



HARIDWAR

MANUFACTURING QUALITY PLAN

ITEM : CORE PRESSING STUD WITH NUT & COUPLER

Q.P NO : TR / QP / 57

REV : 00

DRG. NO : R7002-0118 REV01

DATE 18/06/2016

PAGE 1 of 2

PACKAGE : TOOLINGS

INDENT No.: X20160314

CONTRACTOR : BHEL HARIDWAR

SL .NO	COMPONENTS & OPERATIONS	CHARACTERSTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE OF NORMS	FORMAT OF RECORDS	AGENCY		REMARKS
									M	C	
1	2	3	4	5	6	7	8	9	10		11
1	MACHINING	ITEM NO 1 : 1) Check Thread M99 x 4 by thread plug gauge 2) Check & Maintain size 130 -0,5	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	W	
		ITEM NO 4 : 1) Check Thread M99 x 4 by thread plug gauge 2) Check & Maintain size 130 -0.6	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	V	
		ITEM NO 5 : 1) Checking of Thread M99 x 4 by thread plug gauge 2) Check & maintain dia 135d6 (-0.170 / -0.145) Slitting not to be done at this stage	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	W	
		ITEM NO 6 : 1) Check & maintain dim 135H7 +0.040 2) Assembly of item no 5 & 6 to be ensured.	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	W	
		Slitting of item no.5 to be done after ensuring assembly of item no. 5 & 6	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	V	
		ITEM NO 7 : 1) Checking of Thread M99 x 4 by thread plug gauge 2) Threads M99 x 4 are to be made seperately in each side. In no case both threads are to be made from one end side.	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	W	
		ITEM NO 8,9 & 10 : 1) Checking of Thread M99 x 4 by thread ring gauge 2) Material should be as per specification mentioned in drawing.	Major	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	W	

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									M	C	
1	2	3	4	5	6	7	8	9	10		11
2	ASSEMBLY	1) Interchangeability of threads to be ensured. 2) Use Lubricant on spherical seats of Item no 2 & 3	Critical	Visual	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	V	
3	FINAL INSPECTION	Dimensions	Critical	Measurement	100%	BHEL Drawing	BHEL Drawing	Dimension Report	P	V	
		Completeness of Items as per B.O.M.	Major	Visual	100%	Drawing	Drawing	Internal Report	P	W	
		Free from burrs & dents	Critical	Visual	100%	BHEL Drawing	BHEL Drawing	Internal Report	P	W	
		Identification No.	Major	Visual	100%	-	-	Internal Report	P	V	
		Packing - To be supplied in protected cover to avoid any damage or change in dim during transportation.	Major	Visual	100%	Properly Done so that material surface does not suffer any dents or scratches. Protection of Steel Surface against rust & corrosion. Strong Packing box to withstand careless mis-handling in transportation					

LEGEND :

- M= VENDOR
- C= BHEL NOMINATED AGENCY
- P=PERFORMED BY
- V = VERIFIED BY
- W= WITNESSED BY

MANUFACTURER / SUB CONTRACTOR	PREPARED BY
	APPROVED BY
	SIGNATURE

Pushy
18/06/16

Deam
18/6/16