Annexure-7

QAP guide Line, Formats & specification
QAP GUIDELINES & FORMAT

(ANNEXURE-7, Rev 01)

The QAP format and guidelines for filling up the format shall be used by vendor for preparation and submission of QAP after order placement.

Note:

1. Typical /Indicative /Standard QAP(s) for equipment /package attached is reference document and to use by successful bidder in future for preparation and submission of QAP for BHEL /CUSTOMER approval.

2. No deviation to reference document is acceptable.
GUIDELINES TO VENDORS FOR
PREPARATION OF QUALITY ASSURANCE PLAN

1. QAP shall be made in landscape mode on A4 size paper as per the format enclosed. Font size shall be minimum 10.

2. Each page of QAP shall contain the following information.
   a) Vendor’s name & address.
   b) Customer: BHEL, Hyderabad.
   c) Project.
   d) BHEL Product Standard Number/revision number as referred in P.O.
   e) BHEL Purchase Order Number & Date.
   f) Product as per P.O. description.
   g) QAP Number (unique and shall not repeat)/revision number/date.
   h) Page number and number of pages

3. QAP shall contain four parts / stages as follows.
   a) Raw materials and bought out items.
   b) In process Control / Inspection.
   c) Final assembly, Inspection & Testing.
   d) Painting, preservation & packing.

4. Under ‘Component’, indicate name of the component (say casing, rotor, pressure gauge, etc).

5. Under ‘Characteristics’, indicate appropriately (say chemical analysis, mechanical properties, NDT (UT,DP etc.), hydrostatic test, calibration check etc.)

6. Under ‘Class’, indicate minor, major or critical depending on the importance of characteristic.

7. Under ‘Type of check’, indicate appropriately (say chemical, mechanical, UT, DP etc.)

8. Under ‘Quantum of check’, indicate appropriately (say 100%, 10%, sample, per melt, per heat, all pieces etc.)

9. Under ‘Reference document’ and ‘Acceptance norms’, appropriate National & International standards, BHEL standards, approved drawing references etc. should be indicated. It is not correct to mention as “Vendor’s internal standards or Vendor’s standard practice etc.”. If vendors’ internal standards are referred, same shall be in line with BHEL Spec. indicated in the P.O. These may require review & approval by our Engineering dept.

10. Under ‘Format of record’, indicate appropriately supplier’s test certificate, calibration certificate, lab report, inspection report etc.

11. Please refer ‘Agency’ in QAP format.
   Indicate against each characteristic 1: (BHEL CQS/Nominated inspection agency), OR
   2: (Vendor / Sub vendor)
Note: Performing agency is normally vendor or his sub vendor (Legend 2). Where witness points are indicated in specification, P.O., Drawing etc., for such operations, Under Witness (W) column use 1. Under 'Verify' column, use code 1.

12. Under ‘D’ please put (Tick) against each characteristic where vendor proposes to submit test certificate/report etc. OR as required as per BHEL Specification.

13. Vendor’s signature & stamp should be available on each page of QAP.

14. Vendor should read the BHEL Product Standard thoroughly and QAP should be made only inline and relevant to the Specification & Approved Drawings.

15. The following operations/characteristics/check points may be included (AS APPROPRIATE)
   a) Visual check
   b) Dimensional check
   c) Mechanical and Chemical properties.
   d) Surface preparation before painting (by chemical cleaning, sand blasting, shot blasting etc. as the case may be.)
   e) Painting check for shade, Dry Film Thickness (DFT), Adhesion/peel off test etc.
   f) Check for correctness for all components mounted as per General arrangement Drawing, Bill Of Materials (BOM), etc. for range, rating, make, color, size, location as per GA, quantity, label description including tag nos., annunciator facia, loose components, accessories, spares etc.
   g) Verification of test certificate for protection class for the enclosures.
   h) Mechanical functioning of switches.
   i) Continuity of earthing and provision of earth points.
   j) Colour coding of wiring, size, tightness & dressing of wiring.
   k) Review of test certificates of assembled items, raw materials, internal test reports etc.
   l) Witness of functional checks, which may include mechanical run & electrical run, H.V. test, IR measurement, Electrical and Mechanical tests etc.
   m) PQR, WPS, Welder Qualification Record, welding records (fit up, DP) etc.
   n) Material identification (for punch marks of serial numbers, Heat No, Melt No, Inspector’s stamp etc.)
   o) Hydraulic Pressure Test, Pneumatic Pressure Test, Liquid Penetration Examination and other Non-Destructive Tests.
   p) Tests on Galvanised items (Visual, Hammer Test, Knife Test, Thickness, Pierce Test (Copper sulphate test), Hydrogen evaluation test, Stripping test (for Mass of Zinc coating)
   q) All tests as per BHEL Product Standard & approved drawings including Type tests and Routine tests on individual items and on System as a whole.
   r) Packing and Preservation.

