		<b>Manufacturer's Name &amp; Address</b> BHARAT HEAVY ELECTRICALS LIMITED SOLAR BUSINESS DIVISION, Prof. CNR Rao Circle, Opp. IISc., Malleshwaram, Bangalore-560012			<b>STANDARD QUALITY ASSURANCE PLAN</b>			<b>PROJECT :</b> <b>PACKAGE :</b> <b>CONTRACT NO. :</b>		
<b>ITEM: SPV MODULES</b>		<b>DRG_NO. : AS PER SOLAR MODULE DRAWING &amp; DATASHEET</b>								
Sl. No.	Component & Operations	Characteristics	Class	Type of Check	Quantum of Check	Reference Document	Acceptance Norms	Format of Record	Agency	Remarks
1	2	3	4	5	6	7	8	9	B C	10 11

1	RAW MATERIAL													
1.1	SOLAR CELLS	a	VISUAL AND DIMENSIONAL CHECKS	Major	Visual/Dimension	5 nos / lot	-	As per BHEL specs.	no cracks or chips/ as per BHEL specs.	Supplier TC	✓	P	V	
		b	POWER OUTPUT	Major	Electrical	-	-	As per BHEL specs.	As per BHEL specs. /MI	Supplier TC / Inspection Report	✓	V	V	
1.2	FRONT GLASS	a	VISUAL AND DIMENSIONAL CHECKS	Major	Visual/Dimension	5 nos / lot	-	As per BHEL specs.	No chips or scratches/ As per BHEL specs.	Supplier TC	✓	P	V	
		b	LIGHT TRANSMITTANCE	Major	Optical	-	-	As per BHEL specs.	As per BHEL specs. /MI	Supplier TC	✓	V	V	
1.3	FAST CURE EVA SHEET	a	VISUAL AND DIMENSIONAL CHECKS	Major	Visual/Dimension	One Roll/ lot		As per BHEL specs.	As per BHEL specs.	Supplier TC / Inspection Report	✓	P	V	
		b	Gel Content	Major	Chemical	-	-	As per BHEL specs.	≥ 80%/ As per TPS specs.	Supplier TC	✓	V	V	

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DATE: 20.06.2024		APPROVED BY: RAGHAVENDRA BABU.G.V, SR.MGR/QUALITY	
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		Manufacturer's Name & Address			STANDARD QUALITY ASSURANCE PLAN							PROJECT : PACKAGE : CONTRACT NO. :					
		BHARAT HEAVY ELECTRICALS LIMITED SOLAR BUSINESS DIVISION, Prof. CNR Rao Circle, Opp. IISc., Malleshwaram , Bangalore-560012			ITEM: SPV MODULES		DRG_NO. : AS PER SOLAR MODULE DRAWING & DATASHEET			Acceptance Norms		Format of Record		Agency		Remarks	
Sl. No.	Component & Operations	Characteristics	Class	Type of Check	Quantum of Check		Reference Document										
1	2	3	4	5	B	T	7	8	9	D*	10	11					

1.4	BACK SHEET	c	EVA – Glass adhesion Peel Test	Major	Adhesion Strength	-	-	-	As per TPS specs	≥ 60N / 10mm/ As per TPS specs	✓	V	V		
		d	Batch No. Verification/Expiry Date/ Shelf life	Major	Visual	100 %	-	-	As per BHEL specs	Before expiry date as per data sheet /packaging	✓	P	V		
		a	Visual and dimensional checks	Major	Visual / Dimension	One roll/lot	-	-	As per BHEL specs	As per BHEL specs	✓	P	V		
		b	Adhesion Strength	Major	EVA Adhesion Peel Test	-	-	-	As per BHEL specs	≥ 40N / 10mm/ As per BHEL specs.	✓	V	V		
1.5	CELL INTERCONNECT/ STRING INTERCONNECT	c	Batch No. Verification/Expiry Date/ Shelf life	Major	Visual	100 %	-	-	As per BHEL specs	Before expiry date as per data sheet /packaging	✓	P	V		
		a	Visual// dimension	Major	Visual /Dimension	One roll/ lot	-	-	As per BHEL specs	No damage/ As per BHEL specs.	✓	P	V		
		b	Coating thickness	Major	Measurement	-	-	-	As per BHEL specs	≥ 16 microns / As per BHEL specs.	✓	V	V		
1.6	JUNCTION BOX	c	Chemical Composition	Major	Chemical	-	-	-	As per BHEL specs	% Copper, % Tin, Lead, Silver / As per BHEL specs.	✓	V	V		
		a	Physical damage. No. Of diodes. Length of cables	Major	Visual /Dimension	5 nos/ lot	-	-	As per BHEL specs	No damage. Diodes-3 nos., Cable Length as per Specs	✓	P	V		

