

38145/2020/PE-SD-450_ME

 PROJECT ENGINEERING & SYSTEM DIVISION		STANDARD MANUFACTURING QUALITY PLAN							QP. NO.: PESD/QA/ FASTENER/01/18-19				
		PRODUCT: FASTENER					BHEL SPEC: AS PER P.O			REV NO: 00		DATE: 23-02-2019	
										PAGE 1 OF 3			
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY			REMARKS
										P	W	V	

1.0	BOUGHT OUT ITEMS												
1.1	FASTENERS	Material batch identification, dimensions and GO & NO-GO check	Major	Visual, dimensional, GO & NO-GO check	Sampling plan IS 1367 : Part 17 (AQL=1, LQ10 = 12, sample size = 32, Ac = 1)	BHEL specification or IS Standard IS 1367 : Part 17	BHEL specification or IS Standard IS 1367 : Part 17	MTC and inspection reports	√	2	2	--	Inspection shall be carried out by main supplier.
2.0	FINAL INSPECTION & TESTING												
2.1	FASTENERS	Visual, Dimensions, GO & NO-GO check	Major	Visual, dimensional, GO & NO-GO check	Sampling plan IS 1367 : Part 17 (AQL=0.65, LQ10 = 25, sample size = 8, Ac = 0)	BHEL Specification /BOQ/ IS Standard	BHEL Specification /BOQ/ IS Standard	Inspection reports	√	2	1	--	
2.2		Chemical & Mechanical Properties and Heat Treatment (heat treatment if applicable)	Major	TC Review	One sample per Lot			MTC	√	2	--	1	

LEGEND: P: PERFORM, W: WITNESS, V: TC REVIEW. INDICATE 1 FOR BHEL CQS /BHEL NOMINATED INSPECTION AGENCY/END USER & 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.

APPROVED BY

BHEL QA SIGNATURE



APPROVED BY

-NA-

CUSTOMER'S SIGNATURE & STAMP
(if applicable)

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2.4		PMI#	Major	PMI test	Random			IR/TC	√	2	1	1	# If applicable 10 sets shall be witnessed randomly by "1"
2.5		BOM Check	Major	Visual	100%			Inspection reports	√	2	1	--	
3.0	PRESERVATION & PACKING												
3.1	FASTENERS	Packing# and markings	Major	Visual	Random	BHEL Specification	BHEL Specification	Packing List	√	2	--	1	#Seaworthy packing for export orders refer note-5.

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Notes:-

1. This Standard MQP should be read along with specification (Latest revision as per PO), approved drawings & approved datasheet.
2. Drawing/datasheet shall prevail over quality plan for contradiction if any.
3. Any project/customer specific requirements which shall be notified have to be fulfilled by the vendor at the time of execution of order.
4. **NACE requirement:** For items coming under **NACE category**, all tests, reports, MTC and certificates shall be submitted as per **NACE MR0103** requirements.
5. Seaworthy packing shall be **witnessed** BHEL/BHEL nominated inspection agency for overseas project.

Abbreviations:-

MTC	-	Material Test certificate	TC	-	Test Certificate
NDE	-	Non Destructive Examination	CS	-	Carbon Steel
PMI	-	Positive Material Identification			
SS	-	Stainless Steel			
IR	-	Inspection Report			

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