16. **QAP Format enclosed.**

17. **Typical Manufacturing QAP(s) is /are attached.**
# MANUFACTURING QUALITY PLAN

<table>
<thead>
<tr>
<th>SL NO</th>
<th>COMPONENTS</th>
<th>CHARACTERISTICS</th>
<th>CLASS</th>
<th>TYPE OF CHECK</th>
<th>QUANTUM OF CHECK</th>
<th>REFERENCE DOCUMENT</th>
<th>ACCEPTANCE NORMS</th>
<th>FORMAT OF RECORD</th>
<th>*</th>
<th>D</th>
<th>AGENCY</th>
<th>REMARKS</th>
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<td>RAW MATERIALS &amp; BOUGHT OUT ITEMS</td>
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<td>2.0</td>
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<td>3.0</td>
<td>FINAL INSPECTION &amp; TESTING</td>
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<td>4.0</td>
<td>PRESERVATION &amp; PACKING</td>
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VENDOR TO NOTE: THIS FORMAT IS IN MICROSOFT WORD. HEADER & FOOTER SHALL BE AVAILABLE IN EACH PAGE OF QP. QP SHALL BE IN LANDSCAPE & A4 SIZE ONLY. FONT SIZE SHALL BE MIN 10. VENDOR SHALL SIGN & STAMP IN EACH PAGE OF QP. LOI REF. & DATE ARE NOT ACCEPTABLE. P.O.NO. & DATE SHALL BE INDICATED. QP NO. SHOULD BE UNIQUE AND SHALL NOT REPEAT. ALL THE TESTS / CHECKS INDICATED IN THE BHEL SPEC. SHALL BE INDICATED IN THE QP.

LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL CQS (OR BHEL NOMINATED INSPECTION AGENCY) & 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: VENDOR’S SIGNATURE & STAMP
APPROVED BY: BHEL QA SIGNATURE & STAMP
APPROVED BY: CUSTOMER’S SIGNATURE & STAMP
## TYPICAL MANUFACTURING QUALITY PLAN

**PROJECT ENGINEERING & SYSTEMS**
**DIVISION BHEL, RC PURAM, HYD-502032**

**PROJECT:** PACKAGE: BOILER FEED PUMP
**BHEL TECH SPEC:**

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<thead>
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<th>SL NO</th>
<th>COMPONENTS</th>
<th>CHARACTERISTICS</th>
<th>CLASS</th>
<th>TYPE OF CHECK</th>
<th>QUANTUM OF CHECK</th>
<th>REFERENCE DOCUMENT</th>
<th>ACCEPTANCE NORMS</th>
<th>FORMAT OF RECORD</th>
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### 1.0 RAW MATERIALS & BOUGHT OUT ITEMS