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SOLAR BUSINESS DIVISION,  
Prof. CNR Rao Circle, Opp. IISc.,  
Malleshwaram , Bangalore-560012

### STANDARD QUALITY ASSURANCE PLAN

PROJECT :  
PACKAGE :  
CONTRACT NO. :

ITEM: SPV MODULES  
DRG\_NO. : AS PER SOLAR MODULE  
DRAWING & DATASHEET

Sl. No.	Component & Operations	Characteristics	Class	Type of Check	Quantum of Check		Reference Document	Acceptance Norms	Format of Record		Agency		Remarks
					B	T			9	D*	B	C	
1	2	3	4	5	6		7	8			10		11

	b	Degree of protection IP67 or better	Major	Physical	-	-	As per BHEL specs	As per BHEL specs	Supplier TC	✓	P	V	
	c	Diode: make & Type check	Major	Visual Check	5 nos/ lot	-	As per BHEL specs	As per BHEL specs	Inspection Report / TC/COC	✓	P	V	
	d	No. of diodes in a junction Box	Major	Visual Check	5 nos/ lot	-	As per BHEL specs	As per BHEL specs	Inspection Report / TC/COC	✓	P	V	
1.7	a	Visual and dimensional	Major	Visual /Dimension	5 nos/ lot	-	As per BHEL specs	As per BHEL specs	Supplier TC / Inspection Report	✓	P	V	
	b	Thickness of anodic coating	Major	Passivation	-	-	As per BHEL specs	≥ 15 microns/ As per TPS specs.	Supplier TC	✓	V	V	
	c	Composition	Major	Chemical	-	-	As per BHEL specs	As per BHEL specs	Supplier TC	✓	V	V	

