

 QUALITY ASSURANCE DEPARTMENT									
QA PLAN FOR: Butterfly and Ball valves QA PLAN NO: QA/HG/530 Date: 13/10/2017 PI No: _____ Revision: 00									
Sr. No.	Component/Assy. Operation	Characteristics	Class	Type of Check	Quantum of Check	Reference Documents	Record Format	Agency	Remarks
1.0	Raw Material								
1.1	Valve body & body Connector	Chemical & Mechanical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.2	Ball & Stem	Chemical & Mechanical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.3	Ball seal, Body seal, Seat & Stem packing	Chemical & Mechanical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.4	Gasket	Chemical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.5	Gland Packing	Chemical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.6	Bolts & Nuts	Chemical & Mechanical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
1.7	Other parts	Chemical	Major	R	One sample/Lot	Drawing / Product standard	TC	-	TC to be Verified by QIX/TPIA
2.0	In Process Inspection								
2.1	Heat Treatment of Body & body connector	-	Cn	R	100%	Drawing / Product standard	Record	Supplier	Record to be Verified by QIX/TPIA

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 13/10/17
 ILA YADAV
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 12/10/17

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Sr. No.	Component/Assy. Operation	Characteristics	Class	Type of Check	Quantum of Check	Reference Documents	Record Format	Agency	Remarks
2.2	Body / Cover	Dimensional	Major	R	100%	Drawing / Product standard	Record	Supplier	Record to be Verified by QIX/TPIA
3.0	Final Inspection & Tests								
3.1	Visual Inspection	-	Cri	W	100%	Drawing / Product standard	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
3.2	Dimensional Checks	-	Cri	W	100%	Drawing / Product standard	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
3.3	Hydro static test	Shell/seat/Back seat	Cri	W	100%	Drawing / Product standard	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
4.0	Conservation, Packing, Documentation Before Dispatch								
4.1	Marking, Painting & Packing	-	Major	W	100%	Drawing / Product standard	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA

Following documents/certificates to be submitted by Vendor:

- Raw material test Certificates of original manufacturers.
- Test certificates of tests conducted on Valves as per Drawing & Product standard by the supplier. Testing from NABL approved lab is permitted.
- Dimensional records.
- Guarantee Certificate

Abbreviations:

Maj - Major, Cri - Critical, TC - Test Certificate, Supp. - Supplier, QC - Quality Control, R- Review, W - Witness, QIX - Quality Control Ancillary, TPJA - Third Party Inspection Agency.

13/10/17
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HGE Sr. Design Egr

13/10/2017
D.K. Chandrasekar
Sr. MGR/ISE

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