

# SAMPLE QUALITY PLAN FORMAT

SHEET 1 of 2

QUALITY PLAN			CUSTOMER: NTPC			PROJECT: 2X500 MW MAUDA STPP			SPEC. NO :PE-SS-999-142-M010			
SHEET 1 OF 2			BIDDER/VENDOR: PENNANT			QP NO.:PE-QP-303-100-M002 REV: 00 DT 20.07.10			SPEC. TITLE :STEAM TRAPS			
SYSTEM POWER CYCLE			ITEM: SS THERMODYNAMIC STEAM TRAPS			SECTION			VOLUME			
S.NO.	COMPONENT/ OPERATION	CHARACTERISTICS CHECKED	CATE- GORY	TYPE/METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY	REMARKS		
									P	W	V	
1.0	RAW- MATERIAL											
1.1	BODY,CAP.DISC AND PLUG	1. PHYSICAL, CHEMICAL PROPERTIES	MA	PHYS. CHEM. ANALYSIS	ONE/HEAT /BATCH	APPD. DRG./ TECH. SPEC.	APPD. DRG./ TECH. SPEC.	TEST CERT.	3/2	2	1	CORRELATION REQD (except disc & plug)
		2. SURFACE DEFECTS	MA	VISUAL	100%	MSS-SP-55	MSS-SP-55	INSPN. REPORT	3/2	2	1	
		3. DIMENSIONS	MA	MEASUREMENT	100%	APPD. DRG./ TECH. SPEC.	APPD. DRG./ TECH. SPEC.	-DO-	3/2	-	-	
1.2	SCREEN	1.CHEMICAL PROPERTIES AND MESH SIZE	MA	CHEMICAL TEST & MEASUREMENT	ONE PER LOT	APPD. DRGS./ DATA SHEET	APPD. DRGS./ DATA SHEET	LAB REPORT/ INSP. REPORT	3/2	2	1	MESH SIZE AND MESH PERFORMANCE DIA. SHALL ALSO BE CHECKED.
2.0	MACHINING											
2.1	ALL COMPONENTS	1. DIMENSIONS	MA	MEASUREMENT	100%	-DO-	-DO-	INSP. REPORT	3/2	-	-	
		2. SURFACE DEFECTS	MA	VISUAL EXAM.	100%	MSS-SP-55	MSS-SP-55	-DO-	3/2	-	-	
		3. HARDNESS OF DISC	CR	HARDNESS TEST	100%	APPD. DRGS./ DATA SHEET	APPD. DRGS./ DATA SHEET	-DO-	3/2	2		
		4. DISC SEAT & BODY SEAT	CR	SURFACE DEFECT	100%	ASTM E165	NO DECECTS	-DO-	3/2	2		
		5. CONTACT SURFACE BETWEEN BODY SEAT AND DISC	CR	BLUE MATCHING	100%	-DO-	UNIFORM METAL TO METAL CONTACT	INSP REPORT	3/2	2		
3.0	ASSEMBLY INSPECTION	1. CLEANING & DEBURING	MA	VISUAL	100%	TECH SPEC.	TECH SPEC	LOG BOOK	3/2	-		
		2. DIMENSIONS	CR	MEASUREMENT	100%	-DO-	APPD. DRGS./ DATA SHEET	INSP. REPORT	3/2	2.1		
		3. LEAK TIGHTNESS OF BODY	CR	HYDRAULIC TEST	20 %	APPD. DRG./ TECH. SPEC./ DATA SHEET	NO LEAKAGE	TC/IBR FORMAT	3/2	1		

This approval shall be interpreted as laid down in the contract and it shall not relieve the contractor from his contractual obligations.