<table>
<thead>
<tr>
<th>SL NO</th>
<th>COMPONENTS</th>
<th>CHARACTERISTICS</th>
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<th>QUANTUM OF CHECK</th>
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<th>FORMAT OF RECORD</th>
<th>AGENCY</th>
<th>REMARKS</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.1</td>
<td>Casing, suction &amp; discharge nozzle, stuffing box</td>
<td>Chemical &amp; Mech. Properties</td>
<td>Major</td>
<td>Chemical &amp; Mech. analysis</td>
<td>1 per heat/lot</td>
<td>Tech Spec/ Approved Datasheet/ Approved Drawing</td>
<td>MTC</td>
<td>√</td>
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<tr>
<td>1.2</td>
<td>Heat treatment*</td>
<td>Major</td>
<td>Heat treatment</td>
<td>100%</td>
<td></td>
<td></td>
<td>HT chart</td>
<td>√</td>
<td>2</td>
<td>2</td>
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<tr>
<td>1.3</td>
<td>Impeller, Diffuser and shaft</td>
<td>Chemical &amp; Mech. Properties</td>
<td>Major</td>
<td>Chemical &amp; Mech. analysis</td>
<td>1 per heat/lot</td>
<td></td>
<td>MTC</td>
<td>√</td>
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<tr>
<td>1.4</td>
<td>Mechanical seal</td>
<td>Material compliance and leakage check</td>
<td>Major</td>
<td>TC review, Air test</td>
<td>100%</td>
<td></td>
<td>MTC / COC</td>
<td>√</td>
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<tr>
<td>1.5</td>
<td>Bearing and bearing housing</td>
<td>Make and Model compliance</td>
<td>Major</td>
<td>Visual</td>
<td>100%</td>
<td></td>
<td>MTC / COC</td>
<td>√</td>
<td>2</td>
<td>2</td>
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<tr>
<td>1.6</td>
<td>Lube oil system</td>
<td>MOC, routine tests of all valves, instruments, filters, coolers and pump &amp; motor</td>
<td>Major</td>
<td>OEM test certificate verification</td>
<td>100%</td>
<td></td>
<td>MTC</td>
<td>√</td>
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<tr>
<td>1.7</td>
<td>Piping hydro test</td>
<td>Major</td>
<td>Hydro test</td>
<td>100%</td>
<td></td>
<td>TC</td>
<td>√</td>
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<td>1</td>
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<tr>
<td>1.8</td>
<td>Performance test</td>
<td>Major</td>
<td>testing</td>
<td>100%</td>
<td></td>
<td>TC</td>
<td>√</td>
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<td>2</td>
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<table>
<thead>
<tr>
<th>SL NO</th>
<th>COMPONENTS</th>
<th>CHARACTERISTICS</th>
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<th>REMARKS</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.9</td>
<td>ARC valve, Hydraulic coupling and Gear box</td>
<td>MOC and routine tests</td>
<td>Major</td>
<td>OEM test certificate verification</td>
<td>100%</td>
<td></td>
<td></td>
<td>MTC</td>
<td>2 2 1</td>
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</tr>
<tr>
<td>1.10</td>
<td>Accessories (strainers, coupling and guards, JB, instruments etc.)</td>
<td>Chemical &amp; Mech. Properties</td>
<td>Major</td>
<td>Chemical &amp; Mech. Analysis</td>
<td>1 per heat/lot</td>
<td></td>
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<td>MTC</td>
<td>2 2 1</td>
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<tr>
<td>1.11</td>
<td>Gaskets, Wear rings, base plate and Fasteners</td>
<td>Chemical &amp; Mech. Properties, Hardness</td>
<td>Minor</td>
<td>Chemical &amp; Mech. Analysis, Hardness test</td>
<td>1 per heat/lot</td>
<td></td>
<td></td>
<td>MTC</td>
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**2.0 INPROCESS INSPECTION**

<table>
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<th>COMPONENTS</th>
<th>TYPE OF CHECK</th>
<th>QUANTUM OF CHECK</th>
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<th>FORMAT OF RECORD</th>
<th>AGENCY</th>
<th>REMARKS</th>
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<tbody>
<tr>
<td>2.1</td>
<td>Fabrication of casing and other components</td>
<td>WPS, PQR and WQR</td>
<td>Major</td>
<td>Document verification</td>
<td>100%</td>
<td>Tech Spec/ Approved Datasheet/ Approved Drawing</td>
<td>WPS, PQR and WQR</td>
<td>2 2 1</td>
</tr>
</tbody>
</table>

