

QUALITY ASSUARANCE PLAN

MANUFACTURER'S NAME: Water Supply Specialities			ITEM: Positive Displacement Triplex Reciprocating Single Acting Pump		CUSTOMER: CONTRACTOR: P.O. NO:				
COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK/ PARAMETERS	QTY.OF CHECK	PREFERENCE DOC.	ACCEPTANCE NORM	FORMAT OF RECORDS	REMARKS	
								WS	CL
<u>RAW MATERIAL INCLUDE CHECKS FOR :</u> CASING, CASING COVER, FLUID END, PLUNGER, VALVES, CROSS HEAD, CONN.ROD, CRANSHAFT, PINION & GEAR (if applicable)									
	METAL PROP	CR	MECH & CHEM	PER MELT /HEAT		APPD DRG/DATA SHEET / RELEV SPEC	MCC	P	V
	UT if Crankshaft pin size > 100mm DIA	CR	HARDNESS UT	100%		ASTM A388 / M2032		P	V
BOUGHT OUT ITEMS LIKE PACKING, BEARINGS, NUT & BOLT, V RINGS, GASKET, O RINGS	VISUAL	MA	VISUAL	100 %		NO SURF ACE DEFECTS	MCC	P	-
<u>IN PROCESS INSPECTION</u> VARIOUS COMPONENTS AS ABOVE									
CASING, COVER, CRANKSHAFT, CROSSHEAD, GEAR/PINION (if applicable), PLUNGER,	DIMENSIONAL	MA	DIMENSIONAL	100%		MFG DRAWING	MCC	P	-
	SURFACE FINISH/DP	CR	RMS /CRACK DETECTION	100%		MFR. RECOMMEND.	MCC	P	V
VALVES, FLUID END	HARDNESS TEST	CR	HARDNESS	100%		MFR. RECOMMEND.	MCC	P	V
	LEAK TEST	CR	VISUAL	100%		APPD DG / RELV NO LEAK SPEC	MCC	P	-
<u>FINAL TESTING OF PUMP ASSY</u> HYDROTESTING (CASING COVER) (DURING PERF.TEST) WITH TEST BED MOTOR									
PERFORM TEST WITH WATER WITH TEST BED MOTOR	LEAK TIGHTNESS	MA	VISUAL	100%		NO LEAKAGE FOR TEST DURATION OF 20 MINS (1.3 X WORKING PRESSURE SUBJECT TO MAXIMUM 1000KG/SQ.CM)	MCC	P	V
	PERFORMANCE TEST FOR 2 Hrs.	CR	PRESSURE, FLOW, SPEED, OIL LEAKAGE, POWER CONSUMPTION	100%		APPO DRG/DATA SHEET / RELV SPEC	I.R	P	W
STRIP TEST (LTD TO BEARING) INSPECTION IN ABSENCE OF NORMAL PERFORMANCE-	CHECK FOR WEAR	M.A	VISUAL	100%		APPO DS/DRG NO UNDUE WEAR / DUE TO RUBBING	I.R	P	W
ASSEMBLY OF PUMP ON BASE PLATE SURFACE CLEANING & PAINTING (IF APPLICABLE)	DIMENSIONS, VISUAL FINISH, SHADE.	MA MA	VISUAL / MEAS	100% 100%		APPROVED DRAWING APPD DRG / DATA SHEET			
			VISUAL	100%			I.R	P	-
DOCUMENTATION	COMPLETENESS OF DOCS	MA				APPD DATA SHEET & DRAWING			
PACKING		MA	VISUAL	100%					
NOTE: 1) APPROVED DRAWING & / OR DATA SHEET AS APPLICABLE									
SIGN / STAMP OF MFR		SIGN / STAMP CONTRACTOR		MA – Major, CR – Critical, MCC- Manufacturer Compliance Certificate, IR – Inspection Report P – Perform, V – Verification, W – Witness WS – Water supply Specialities CL- Client/Authorized Agency			APPR. AUTHORITY		