**APPROVAL CATEGORY AWARDED**

CAT I = Approved

CAT II = Batchwise

CAT III = Not Approved

CAT IV = Reference Drawing

**APPROVED BY**

BHEL - PEM

DEPARTMENT

NAME

SIGNATURE

DATE

20.07.10

BHEL	PARTICULARS	BIDDER/VENDOR
Govind	NAME	
	SIGNATURE	
Engineer (MPL)	DATE	
PEM		

BIDDER'S/VENDOR'S COMPANY SEAL

REF. ENQUIRY NO. PE/PG/VTG/E-3730/12 dt. 21/09/2012



# SAMPLE QUALITY PLAN FORMAT

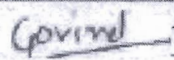
SHEET 2 of 2

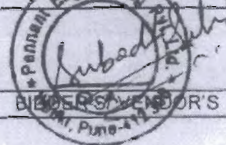
QUALITY PLAN			CUSTOMER: NTPC			PROJECT: 2X500 MW MAUDA STPP			SPEC. NO: PE-SS-999-142-M010			
SHEET 2 OF 2			BIDDER/VENDOR: PENNANT			QP NO.: PE-QP-303-100-M002   REV: 00 DT 20.07.10			SPEC. TITLE: STEAM TRAPS			
SYSTEM			POWER CYCLE			ITEM: SS THERMODYNAMIC STEAM TRAPS			SECTION VOLUME			
S.NO.	COMPONENT/ OPERATION	CHARACTERISTICS CHECKED	CATE- GORY	TYPE/METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	P	W	V	REMARKS
3.0	ASSEMBLY INSPECTION CONTD. (-----)	4. FUNCTION OF TRAP	CR	PERFORMANCE TESTING IN SIMULATED CONDITIONS (REF. ATTACHED TEST PROCEDURE)	10% (RANDOM) MIN. 1 NO.	APPD. DRG./ TECH. SPEC./ DATA SHEET	TECH. SPEC./ DATA SHEET/APPD. DRG	TEST CERT.	2	2.1	1	AS PER ATTACHED TEST PROCEDURE (TO BE CARRIED OUT IF TOTAL QTY. IS MORE THAN 5) CHP-REFER NOTE
4.0	SOCKET WELD ENDS	1.DIMENSIONS	CR	TEMPLATE	100%	APPD. DRG./ TECH. SPEC.	APPD. DRG./TECH. SPEC.	INSP. REPORT	2	1	-	
		2. SURFACE DEFECTS	CR	PT	100%	ASTME 165	NO SURFACE DEFECTS	-DO-	2	2	1	
5.0	PAINTING	SURFACE PREPARATION AND PAINTING	MA	VISUAL	100%	APPD DRG	APPROD DRG	-DO-	2	2	1	
6.0	PROVISION OF NAME PLATE & PACKING IN WOODEN CASESON	AS PER TECH. SPEC.	MA	VISUAL	100%	APPD DRG./ TECH. SPEC.	APPD DRG./ TECH. SPEC.	-DO-	3/2	-	1	

## ABBREVIATIONS

CR= CRITICAL CHARACTERISTIC    P= PERFORMED BY,    W = WITNESSED BY    V = VERIFIED BY  
 MA=MAJOR CHARACTERISTIC,    1= PURCHASER (BHEL)    2 = VENDOR,    3 = SUB VENDOR OF THE VENDOR

NOTE: SUCCESSFUL VENDOR SHALL SUBMIT FUNCTIONAL TEST PROCEDURE OF TRAP ALONG WITH QP IMMEDIATELY AFTER ORDER IS PLACED FOR APPROVAL.

BHEL	PARTICULARS	BIDDER/VENDOR
 Engineer (MPL) PEM	NAME	
	SIGNATURE	
	DATE	

  
 BIDDER'S/VENDOR'S COMPANY SEAL

This approval shall be interpreted as laid down in the contract and it shall not relieve the contractor from his contractual obligations.

APPROVAL CATEGORY AWARDED

CAT-I = Approved  
 CAT II = Approved with Comments as Noted  
 CAT III = Not Approved  
 CAT IV = Reference Drawing

APPROVED BY

BHEL - PEM  
 DEPARTMENT  
 NAME  
 SIGNATURE  
 DATE

2007.10