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REVISION 00

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QUALITY

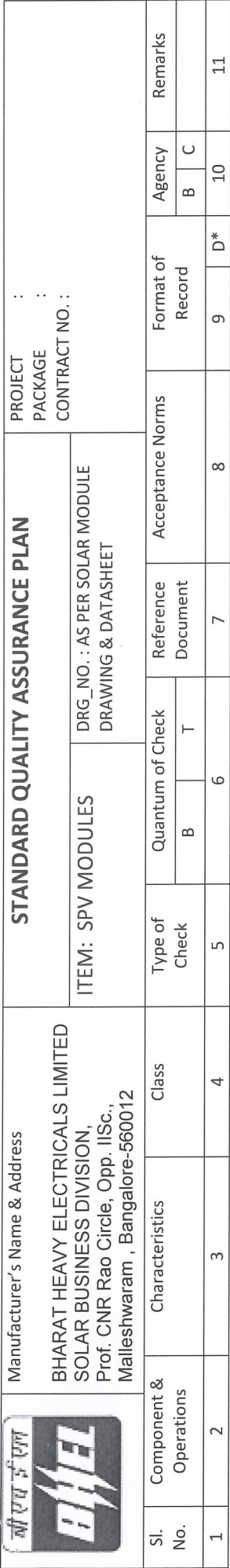
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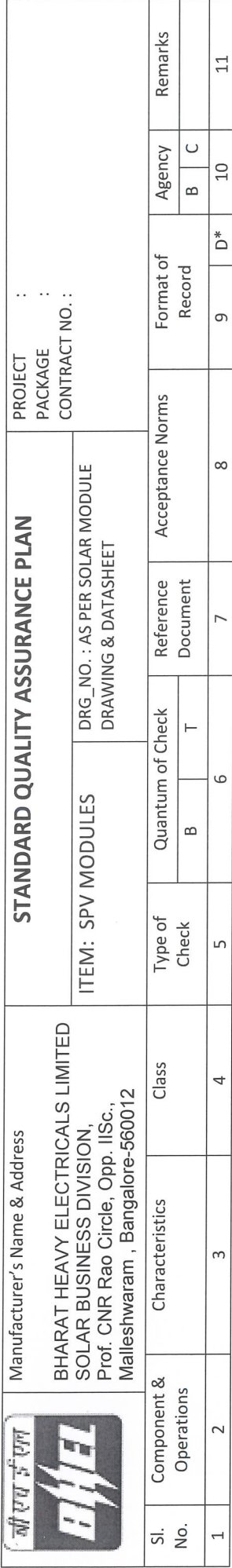
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			BHARAT HEAVY ELECTRICALS LIMITED SOLAR BUSINESS DIVISION, Prof. CNR Rao Circle, Opp. IISc., Malleshwaram , Bangalore-560012		ITEM: SPV MODULES		DRG_NO. : AS PER SOLAR MODULE DRAWING & DATASHEET		Acceptance Norms		Format of Record		Agency		Remarks	
					Type of Check	Quantum of Check		Reference Document			B		T		B	C
1	2	3	4	5	6	7	8	9	D*	10	11					

2.											
2.1	GLASS LOADING	Visual check	Major	Visual	100%	-	Work Instruction	No dust, scratch, chipping in the glass	Producti on record	P	V
2.2	CUTTING OF EVA/BACK SHEET WITH JB SLOT	Dimension	Major	Measureme nt	Once in a day	-	Work Instruction	As per Work Instruction	Producti on record	P	V
2.3	TABBING AND STRINGING OF SOLAR CELLS IN SERIES	Visual check for alignment of tabs, soldering quality, cell breakage	Major	Visual	100%	-	Work Instruction	No significant misalignment of tabs, No cell breakages and proper soldering	Producti on record	P	V
2.4	BUSSING & LAYUP	Soldering Peel Strength Test	Major	Soldering Strength	2 tests / day	-	Work Instruction	≥ 1N	Quality log book	P	V
		Visual check for misalignment of cell strings, external material	Major	Visual	100%	-	Work Instruction	No significant misalignment No external stray material	Producti on record	P	V
2.5	EL TEST	EL Image Analysis	Major	Electrical	100%	-	Plant Standard	As per Annexure-1 of this QAP	Producti on record	P	V

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DATE: 20.06.2024 Page 4			APPROVED BY: RAGHAVENDRA BABU.G.V, SR.MGR/QUALITY	



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3.4	INSULATION/RESISTANCE (BEFORE AND AFTER HV TEST) for 2min	IR Test :Determining Insulation Resistance by applying 1500V DC with HV/IR tester	Major	Electrical	1 Module/ Shift	-	Plant Standard/ approved datasheet/ Customer Specification	>40M ohms.m2	Production record		P	V
3.5	MODULE TO WITHSTAND HV OF 4000V DC for 1min	HV Test: Ensure that leakage current is less than specified limit by applying a high voltage of 1000 V+2X(system voltage) DC with HV/IR tester	Major	Electrical	1 Module/ Shift	-	Plant Standard/ approved datasheet/ Customer Specification	No arcing, no dielectric failure	Production record		P	V
3.6	MECHANICAL LOAD TEST	MECHANICAL LOAD TEST	Major	Electrical	1 Module/ Week	-	Plant Standard/ / Customer Specification /	As per IEC 61215	Inspection/ Test report		P	V
3.7	ROBUSTNESS OF TERMINATION TEST	ROBUSTNESS OF TERMINATION TEST	Major	Electrical	1 Module/ Lot	-	Plant Standard/ / Customer Specification	As per IEC 61215	Inspection/ Test report		P	V

