

बी एच ई एल BHEL		MANUFACTURING QUALITY PLAN							MQP. NO.: SMQP/FPS/10/A/092013				
		PROJECT ENGINEERING & SYSTEMS DIVISION BHEL, RC PURAM, HYD-502032			PRODUCT: HVWS NOZZLE SPARY				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												
	HOUSING (BRASS)	CHEMICAL	MAJOR	CHEM. ANALYSIS	ONE PER HEAT OR BATCH	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	Lab./Mfg. TC	√	2	-	1	
		DIMENSION	MAJOR	MEASURE MENT	ONE PER HEAT OR BATCH	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	IR	-	2	2	1	
	SCROLL (BRASS)	MECH. & CHEMICAL	MAJOR	MECH & CHEM. ANALYSIS	ONE PER HEAT OR BATCH	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	Lab./Mfg. TC	-	2	-	1	
2.0	INPROCESS INSPECTION												
	HOUSING	MECH. & DIMENSION CHECK	MAJOR	MEASURE MENT & GAUGE CHECK	100%	AS per approved drg.	AS per approved drg.	IR	-	2	2	1	
	SCROLL	DIMENSTION CHECK	MAJOR	MEASURE MENT & GAUGE CHECK	100%	AS per approved drg.	AS per approved drg.	IR	-	2	2	1	
	ASSY	Fitment & Assembly Check	MAJOR	VISUAL	100%	AS per approved drg.	AS per approved drg.	IR	-	2	2	1	
		Cleaning & Flow Testing	MAJOR	FLOW TEST	100%	AS per approved drg.	AS per approved drg.	IR	-	2	2	1	
3.0	FINAL INSPECTION & TESTING												

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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	HVWS NOZZLE (Complete Assy)	PHYSICAL OBSERVATION & DIMN. CHECK	MAJOR	VISUAL & MEASURE MENT	100% for 2, 10% for 1	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	IR	√	2	2, 1	-	
		PERFORMANCE (FLOW,SPRAY ANGLE,SPRAY PATTERN TEST)	CRITIC AL	FLOW TEST	100% for 2, 10% for 1	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	IR / TC	√	2	2, 1	-	
		MARKING & FINISH	MAJOR	VISUAL	100% for 2, 10% for 1	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	IR	√	2	2, 1	-	
4.0	PRESERVATION & PACKING												
	HVWS NOZZLE ASSY	PROPERLY PACKING WITH NECESSARY MARKING	MAJOR	VISUAL	100%	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	PACKING NOTE	-	2	2	-	
		PRESERVATION MUST BE MAINTAINED IN PROPER PLACE	MAJOR	VISUAL	100%	As per approved drg/TDS//Spec .	As per approved drg/TDS//Spec.	PACKING NOTE	-	2	2	-	

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