



UNIQUE DOSING SYSTEMS
QUALITY ASSURANCE PLAN



WKS/F/08/0

SR NO	COMPONENTS / STAGE OPERATION	CHARACTERISTICS CHECKED	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORM	FORM OF RECORD	AGENCY	REMARK
1	RAW MATERIAL 1. PUMP LIQUID END(WETTED PARTS) VALVE THROAT BUSH HEAD,PLUNGER, VALVE HOLDER, PLATE 2. PIPE TANK SHEET PRV , DAMPNER NRV	DIMENSIONAL INSPECTION DIMENSIONAL INSPECTION	INSPECTION BY MEASURING INSTRUMENTS INSPECTION BY MEASURING INSTRUMENTS	100 % 100 %	AS PER PURCHASE ORDER AS PER PURCHASE ORDER	AS PER PURCHASE ORDER AS PER PURCHASE ORDER	INSPECTION REPORT INSPECTION REPORT	Q.A Q. A .	
2	IN PROCESS INSPECTION MACHINING OF ALL COMPONENTS	DIMENSIONS	INSPECTION BY MEASURING INSTRUMENTS	100%	PART DRG.	TOLERANCE AS PER PART DRAWING	INSPECTION REPORT	Q.C. ENGR.	
3	ASSEMBLY & WELDING	FIT UP	VISUAL	100%	AS PER G.A. DRAWING	ALL DIMENSION SOULD BE WITHIN TOLERANCE AS PER G. A. DRAWING	TEST REPORT BY UNIQUE	UNIQUE	



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4	LIQUID HEAD & INTERCONNECT PIPING HYDRO TEST	PRESSURE HOLDING CAPACITY	HYDROSTATIC TEST AT 1.5 TIMES WORKING PRESSURE FOR 30 MIN. WITH WATER	100%	API 675	NO LEAKAGE	HYDRO TEST REPORT BY UNIQUE	Q.A.	TEST REPORT PROVIDED TO CUSTOMER
5	FINAL INSPECTION PUMP UNIT WITH MOTOR	PERFORMANCE TEST AT VARIOUS STROKE LENGTHS	CAPACITY AT VARIOUS STROKE AT WORKING PRESSURE, AMP., VOLT., POWER AT MAXIMUM STROKE.	100%	API 675	PERFORMANCE TO BE RECORDED AS PER API 675	PUMP PERFORMANCE TEST REPORT BY UNIQUE	Q.A.	TEST REPORT PROVIDED TO CUSTOMER
6	PAINTING AND PACKING	SURFACE FINISH SOUNDNESS OF PACKING MATERIAL	VISUAL	100%	MANUFACTURER STANDARD	MANUFACTURER STANDARD	PACKING LIST	Q.C. ENGR.	