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<th>AGENCY</th>
<th>REMARKS</th>
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<tbody>
<tr>
<td>2.2</td>
<td>Fillet welds on pressure containing components *</td>
<td>NDE</td>
<td>Major</td>
<td>MPI or LPI (when MPI is not feasible)</td>
<td>100%</td>
<td></td>
<td></td>
<td>NDE reports</td>
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<tr>
<td>2.3</td>
<td>Nozzle weld and butt weld joints on pressure containing components *</td>
<td>NDE</td>
<td>Major</td>
<td>RT or UT (when RT is not feasible)</td>
<td>100%</td>
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<td>NDE reports</td>
<td>2</td>
<td>2</td>
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<tr>
<td>2.4</td>
<td>Casing, suction &amp; discharge nozzle, stuffing box</td>
<td>Surface finish &amp; NDE</td>
<td>Major</td>
<td>Visual &amp; DPT/MPI</td>
<td>100%</td>
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<td>IR and NDE reports</td>
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<td>Impeller, Diffuser and Shaft &gt; 50 mm diameter</td>
<td>NDE</td>
<td>Major</td>
<td>For impeller/ diffuser DPT/MPI and for Shaft UT</td>
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<td>NDE reports</td>
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<td>Rotor with coupling hub</td>
<td>Dynamic balancing</td>
<td>Critical</td>
<td>Balancing</td>
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<tr>
<td>2.7</td>
<td>Auxiliary piping</td>
<td>Leakange check</td>
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<td>Hydro test</td>
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## 3.0 FINAL INSPECTION & TESTING

<table>
<thead>
<tr>
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<th>QUANTUM OF CHECK</th>
<th>REFERENCE DOCUMENT</th>
<th>ACCEPTANCE NORMS</th>
<th>FORMAT OF RECORD</th>
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<tr>
<td>3.1</td>
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<td>3.2</td>
<td>Vibration level at five points, Noise level, Bearing temperature rise and leakage from mechanical seal</td>
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<td>100%</td>
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<td>3.3</td>
<td>Pump Assembly with job motor</td>
<td>NPSH (if applicable)</td>
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<td>3.6</td>
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<td>3.8</td>
<td>Spares (if any)</td>
<td>Major BOM check</td>
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## 4.0 PRESERVATION & PACKING

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<th>QUANTUM OF CHECK</th>
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<td>Tech Spec/ Approved Datasheet/ Approved Drawing</td>
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<td>IR $\sqrt{2}$ 2 1 --</td>
<td># Seaworthy packing for export orders</td>
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### LEGEND
- **P**: PERFORM
- **W**: WITNESS
- **V**: VERIFICATION
- INDICATE 1 FOR BHEL CQS (OR BHEL NOMINATED INSPECTION AGENCY) & 2 FOR VENDOR/SUB VENDOR AS APPROPRIATE AGAINST EACH COMPONENT/CHARACTERISTIC UNDER P, W & V COLUMNS. * FOR ITEMS MARKED $\sqrt{}$ (TICK) IN COLUMN ‘D’, TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.
### Notes:

1. This TMQP should be read along with specification (latest revision), approved drawings & approved data sheet.
2. Specifications/drawing/data sheet shall prevail over quality plan for contradiction if any between quality plan and drawing/specification.
3. All test certificates/reports reviewed and certified by TPI/BHEL shall be submitted to BHEL as documentation package.
4. Any project/customer specific requirements which shall be notified have to be fulfilled by the vendor at the time of execution of order.

### Abbreviations:

- **MTC** – Material Test certificate
- **IBR** – Indian Boiler Regulations
- **DFT** – Dry Film Thickness
- **TC** – Test Certificate
- **PMI** – Positive Material Identification
- **G.I** – Galvanized Iron
- **WPS** – Welding Procedure Specification
- **PQR** – Procedure Qualification Record
- **WPQ** – Welder Performance Qualification
- **NDE** – Non Destructive Examination
- **OD** – Outer Diameter
- **ID** – Internal Diameter