

Industry & Facilities Division  INSPECTION REPORT N° INS/SW-CD-14/074	Page: 1/10
	<input type="checkbox"/> Interim <input checked="" type="checkbox"/> Final
BV Job nr: INS/SW-CD-14/074	

PROJECT: Third Party Inspection For Gasket	Ref: INS/SW-CD-14/074
BV Client: Chengdu DERBO Steel Co.,Ltd	P/o nr: INS/SW-CD-14/074 <i>(client to BV)</i>
Manufacturer: Ningbo Tecson sealing technology Co.,Ltd	P/o nr: N/A <i>(client to Manufacturer)</i>
Inspection requested by: Chengdu DERBO Steel Co.,Ltd	

SUPPLY / SUBJECT OF INSPECTION	ITEM / TAG Nr	QTY
Gaskets, details refer to annexe 1-subject inspection list	NA	125 Set

DOCUMENTS OF REFERENCE : See continuation sheet for additional documents: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No				
Title	Reference n°	Rev.	Approved by	Date
Technical and commercial proposal for third party inspection service	INS/SW-CD-14/074	0	Client	Dec.12,2014

INSPECTIONS : <u>Inspection place & Date or Period:</u> Place: 1288#, Qianying Road, Cixi, Ningbo City, Zhejiang province, China Date: 16 th ~ 17 th , Dec., 2014 <u>Stage of inspection :</u> <input type="checkbox"/> Before manufacturing <input type="checkbox"/> During manufacturing <input checked="" type="checkbox"/> Final <input type="checkbox"/> Packing <u>Type of inspection:</u> <input type="checkbox"/> Pre-inspection meeting <input type="checkbox"/> Document and QC record review <input checked="" type="checkbox"/> Visual examination, checks <input checked="" type="checkbox"/> Witnessing tests <input type="checkbox"/> Manufacturing progress status <input type="checkbox"/> Vendor assessment <input checked="" type="checkbox"/> Final inspection <input type="checkbox"/> Packing <i>(for details see continuation sheet)</i> <u>Stamping :</u> <input checked="" type="checkbox"/> No <input type="checkbox"/> BV <input type="checkbox"/> CV	<u>Results of inspection :</u> <input checked="" type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory <u>Non Conformities Reports (NCR):</u> o NCR's issued during reported period : None o List of outstanding NCR's : None <u>Main Conclusions & Remarks:</u> BV inspector inspected insulation gaskets in Ningbo Tecson sealing technology Co.,Ltd on 16 th ~17 th , Dec., 2014. Final inspection result is satisfactory. (for more details, please refer to the inspection details hereinafter) <u>Next visit scheduled:</u> NA
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INSPECTION REPORT N° INS/SW-CD-14/074**BV Job nr: INS/SW-CD-14/074****Description of the inspections carried out:****➤ Introduction** (*Attendees, BV scope of work*)

Third Party Inspection for _gaskets_ was carried out by _Mr. Daozhou. Zhang_, the inspector from Bureau Veritas Quality Service (Shanghai) Co., Ltd on _16th~17th, Dec., 2014 _ in Ningbo Tecson sealing technology Co., Ltd which located at Ningbo City, Zhejiang Province, China_.

BV scope of work:

- 1) Quantity check
- 2) Marking inspection at rate 20%
- 3) Visual inspection at rate 20%
- 4) Dimension inspection at rate 20%

➤ Applicable Documents & Status of Approval (*Type of documents reviewed & endorsed*)

Same as above documents of reference

➤ Manufacturing Progress Status (*Quantities*)

The above mentioned gaskets have been completed & packed and ready for TPI before BV inspector arrived.

➤ Details of inspection activities carried out with respect to scope of work (*Visual examination, witnessing NDT, dimensional checks, material identification...*)**● Quantity check**

The gasket quantity was checked by BV inspector as per product list, 1 set gasket including soft plastic pipe; G10 gasket; ZPS gasket; G10/316 gasket, the quantity was same as product list.

