



QUALITY ASSURANCE DEPARTMENT

QA PLAN FOR: Gate & Globe valves

PI No: _____

QA PLAN NO: QA/HG/505

Date: 27/10/2016

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, Bonnet & Yoke	Chemical & Mechanical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.2	Seat, Disc, Thrust plate	Chemical & Mechanical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.3	Spindle, Back seat, Bush	Chemical & Mechanical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.4	Gasket	Chemical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.5	Gland Packing	Chemical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.6	Bolts & Nuts	Chemical & Mechanical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
1.7	Other parts	Chemical	Major	R	One sample/Lot	BHEL Drawing/standard	TC	-	TC to be Verified by QIX/TPIA
2.0	In Process Inspection								
2.1	Heat Treatment of Body, Bonnet and Yoke.	-	Cri	R	100%	BHEL Drawing	Record	Supplier	Record to be Verified by QIX/TPIA

[Signature]
27/10/2016
(HGE)

[Signature] 27/10/16
Ritesh Gajhiya
Sr. Mgr. (HGE)

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28/10/16
(AHM)

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27/10/16
Anthon Thomas
Sr. Mgr.

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2.2	Body / Cover	Dimensional	Major	R	100%	BHEL Drawing	Record	Supplier	Record to be Verified by QIX/TPIA
3.0	Final Inspection & Tests								
3.1	Visual Inspection	-	Cri	W	100%	BHEL Drawing	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
3.2	Dimensional Checks	-	Cri	W	100%	BHEL Drawing/ Vendor Approved Drawing	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
3.3	Hydro static test	Shell/seat/Back seat	Cri	W	100%	BHEL Drawing	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
4.0	Conservation, Packing, Documentation Before Dispatch								
4.1	Marking, Painting & Packing	-	Major	W	100%	BHEL Drawing	Supp./QC record	Supplier and QIX/TPIA	QIX/TPIA
Following documents/certificates to be submitted by Vendor: I) Raw material test Certificates of original manufacturers. II) Test certificates of tests conducted on Valves as per BHEL drawing by the supplier. Testing from NABL approved lab is permitted. III) Dimensional records. IV) Guarantee Certificate									
Abbreviations: Maj - Major, Cri - Critical, TC - Test Certificate, Supp. - Supplier, QC - Quality Control, R - Review, W - Witness, QIX - Quality Control Ancillary, TPIA - Third Party Inspection Agency.									
 27/10/2016 (Anil Koyal) HGE SKDE/HGE  27/10/16 Ritosh Gajshye Sr. Mgr. (HGE)  27/10/16 Srinivas Kumar Sr. Mgr. (HGE)  Adarsh QA-Hydro									