

		INSPECTION TEST PLAN FOR SINGLE & TWO PIECE FLOATING BALL VALVES						QAP No:	BV - 600XXXX		Rev:	0				
SO No		600XXXX		Customer	CRS MARKETING						Date:		02.01.2012		Prepared by: PBB	
PO No		NA		Project	N/A						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 : Body & connector	Chemical	Major	Chemical Analysis	Each Heat	Standard	Standard	Test Certificate	P	R	R	R				
		Heat Treatment	Major	Review of TC	100%	Standard	Standard	Test Certificate	P	R	R	R				
		Mechanical	Major	Mechanical Test	Each Heat	Standard	Standard	Test Certificate	P	R	R	R				
		Visual Inspection	Major	Visual	100%	MSS SP-55	MSS SP-55	Test Certificate	P	P	R	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	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	L&T Procedure	L&T Procedure	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	Hydro	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						MTC / VTR / 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																