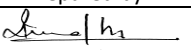


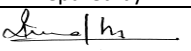
 RANIPET	Manufacturer's Name and Address: BHEL approved Source.		MANUFACTURING QUALITY PLAN						PROJECT: STANDARD					
			ITEM: RUBBER LINING CONFIRMING TO CODE: IS4682 PART-I/ASTM-D-7602			QP NO: FGD:708			Package : FGD PACKAGE					
						REV:01								
			SUB SYSTEM: FGD			DATE: 23.04.2020			Contractor: BHEL					
Page 1 of 4														
S.NO	COMPONENTS & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS	D	AGENCY			REMARKS
					M	C/N					M	C	N	
1	2	3	4	5	6		7	8	9	10	11			12

1.0 RAW MATERIAL														
1.1	Rubber Mix	Tensile Strength % Elongation	Major	Mechanical	1 sample/ batch		IS 3400 part-1	T.S. > 120Kg/cm2 % elongation > 350	TC	√	P	V	V	Refer Note.
		Resistance to Bleeding	Major	Chemical	1 sample/v ulc. lot		AS PER EN 14879-4:2007		TC	√	P	V	V	
1.2	Thickness of Sheets	Dimensions	Minor	Measure	100 %	-	Technical spec		IR		P	-	-	
2.0	IN PROCESS INSPECTION													
2.1	Surface Preparation	Cleanliness & Uniformity	Major	Visual	100 %	-	IS 4682 part 1	IS 4682 part 1	TC		P	-	-	

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	 Rakesh kr Madhu (Dy Manager / QA) Reviewed By		FOR CUSTOMER USE			
	 K C Gandhiparimalam (DGM/QA) Approved by			REVIEWED BY	APPROVED BY	APPROVAL SEAL

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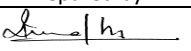
2.2	Continuity of lining at uncured stage	Spark Test	Major	Visual	100 %	-	Is 4682 part 1	No spark at 6 KV/mm of lining thickness	TC		P	-	-	
2.3	Curing of Rubber lining	Control of pre/.temp & time	Major	Visual	100 %	-	IS 4682 part 1	IS 4682 part 1	LOG BOOK		P	-	-	
3.0	FINAL INSPECTION													
3.1	Complete Lining	Shore Hardness	Major	Hardness Test	Random		Is 4682 part 1	Approved drawing / data sheet	IR	√	P	W	W	
		Spark test	Critical	Visual	100%		Is 4682 part	No spark at 6 KV/mm of	IR	√	P	W	W	

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 BHEL RANIPET	Manufacturer's Name and Address: BHEL approved Source.		MANUFACTURING QUALITY PLAN						PROJECT: STANDARD					
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Page 3 of 4														
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					M	C/N					M	C	N	
1	2	3	4	5	6		7	8	9	10	11			12

						1	lining thickness							
		Thickness	Major	Measure	Random	Drawing / Data sheet		IR	√	P	W	W		
		Adhesion	Major	Peel off test	2 samples/ volc. lot	IS 4682 part 1		IR	√	P	W	W	Refer Note	
		Surface Defects	Major	Visual	100%	IS 4682 part 1		IR		P	W	W		
		completeness	Major	Visual	100%	Drawing / Data sheet	Drawing / Data sheet	IR		P	W	W		

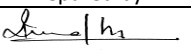
Note: 1. Repairs, if any, shall be carried out by the same process, as applied for original Rubber lining. Repairs inside the pipe are not allowed
 2. For Ebonite/ Hard rubbers, Tensile strength, % Elongation & Adhesion check are not applicable.
 3. For adhesion test, test coupon shall be made as per governing Code.

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					M	C/N					M	C	N	
1	2	3	4	5	6		7	8	9	10	11			12

4. General Notes:

- Latest version of standards & Specification shall be applied.
- Materials shall be procured in compliance to Functional Technical Specification.
- Gauges and measuring instruments with valid calibration only shall be used.
- Inspection / Inspection wavier / approval by BHEL does not absolve Supplier's responsibility for conformity of the specification as per the terms of PO.
- BHEL /BHEL Authorized representatives shall have the right to witness the necessary inspection and testing of goods mentioned in the PO.
- In case of Vendor Drawing & Datasheet, it needs approval by BHEL Engineering.
- This QP Shall be read along with relevant PO, BHEL Specification/Drawing/Approved Datasheet.

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