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BHARAT HEAVY ELECTRICALS LIMITED SOLAR BUSINESS DIVISION, Prof. CNR Rao Circle, Opp. IISc., Malleshwaram , Bangalore-560012				ITEM: SPV MODULES		DRG_NO. : AS PER SOLAR MODULE DRAWING & DATASHEET							
				Type of Check		Quantum of Check		Reference Document		Acceptance Norms		Format of Record	
Sl. No.	Component & Operations	Characteristics	Class									Agency	Remarks
1	2	3	4	5	6	7	8	9	D*	10	11		

3.8	WET LEAKAGE TEST	INSULATION RESISTANCE	Major	Electrical	1 Module / 10MW	Plant Standard / Customer Specification	As per IEC 61215	Inspection / Test report	P	V	Destructive test
4.	ACCEPTANCE TEST										
4.1	VISUAL CHECK OF MODULE WITH NAKED EYE	Visual Inspection	Major	Visual	-	General Inspection Level S4, AQL 4.0 as per IS 2500 Part-1	Plant Standard/ approved datasheet/ approved drawing	1.Cell breakage: a. There shall be no cell cracks b. Cell Edge chip up to 2mm x 2mm 2. Air-bubbles / de-lamination: There shall not be any air bubbles or de-lamination forming a continuous path between any part of the electrical circuit and the edge of the module. There shall also be no bubbles (air-trapping) on the back-sheet.	✓	P	W


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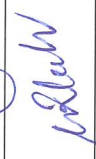
4.2	POWER OUTPUT MEASUREMENT FROM SUN SIMULATOR AT STC	Electrical parameters of PV Module	Major	Electrical	-	General Inspection Level II, AQL 2.5 as per IS 2500 Part-1	Plant Standard/ approved datasheet	Pmax as per electrical characteristics of Technical Data sheet. Measurement repeatability of peak power output (Pmax) during inspection : $\pm 2\%$	Inspection report	✓	P	W
4.3	EL TEST	EL Image Analysis	Major	Electrical	-	Special Inspection Level S-4, AQL 2.5 as per IS	Plant Standard	As per Annexure-1 of this QAP	Inspection Report	✓	P	W


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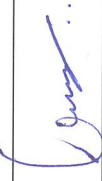

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4.4	INSULATION/RESISTANCE (BEFORE AND AFTER HV TEST) for 2min	IR Test :Determining Insulation Resistance by applying 1500V DC with HV/IR tester	Major	Electrical	-	2500 Part I Special Inspection Level S-2, AQL 2.5 as per IS 2500 Part-I	Plant Standard/ approved datasheet	>40M ohms	✓	P	W	
4.5	MODULE TO WITHSTAND HV OF 4000V DC for 1min	HV Test: Ensure that leakage current is less than specified limit by applying a high voltage of 1000 V+2X(system voltage) DC with HV/IR tester	Major	Electrical	-	Special Inspection Level S-2 and AQL 2.5 as per IS 2500 Part-1	Plant Standard/ approved datasheet/ Customer Specification	No arcing, no dielectric failure	✓	P	W	
4.6	MECHANICAL LOAD TEST	MECHANICAL LOAD TEST	Major	Electrical		1 Module/ Offered Lot	Plant Standard/ / Customer Specification /	As per IEC 61215	✓	P	W	Destructive test