● Marking check at rate 20%

The marking was checked by BV inspector at rate 20%, the marking was found on G10/316 gasket, the marking is "IGCC_VCS-g10-TEF_SIZE_CLASS_ANSI_16.5_WO:TCB0051104", refer to attached photos.

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- **Visual inspection at rate 20%**

The visual inspection was carried out by BV inspector at rate 20% per item, slight scratch and glue mark can be found on part sampling G10/316 gaskets, but the manufacturer said that these defect didn't affect the using, so the visual inspection result was acceptable.

- **Dimension inspection at rate 20%**

The dimension inspection was carried out by BV inspector at rate 20% per item, the inspection result can meet the manufacturer's data sheet and specifications, the details inspection result as below table:

		Unit:mm		
Description	Name	16" 900LB	8" 900LB	8" 1500LB
G10 retainer	OD	77.81~77.88	66.64~66.74	77.69~78.06
	ID	42.72~42.87	36.41~36.61	42.38~42.73
	THK	2.97~3.01	3.04~3.12	2.97~3.06
ZPS washer	OD	77.42~77.48	66.56~66.59	77.37~77.47
	ID	42.72~42.77	36.36~36.44	42.58~42.80
	THK	2.97~3.00	2.99~3.01	2.92~3.00
Mylar sleeve	OD	43.02~43.30	36.65~36.85	42.93~43.31
	ID	42.18~42.34	35.49~35.68	42.05~42.10
	L	195.3~195.6	144.0~144.6	201.1~201.7
G10/316 Gasket	OD	569.5~569.7	353.9~354.0	347.3~347.4
	ID	399.7~400.0	199.6~200.0	199.9~200.2
	THK1	6.39~6.92	6.38~6.55	6.26~6.46
	THK2	8.53~8.66	8.15~8.35	8.31~8.51
Description	Name	10" 900LB	12" 900LB	18" 1500LB
G10 retainer	OD	66.64~66.87	66.56~66.68	88.78~88.96
	ID	36.35~36.68	36.55~36.70	49.28~49.37
	THK	2.98~3.11	3.00~3.09	3.01~3.05

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ZPS washer	OD	66.55~66.60	66.53~66.60	88.50~88.53
	ID	36.41~36.44	36.41~36.43	49.11~49.12
	THK	2.95~3.12	2.91~3.01	2.99~3.03
Mylar sleeve	OD	36.48~36.82	36.50~36.77	49.10~49.30
	ID	35.31~35.94	35.47~35.74	48.27~48.35
	L	157.0~157.2	156.9~157.0	220.4~220.6
G10/316 Gasket	OD	429.9~430.0	493.3~493.5	632.9~633.0
	ID	249.8~250.0	300.0~300.2	450.0~450.3
	THK1	6.52~6.60	6.43~6.64	6.39~6.69
	THK2	8.3~8.44	7.66~8.39	8.40~8.66

Note: OD: Outside diameter

THK1: Thickness of G10/316 gasket

ID: Inside diameter

THK2: Thickness RTJ of G10/316

THK: Thickness

L: Length

➤ **Surveillance with reference to ITP** (Each activity elaborated in detail)

NA

➤ **Results of Inspection** (incl. calibration status of equipment / instruments used for the inspection / testing)

The calibration of the instruments used for the inspection was valid .

The inspection result was acceptable .

No.	BV Scope of Work	Satisfactory	Unsatisfactory	Findings
1	Quantity check	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
2	Marking check at rate 20%	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
3	Visual inspection at rate 20%	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
5	Dimension inspection at rate 205	<input checked="" type="checkbox"/>	<input type="checkbox"/>	

➤ **Problems pending** (Areas of Concern, punch list...)

Nnoe.

