Annexure – A

Pre-dispatch Inspection Protocol for Crystalline PV Modules by Customer or Customer Deputed Agency

Contents

Pre-dispatch inspection procedure

1. Objective:

The objective of this document is to establish General inspection protocol with objectivity for verification of Quality Parameters of Solar Modules by the customer (or its authorised inspection agency) prior to dispatch. The decision rules and procedure specified herein seek to uphold quality standards based on industry best practices and technical specifications laid out in tender documents as well as to control risks associated with item procurement.

2. Standard:

Sampling for determining Acceptance Quality Level (AQL) shall follow ISO2859-1:1999.

3. Definitions:

1. Lot: All products/items manufactured in one batch.
   Notwithstanding the aforementioned definition, the customer or authorized inspection agency can lay down alternate/additional criteria for determining a lot.
2. Major Defect: A defect that reduces the usability or causes the product to fail to fulfil its nominal characteristic function.
3. Minor Defect: A defect that does not reduce the usability of the product, but does not meet the quality standard.

4. Inspection Schedule:

Customer representative shall propose the schedule for Pre despatch Inspection of Finished Goods to the Customer well in advance, and in no case less than 3 working days prior to commencement of Inspection at a location within India and 7 days in case of a foreign country.

5. Scope of Inspection:

Supplier representative will accompany the Inspector while doing the inspection which shall typically consist of 2 steps for clearance of each Lot:

BOM verification: To be conducted prior to the commencement of production.

The details of materials used will be verified from the ERP/Manufacturing data and corroborated with the Construction Data Form (CDF). This shall include verification of following:

Item	Method of Verification
Shelf life of the following BOM items: • EVA • PV Module Back sheet • Sealant and potting material (Silicone)	1. Verify the expiry date/shelf life and storage conditions *The PV Module manufacturer shall submit all required information to prove that materials being used are within their shelf life.*

Note: Supplier shall provide the necessary documents for approval of BOM as per IEC standards and tender Technical Specifications.

Witness Tests:

Manufacturer shall assist the Inspecting agency to witness following checks, the details of which are provided elsewhere in this document:

I. Flash test- As per sampling Plan

II. Visual Inspection- As per sampling Plan

III. EL Inspection-As per Sampling Plan

IV. Electrical Characteristics (Other than Flash Test)- As per Sampling Plan

Note: The Supplier shall furnish soft and hard copy of the Production Quality Plan prior to commencement of the Inspection.

6. Sampling Process:

a. Supplier shall provide the list of modules in a lot ready for despatch, along with flash test data (Measured Electrical Data, P_{max}) prior to commencement of Inspection tests.

Note: Smallest lot size for Inspection: 20% of the capacity as per the PO.

b. Supplier will arrange to move the PV Modules from FG to Inspection area.

c. Same samples shall be used for all Witness Tests stated at 5.2 above.

d. Inspector shall commence Inspection process by randomly selecting samples from the list of serial nos. (pallet-wise) provided by Supplier as per ISO 2859: Single Sampling Plan for Normal Inspection, General Inspection plan level-II. However, the Inspector shall reserve the right to switch to tightened or reduced level of Inspection as per the lot quality.

7. Decision Rules for Acceptance/Rejection

Following is a summary of Decision Rules for Acceptance/Rejection of a given Sample in a lot offered for Inspection:

Table 1: AQL Levels

Defect Type	AQL (%)
Major (Ma)	2.5
Minor (Mi)	4

Table 2: Inspection Levels

Inspection steps	Inspection item	Inspection level
1.	Flash Test	General inspection level I
2.	Visual	General inspection level I
3.	EL	General inspection level I
4.	EC (Other than Flash Test)	10 Nos. per lot

8. Inspection Process

a. Electrical Inspection – Flash Tests

For Electrical inspection following preparation will be done:

- Module Temp Stabilisation : Modules will be kept in controlled environmental condition till it reaches 25 ±2ºC
- Calibration of Sun-simulator: Sun-simulator will be calibrated as per Calibration Reference .Reference should calibrated against Calibration Reference tested from reputed testing lab TUV / Fraunhofer etc. Testing of modules will be done at STC condition, AM=1.5

Note:

i All modules selected for sampling inspection will be re-tested in the sun-simulator. A P_{max} retest (repeatability test) variation of ± 2 % on actual flash P_{max} value will be acceptable.

ii The Supplier shall provide a valid calibration certificate of the apparatus used.

b. Visual Inspection:

- Customer representative will verify the module visual characteristics as per the Visual Acceptance norms.
- The Visual Inspection shall be carried out in a well-lit room. It shall be the responsibility of the Supplier to ensure adequate brightness in the room.

c. Electroluminescence (EL) Inspection:

- The EL image shall have sufficient resolution for analysis of defects.

- Hi-pot test shall be done as per IEC procedure. The Supplier shall provide a valid calibration certificate of the apparatus used.

9. Re-inspection and review

In case of minor non-conformities like cleaning issues, label mismatch, etc. which can be easily reworked, Supplier shall rework/replace the modules and offer them for re-inspection to Inspector.