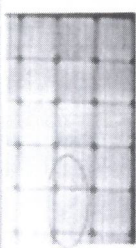
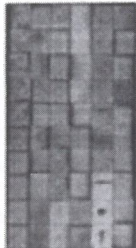
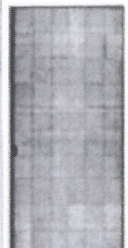
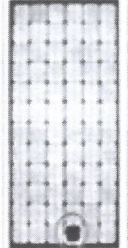
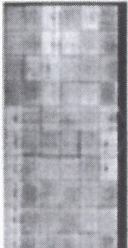
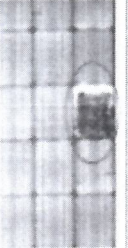
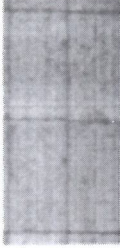
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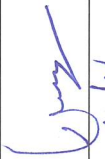

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4.7	ROBUSTNESS OF TERMINATION TEST	ROBUSTNESS OF TERMINATION TEST	Major	Electrical	1 Module/ Offered Lot	Plant Standard// Customer Specification	As per IEC 61215	Inspection report	✓	P	W	Destructive test
4.8	WET LEAKAGE TEST	INSULATION RESISTANCE	Major	Electrical	1 Module/ Offered Lot	Plant Standard// Customer Specification	As per IEC 61215	Inspection/ Test report	✓	P	W	Destructive test


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ITEM: SPV MODULES					DRG. NO. : AS PER SOLAR MODULE DRAWING & DATASHEET								

ANNEXURE-1							
EL ACCEPTANCE CRITERIA:							
Sl.	Defect	EL Pictures	Acceptance Criteria				
1	Micro Crack		≤2 nos. of cracks - in one cell (straight line cracks)				≤10% of Cell area
2	Dark Area		≤10 Nos of cells - in one module				Not accepted
3	Grid Finger Interruptions		≤10% of Cell area				Not accepted
							≤10 cells - in one module

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1	2	3	4	5	B	T	6	7	8	9	D*	10	11

**Note:-**

- The SQAP shall be read in conjunction with BHEL Specification mentioned in Purchase Order and shall deem to include any additional tests as per the specification/Standard. Sample for testing shall be selected as indicated in SQP/ BHEL Spec.
- Material supplied shall be in line with BHEL Purchase Order, Technical Specification, Approved Drawings, applicable Standard References, or any other document/references.
- In case of any contradiction between this SQAP & BHEL Specifications, the following precedence shall be followed:
  - 1<sup>st</sup>: BHEL Purchase Order Specification;
  - 2<sup>nd</sup>: This STANDARD QUALITY ASSURANCE PLAN & Applicable standard;
  - 3<sup>rd</sup>: Manufacturers plant standards
- Packing and marking of the packages shall be as per BHEL specification / purchase order.
- BHEL reserves the right for pre-dispatch inspection at vendor works by BHEL or BHEL nominated agency.
- In case of pre-dispatch inspection, Supplier shall raise the inspection call in the CQIR with inspection agency as BHEL SBD URL: [www.cqir.bhel.in](http://www.cqir.bhel.in) and shall upload Test Certificates, Internal Tests Report as per this SQAP in CQIR Portal. TC to be verified w.r.t to inspected item during inspection and to be signed by the inspector.
- Original Test Certificates, Internal Tests Report (Duly Sealed & signed), as per this SQAP shall be sent along with lot for review.

FORMAT NO.: EP-SQP-02 REVISION 00		<b>LEGEND: D* RECORDS IDENTIFIED WITH "TICK" (✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** B: MANUFACTURER, BHEL-SBD C: CUSTOMER OR CUSTOMER NOMINATED AGENCY P: PERFORM W: WITNESS AND V: VERIFICATION. AS APPROPRIATE, CHP: CUSTOMER SHALL IDENTIFY IN COLUMN "N" AS "W" TC- TEST CERTIFICATE FROM THE VENDOR.</b>	PREPARED BY: JAI CHANDRU QUALITY	
DATE: 20.06.2024	APPROVED BY: RAGHAVENDRA BABU.G.V, SR.MGR/QUALITY			
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