


QUALITY PLAN

BHEL	QP NO.	QA/CF/QP/330/0T	REV.	00	DESCRIPTION				LEGENDS			
	SPEC. NO.	HW10786	REV.	04	BLADE BARS				P- PERFORMED BY		1- BHEL REP	
	SIZE	AS PER PO							W- WITNESSED BY		2- VENDOR	
									V- VERIFIED BY		3- SUBVENDOR	
SL. NO.	COMPONENT OPERATION	CHARACTERISTICS	CLASSIFICATION	TYPE OF CHECK	QUANTUM	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS
									P	W	V	

1.	MELTING IN EAF	CHEMICAL COMPOSITION	MAJOR	SPECTRO ANALYSIS	EACH HEAT	HW10786	HW10786	TC	2			
2.	REFINING AOD-LRF-VD	CHEMICAL COMPOSITION	MAJOR	SPECTRO ANALYSIS	EACH HEAT	HW10786	HW10786	TC	2		1	
3.	BOTTOM POURING INGOT CASTING	INGOT SURFACE / SIZE	MAJOR	VISUAL	100%	VENDOR'S INTERNAL NORMS		IR	2	-	-	
4.	FORGING					AS PER VENDOR'S PRACTICE AND APPROVED MANUFACTURING PLAN		IR	-	-		
5.	HOT ROLLING TO FINAL SIZE LENGTH CUTTING	ROLLING TEMPERATURE DIMENSIONS	MAJOR	TEMP RECORDING DIMENSIONAL	100%	VENDOR'S INTERNAL NORMS		IR	2	-	-	
6.	HEAT TREATMENT	TIME & TEMPERATURE	MAJOR	HT GRAPH	100%	HW10786 & APPROVED MP	HW10786 & APPROVED MP	TC	2	-	1	
7.	HARDNESS TEST (TO IDENTIFY HARDEST BAR)	HARDNESS	MAJOR	HARDNESS	AS PER SPEC	HW10786	HW10786	TC	2	1	-	
8.	MECHANICAL TESTING	TENSILE & IMPACT (LONGITUDINAL)	MAJOR	MECHANICAL TEST	ON BARS WITH MAX. & MIN HARDNESS PER HEAT PER HT BATCH	HW10786	HW10786	TC	2	1	-	
9.	TENSILE & IMPACT (TRANSVERSE) FOR PROCESS QUALIFICATION FATT FOR PROCESS QUALIFICATION		MAJOR	MECHANICAL TEST	ONE/HEAT/HT BATCH	HW10786	HW10786	TC	2	1	-	
10.	METALLOGRAPHIC TESTING	MICROSTRUCTURE DELTA FERRITE INCLUSION GRAIN SIZE	MAJOR	METALLOGRAPHIC	ONE/HEAT/HT BATCH	HW10786	HW10786	TC	2	1	-	
11.	NDT	INTERNAL DEFECTS	MAJOR	UT	100%	HW10786	HW10786	TC	2	1		
12.	MATERIAL IDENTITY TEST	CHEMISTRY	MAJOR	SPECTRO	100%	HW10786	HW10786	TC	2	1	-	
13.	VISUAL & DIMENSIONAL CHECK	VISUAL & DIMENSION	MAJOR	VISUAL & MEASURE	10%	PURCHASE ORDER	PURCHASE ORDER	TC	2	1	-	
14.	IDENTIFICATION MARKING & PAINTING PACKING	MARKING COLOUR CODE	MAJOR	VISUAL	100%	HW10786	HW10786	TC	2	-	1	


 Sugandh Agawal, QA.
 10/2/14

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