM, W: WITNESS, V: TEST CERTIFICAT REVIEW. INDICATE 1 FOR BHEL / BHEL NOMINATED INSPECTION AGENCY/END USER/END USER'S REPRESENTATIVE & 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
	BHEL QA SIGNATURE & STAMP	BHEL QA SIGNATURE & STAMP	CUSTOMER'S SIGNATURE & STAMP (IF APPLICABLE)

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										P	W	V	
3.3		Leakage Test	Major	Leakage Test	100%	IS:2878	IS:2878	TC	√	2	2	1	
4.0	PRESERVATION & PACKING												
4.1	Complete Assembly	Properly Packing with necessary marking	Major	Visual	100%	App. TDS / IS:2878	App. TDS / IS:2878	Packing Report	--	2	2	--	
		Preservation must be maintained at proper place	Major	Visual	100%	App. TDS / IS:2878	App. TDS / IS:2878	Packing Report	--	2	2	--	

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