

QUALITY ASSURANCE PLAN



PROJECT : : BD80
 NOMENCLATURE : KIT WIRE HARNESS
 PART No. : 1955AAFK013F

DOC NO : QP/KWH/1955AAFK013F
 Rev No.: 0
 Date: 30.11.2024

SLNO	DESCRIPTION	CHARECTERISTIC / PARAMETERS / TYPE OF CHECK	QAUNTUM OF CHECK	TESTING STANDARD	ACCEPTANCE STANDARD / SPECIFICATION	FORMAT OF RECORD	QA AGENCY		REMARKS
							SUP	BEML	
1	Scope of kit	No of items & Qty / kit, spare items	100%	Drawing	Shall confirm to drawing BOM	COC	P	P/R	
2	Visual Aspects	Visual	100%	Drawing	To be manufactured as per BEML Company Standard PR1030-C - Manufacturing Procedure for wire harness & tested As per BEML Company Standard IP1053000-C - Inspection & Testing standard for Wire harness	Inspection report	P	P/R	
3	Material								
3.1	Cables (including Battery cables)	As per drawing /applicable standard	As per standard	Drawing / IS standard / SAE standard/ Company standard/JIS C3406 / JASO D611 / KES D 08024	Shall conform to relevant drawings / IS standard / SAE standard / ISO standard / Company standard requirements / JIS C3406 / JASO D611/KES D 08024	NABL Lab Test reports / OEM certificate/ Manufacturer's standard format	P	R	For Each Batch Relevant doucments to be submitted along with supply
3.2	Terminals								
3.3	Connectors & Connector pins								
3.4	Conduits								
3.5	Sleeves								
3.6	Insulation tape, Heat shrink Tube, ring terminals, tabs, terminals caps, insulation tape etc.,								
3.7	shielded cable for signals								
4	Dimensions Check	Dimensions of individual component & assy dimensions	As per Sampling Plan	Drawing / IS standard / Company standard	Shall confirm to drawing / company standard requirements.	Inspection report	P	P/R	

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5	Continuity test	Continuity	100% by supplier.	Drawing / Standard	Shall confirm to drawing / Company standard requirements.	supplier test report	P	R	
6	Pull test	Crimping Strength	one per batch	Company standard CEW03	Shall confirm to table 2 of Company standard CEW03 requirement	supplier test report	P	R	Applicable for P/no's: CEW03 02105 CEW03 41417 CEW03 41527 CEW03 42603 CEW03 42617 CEW03 42737
6	Identification Marking	Label	100%	-	Routing tag , label with Part No., VC No & Batch .No on Each wire Harness assy,	Check Sheet	P	R	
7	Preservation/ Packing	Visual	100%	-	Individually each harness to packed in plastic bag & packed in Carton box and affix packing slip with list of items along with spare items as indicated in KIT & Individual drawings.	Check Sheet	P	R	

Note: SOFT COPY OF QUALITY DOCUMENTS INLINE WITH QAP TO BE TO MAIL ID: qer@beml.co.in BEFORE DESPATCH

Sampling Plan : As per IS: 2500- 2000, Part 1, Level -II. Details mentioned in below.

Lot Size in Nos	Sample Size in Nos	AQL
2 ~ 50	8	1.5%
51 ~ 90	13	1.0%
91~150	20	0.65%
151~280	32	0.40%
281~500	50	0.25%
501~1200	80	0.15%
1201~3200	125	0.10%
3201~10000	200	0.065%

M -Manufacturer
P - Perform the Activity
W: Witnessing of Activity
R: Reviewing of QA Report

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- Note :**
1. Vendor to follow PR1030-C - Manufacturing procedure for wire harness during manufacturing of Wire harness.
 2. Vendor to strictly follow the General Notes , Specific requiriements & Notes indicated in the drawing, for any query or doubt may contact BEML for clarification
 3. Vendor to submit FRHR Test certificates for Conduits, Cables, Tapes etc., where ever applicable.
 4. Vendor to supply full quantity of spare items called in the BOM, notes & along with parts of individual drawings
 5. Vendor shall not deviate any make of the parts
 6. Vendor shall not deviate any colours of the wires/cables

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