10. Inspection Summary:

Once the inspection is completed Customer Representative will compile his Inspection Summary Report and share with Supplier and give necessary recommendation on despatch depending upon the audit findings based on the observations made. This report shall be provided within same day of inspection (Format Attached).

11. Disclaimer:

Inspection by SECI/ Employer does not absolve the responsibility of the Supplier/vendor to ensure quality during production of the material and its transport to site. Any damages during transport/ handling shall be replaced before erection at site as directed by Engineer-in-charge without any extra cost to the purchaser.

Sampling Plan

(Sampling Plan as Per ISO 2859) -1

Table 1 - Sample size code letters (see 10.1 and 10.2)

Lot size		Special inspection levels				General inspection levels		
		S-1	S-2	S-3	S-4	I	II	III
2 to	8	A	A	A	A	A	A	B
9 to	15	A	A	A	A	A	B	C
16 to	25	A	A	B	B	B	C	D
26 to	50	A	B	B	C	C	D	E
51 to	90	B	B	C	C	C	E	F
91 to	150	B	B	C	D	D	F	G
151 to	280	B	C	D	E	E	G	H
281 to	500	B	C	D	E	F	H	J
501 to	1 200	C	C	E	F	G	J	K
1 201 to	3 200	C	D	E	G	H	K	L
3 201 to	10 000	C	D	F	G	J	L	M
10 001 to	35 000	C	D	F	H	K	M	N
35 001 to	150 000	D	E	G	J	L	N	P
150 001 to	500 000	D	E	G	J	M	P	Q
500 001 and over		D	E	H	K	N	Q	R

Table 2-A — Single sampling plans for normal inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																													
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A	2	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31
B	3	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45
C	5	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	⇧
D	8	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	⇧	
E	13	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	⇧		
F	20	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧		
G	32	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧		
H	50	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧			
J	80	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧			
K	125	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧				
L	200	⇩	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧					
M	315	⇩	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧						
N	500	⇩	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧							
P	800	⇩	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧								
Q	1 250	0 1	⇧	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧	⇧								
R	2 000	⇧	⇧	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧

⇩ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

⇧ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 2-B — Single sampling plans for tightened inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A	2	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	27 28
B	3	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	27 28	41 42
C	5	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	27 28	41 42	⇧	⇧
D	8	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	27 28	41 42	⇧	⇧	⇧
E	13	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	27 28	41 42	⇧	⇧	⇧	⇧
F	20	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧
G	32	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
H	50	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
J	80	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
K	125	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
L	200	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
M	315	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
N	500	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
P	800	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
Q	1 250	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
R	2 000	0 1	⇧	⇩	1 2	2 3	3 4	5 6	8 9	12 13	18 19	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
S	3 150			1 2																								

⇩ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

⇧ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 2-C — Single sampling plans for reduced inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A	2	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇩	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	⇩
B	2	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	⇩
C	2	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇧	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	14 15	21 22	⇩	⇩
D	3	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇧	1 2	2 3	3 4	5 6	6 7	8 9	10 11	14 15	21 22	⇩	⇩	⇩
E	5	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	14 15	21 22	⇧	⇩	⇩	⇩
F	8	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇧	⇧	⇧	⇩	⇩	⇩
G	13	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩
H	20	⇩	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
J	32	⇩	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
K	50	⇩	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
L	80	⇩	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
M	125	⇩	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
N	200	⇩	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
P	315	⇩	0 1	⇧	⇩	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩	⇩
Q	500	0 1	⇧	⇧	⇩	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧
R	800	⇧	⇧	⇧	1 2	2 3	3 4	5 6	6 7	8 9	10 11	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧	⇧

⇩ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

⇧ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Customer inspection Report

CUSTOMER INSPECTION REPORT			
Ref. No. & Date:			
Client:	**PMC**: SECI	**EPC Contractor**: PO Ref. No.:	
Place of Inspection:	**Date of inspection:**	**Lot Size**	**Sample Quantity**
Problem Quantity: **Detail:** **Inspection Result (OK/Not OK):**			
Visual Inspection **Problem Quantity:** **Detail:**			
Flash Test **Problem Quantity:** **Detail:**			
EL Inspection: **Problem Quantity:** **Detail:**			
EC Inspection (Hipot,DC Continuity,IR): **Problem Quantity:** **Detail:**			
Any Other Criteria/Remarks:			
Is the shipment qualified to be released? ☐ ☐ **Yes** **No**			
From Client	From EPC Contractor	Solar Energy Corporation of India Limited	

Enclosed: Test Details, Flash Test Report, EL test (images- soft copy), EC Test Report

Disclaimer: *This Inspection by SECI/ Employer does not absolve the responsibility of the vendor to ensure quality during production of the material and its transport to site. Any damages during transport/ handling shall be replaced before erection at site as directed by Engineer-in-charge without any extra cost to the purchaser.*

Details:

Lot :				**Date**
S.No.	**Defect**	**Module Id**	**Type (Ma/Mi)**	**Details**
1				
2				
….				