

Company Name and logo			MANUFACTURING QUALITY PLAN OF FORGED MACHINED BLOCK						QAP. NO.:QA/3SK0560				
			CUSTOMER: BPCL Naini Allahabad PRODUCT: Machined Forged Block BPC Drg. No. 3SK0560 Rev. 0 MATL. SPEC. NO. – DP/SPEC/358 REV. 0			BPCL P.O.No.			Rev.0	Date			
									Page 1 of 2				
SL NO	STAGE	CHARACTERISTICS	TYPE OF TEST/ CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	P	W	V	REMARKS
1	RAW MATL. (INGOT)	CHEMICAL ANALYSIS	Major	Chemical	Each heat	*Relevant Matl. Specification	*Relevant Matl. Specification	Test Certificate	√	2	2	1	
2	HEAT TREATMENT	H.T. CYCLE	Major	H.T. CYCLE	PER CYCLE	*Relevant Matl. Specification	*Relevant Matl. Specification	H.T. CHART	√	2	2	1	
3	MECH. PROPERTIES	MECHANICAL PROPERTIES	Major	Physical	Each heat	*Relevant Matl. Specification	*Relevant Matl. Specification	Test Certificate	√	2	2, 1	1	
4	NDT	ULTRASONIC TEST (With 3mm FBH Method)	Major	NDT	Each Piece	BPC SPEC.NO. 6080003/S R4	BPC SPEC.NO. 6080003/S R4	Inspection Report	√	2	2, 1	1	On P/M Forging (HOLD
		MP Test	Major	NDT	Each Piece	BPC SPEC.NO. 4DSD0341 R0	BPC SPEC.NO. 4DSD0341 R0	Inspection Report	√	2	2, 1	1	On P/M Forging HOLD
5	ON FINISH MACHINED BLOCK	LIQUID PENETRANT TEST(On Machined Surface)	Major	NDT	Each Piece	BPC SPEC.NO. 4DSD0340 R0	BPC SPEC.NO. 4DSD0340 R0	Inspection Report	√	2	2, 1	1	HOLD
		DIMENSIONS & VISUAL	Major	Dimension & Visual	Each Piece	BPC DRG. No. 3SK0560 Rev.0	BPC DRG. No. 3SK0560 Rev.0	Inspection Report	√	2	2, 1	1	HOLD

LEGEND:

P : PERFORM,
W : WITNESS,
V : VERIFICATION.

P : CUSTOMER (BPCL) HOLD POINT

1 : FOR BPCL CQS (OR BPCL NOMINATED INSPECTION AGENCY)

2 : FOR VENDOR/SUB VENDOR ((OR THEIR NOMINATED INSPECTION AGENCY)

* FOR ITEMS MARKED ✓ (TICK) IN COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BPCL FOR RECORDS.

PREPARED & REVIEWED BY

QA QC DESIGN
VENDOR'S SIGNATURE & STAMP

APPROVED BY

VENDOR'S SIGNATURE & STAMP

APPROVED BY

CUSTOMER'S SIGNATURE & STAMP