



Vendors' Meet 2020

21st October 2020

*“Prosperity through
Partnership”*

Presentation on Quality (Expectations from Vendors)



Vendor Base – Project items

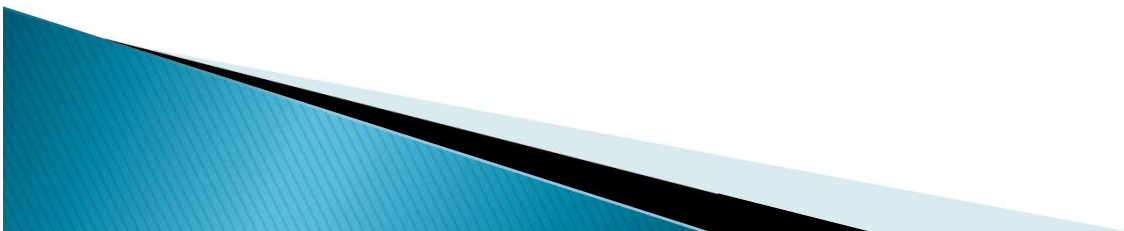
(As on 01st October,2020)

No. of Approved Vendors (AVL) - 1698

No. of ISO Certified Vendors - 1508

ISO 9001 Quality Management system requirements are very much essential to achieve consistent product quality.

- Existing ISO vendors to upgrade to the latest ISO 9001 -2015 Version and submit the certificates**



MSME Vendors base– Project items

(As on 01st October, 2020)

CATEGORY	No. of Vendors
MICRO	283
SMALL	587
MEDIUM	41
TOTAL	911

Against **1698** Registered Vendors under AVL category,
MSME vendors are 911



Initiatives for improving Quality of vendor supplies -

- **Vendor development remains the “focus area” to improve Quality.**
- **Reviewing of Rejections of Vendor Supplied items by Divisional Quality Team & Source Inspection Team (SIT)**
- **Corrective and Preventive actions (CA / PA) at Vendors’ premises are being reviewed by Quality team**
- **Experts from Quality, R&D, Tooling departments will be deputed to guide the suppliers for improvement of Process / Quality systems**

Initiatives for improving Quality of vendor supplies -

- **Periodic Process / System audits by Quality Team**
- **Vendors' are encouraged to work towards obtaining "Self-certification" status for their supplies**
- **BEML is ready to extend help in training, guiding for improving processes towards self certification**

Vendor Performance - Measurement

For the current year , MIS on few Quality parameters

- **No. of Vendors whose Quality Acceptance score in the range 90~100% has gone up from 83.8% to **90.75%**.**
- **Vendor Rejection (Incoming and Processing stage) is at **0.55%** of VOP**
- **Suggestion / feedback for Quality improvement of Components can be sent to concerned purchase dept with a copy to Divisional and Corporate Quality Dept.,**



Expectations -

- **Supplies should adhere to PO / Latest Drawing / TDC requirements**
- **Understanding of DRG. fully before taking up for processing – interact with Purchase to have clarity and avoid possible rework/rejections**
- **Part to be processed as per latest Drg. Only**
- **For items developed first time, first article inspection (FAI) & process establishment.**
- **Self inspection and documentation**
- **Test Certificates & Check sheets should be complete and accurate (in line with QAP)**

Expectations -

- **Before quoting for new development, all bought-out / sourcing issues to be fully visualized to avoid last minute non-conformance.**
- **In case of development of aggregates, wherever sources are not specified in the Drg., Vendor should approach concerned Purchase / Design department for the Make / Model of the Items / Hardware that to be used. This will help in the smooth acceptance process.**
- **Corrective & Preventive Action (CAPA) to be promptly carried out.**
- **Address Rejection / Field performance issues on priority and implement the corrective actions in the immediate batches .**

Checks to be followed to avoid Rejection :

- ▶ Vendors shall clearly study drawings , obtain clarification (if any) , establish right process to meet desired specification before taking-up bulk Production.
- ▶ Conformance of Raw material / Input material specification against BEML drawing shall be strictly verified either through **NABL Labs or Bemi Approved Labs.**
- ▶ Quality Plan / Dimensional check sheets, shall be prepared for each of the components offered for inspection. **Establish Internal Quality control system.**
- ▶ **Heat Treatment and Surface treatment process** shall be done through a BEML approved Sub-vendors. **Process qualification is to be ensured** prior to bulk production. .
- ▶ **Measuring Instruments** used shall have **valid Calibration** certificates / record.
- ▶ All Functional Tests called in Drawing / required as per Quality Plan shall be carried out 100% (not partially). **Incomplete test reports liable for rejections .**
- ▶ Vendors shall submit **Inspection document (Soft copy preferred)** along with Delivery challan , to ensure speedy clearance of the components.
- ▶ .



Self-certification/Waiver of Inspection

BEML wants to promote self-certification

As on date 209 Suppliers have been accorded Self-certification / Inspection Waiver status

Self certification Procedure:

- ✓ **Should have a formal ISO 9001 -2015 Certification**
- ✓ **Rejection in past 2 years to be less than 1%**
- ✓ **Should meet minimum requirements w.r.t :**
 - **Incoming material control**
 - **Manufacturing process control**
 - **Inspection and test plan**
 - **Improvement initiatives**
 - **Technical Documentation as per ISO norms**

Will be accorded after assessment



जयभारत