

		INSPECTION TEST PLAN FOR THREE PIECE FLOATING BALL VALVES						QAP No:	BV - 600XXXX		Rev:	0		
SO No		600XXXX		Customer	CRS MARKETING						Approved by: NMG			
PO No		NIL		Project	NA			Appl Tech Spec	NA					
SI No	Component & Operation	Characteristic	Class	Type of Check	Quantum of Check	Reference Document	Acceptance Norm	Format of Record	Agency				Remarks	
									Supp	CMG	L&T	TPI		
1.0 RAW MATERIAL:														
1.1	Casting & Forging: Body & connector	Chemical	Major	Chemical Analysis	Each Heat	Standard	Standard	Test Certificate	P	R	R	-		
		Heat Treatment	Major	Review of TC	100%	Standard	Standard	Test Certificate	P	R	R	-		
		Mechanical	Major	Mechanical Test	Each Heat	Standard	Standard	Test Certificate	P	R	R	-		
		Visual Inspection	Major	Visual	100%	MSS SP-55	MSS SP-55	Test Certificate	P	P	R	-		
2.0 FINISHED METAL ITEMS:														
2.1	Stem & Ball	Chemical, Mechanical	Major	Review of TC or CC	L&T Sampling Plan	Standard / Drawing	Standard / Drawing	TC or CC	P	R	R	-		
3.0 FINISHED NON METAL ITEMS:														
3.1	Seat, Seal & Packings	Density	Major	Review of TC or CC	L&T Sampling Plan	Standard / Drawing	Standard / Drawing	TC or CC	P	R	R	-		
4.0 IN-PROCESS:														
4.1	Machined Components	Visual & Dimension	Major	Visual & Measurement	5% at random	L&T Drawing	L&T Drawing	Record	-	P	R	-		
5.0 FINAL INSPECTION:														
5.1	Valve Assembly	Shell Test	Critical	Air	100%	Approved GAD	Approved GAD	Test Record - VTR	-	P	10% W	10% W	Per size / Class / Type	
		Seat Test	Critical	Air										
		Visual & Dimensions	Major	Visual & Measurement	L&T Sampling Plan	Approved GAD	Approved GAD	PDI Report	-	P	R	R		
5.2	Cleaning & Packing	Visual Inspection	Minor	Visual	Random	L&T Procedure	L&T Procedure	Packing List	-	-	P	-		
6.0 FINAL RELEASE:														
6.1	Final Release	Release for despatch					VTC	-	-	P	R			
NOTE: R - Review, P - Perform, W - Witness, H - Hold point, TC - Test Certificate, GAD - General Assembly Drawing, CC - Compliance Certificate, TPI - Third Party Inspection, CMG - Contract Manufacturing, VTC - Valve Test Certificate, VTR - Valve Test Report														