

VOLTECH TEJAS VALVES PVT. LTD		QUALITY ASSURANCE PLAN											
SL NO	COMPONENT/ OPERATION	CHARACTERISTICS	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	TYPE OF RECORD			INSPECTED BY			REMARKS
							D	P	W	V	H		
1.0 Raw Material Inspection													
1.1	Body, End Connector, Ball (Forgings/ Castings)	Identification, Dimension Surface finish	Major	Visual & Measurement	100%-	As per VTVPL Drawings/ Quality Manual	1	3	--	3	--		
1.2		Chemical Composition & Mechanical properties	Major	Verification of MTC	One No per heat/LOT	As per ASTM Standards	1	4	--	3	--		
1.3	Bars for Stem, Trim Parts, Gland (Rolled Sec. / Forgings) & Fasteners	Identification Dimension	Major	Visual & Measurement	100%	Quality Manual	--	3	--	3	--		
1.4		Chemical Composition & Mechanical Properties	Major	Verification of MTC	One no.,per Size/lot	As per ASTM Standards	1	4	--	3	--		
2.0. IN PROCESS CONTROL and INSPECTION													
2.1	Body, End connector,	Dimension	Major	Visual & Measurement	100%	As per VTVPL Drawings/ Quality Manual	1	4/3	--	3	--		
2.2		Surface Finish	Major	Visual	100%	As per VTVPL Drawings/ Quality Manual	1	4/3	--	3	--		
2.3	Ball & Stem	Dimension and surface finish	Critical	Visual & Measurement	100%	As per VTVPL Drawings/ Quality Manual	1	4/3	--	3	--		
2.4	Ball & Seat	Surface conformity by Blue Matching	Major	Visual	1%	As per VTVPL Drawings/ Quality Manual	1	3	--	3	--		
2.5	Painting of Valve body and other accessories	Surface Preparation	Major	Visual	100%	Quality Manual	1	3	--	3	--		
LEGEND: 0:Optional 1 - Customer; 2 - Customer / Customer Nominated Agency; 3 - Voltech Tejas; 4 - Sub Vendor; P - Perform; V - Verification / Review; W - Witness; H - Hold. D - "I" mark in this column indicates that Document is required.													
Prepared By : TG				Verified By :VS				Approved By : VVB					

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3.0 Bought Out Items													
3.1	PTFE seat, Seal, Gland Packing, Stem Seal,	Identification, Dimension Surface finish	Major	Visual, Measurement	10 %	As per VTVPD Drawings/ Quality Manual	Inward Inspection report	1	4	--	3	--	
3.2	Fasteners Disc Spring, Levers	Identification, Dimension Surface finish	Major	Visual, Measurement	10 %	As per VTVPD Drawings/ Quality Manual	Inward Inspection report	1	4	--	3	--	
4.0. ASSEMBLED VALVE and TESTING													
4.1	Valve Final Assembly	Completeness and correct alignments	Major	Visual	100%	As per VTVPD Drawings/ Quality Manual	Internal QC Report	1	3	--	3	--	
4.2		Opening & Closing of Valve	Major	Valve Operation	100%		Test Report	--	3	--	3	--	
Pressure Tests													
4.3	Pressure Test	Hydro Body/Seat	Critical	Hydro Test (HT)	100%	BS 6755 Part I	No Leakage/ Test Report	1	3		3		-
4.4		Pneumatic air	Critical	Air seat Test	100%		No Leakage/ Test Report	1	3	--	3	--	
5.0 Pre delivery Inspection													
5.1	Marking & Identification	Name Plate Details	Major	Visual Verification	100%	As per VTVPD Drawings/ Quality Manual	Inspection Report	1	3	--	3	--	
5.2	Valve End Protection	Damage Control	Major	Visual / Verification	100%	Quality Manual	Inspection Report	1	3	--	3	--	
5.3	Packing	Transit worthy	Major	Visual	100%	Quality Manual	Inspection Report	1	3	--	3	--	
5.4	Inspection Clearance	Documentation & Certification	Major	Verification	100%	Quality Manual	Inspection Report	1	3	--	3	--	
Notes : There Shall be correlation with raw material test certificates.													
Chemical analysis & Mechanical tests shall be performed in approved laboratories. Calibrated instruments shall be used during testing.													
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