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➤ Photos at site



Packed gaskets



Tag on carton



1 set gasket packed in one carton



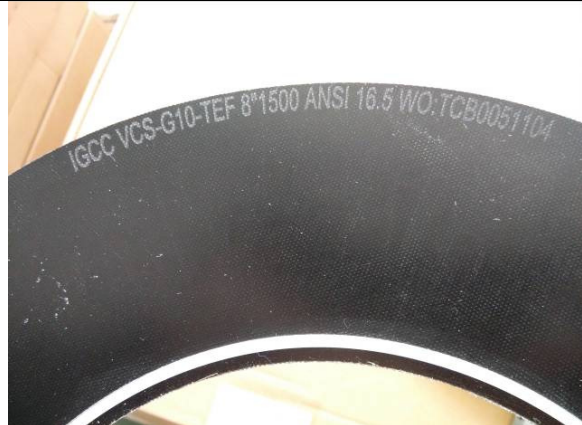
Quantity check

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Marking on G10/316 gasket



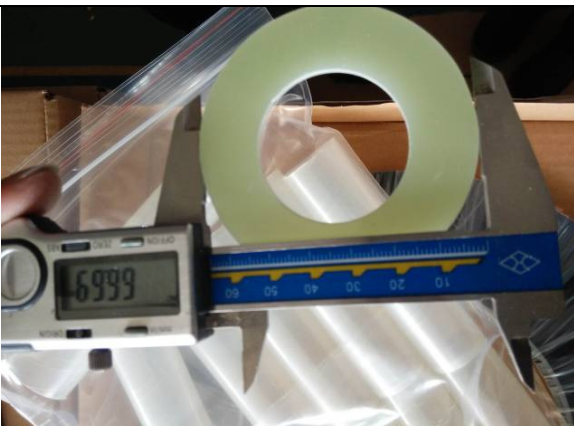
Marking on G10/316 gasket



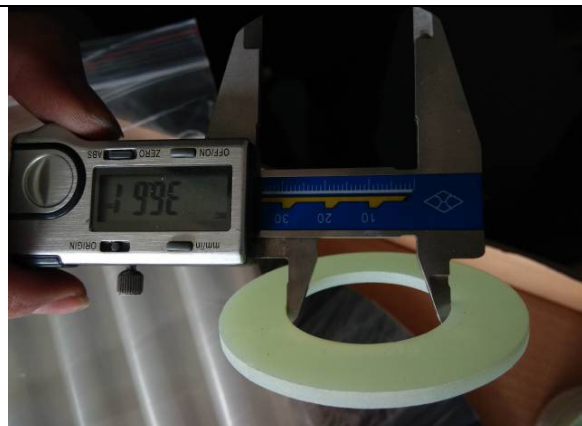
Visual inspection



Visual inspection



OD check for G10 retainer



ID check for G10 retainer

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Thickness check for G10 retainer



OD check for ZCP washer



ID check for ZCP washer



Thickness check for ZCP washer



OD check for mylar sleeve



OD check for mylar sleeve

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Length check for mylar sleeve



OD check for G10/316 gasket



ID check for G10/316 gasket



Thickness check for G10/316 gasket(THK1)



Thickness check for G10/316 gasket(THK2)



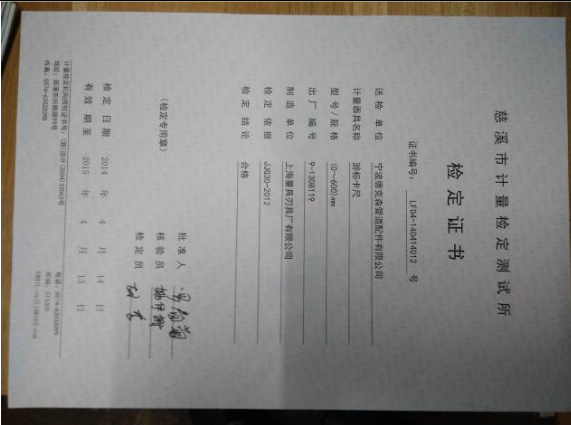
Slight scratch on gasket surface



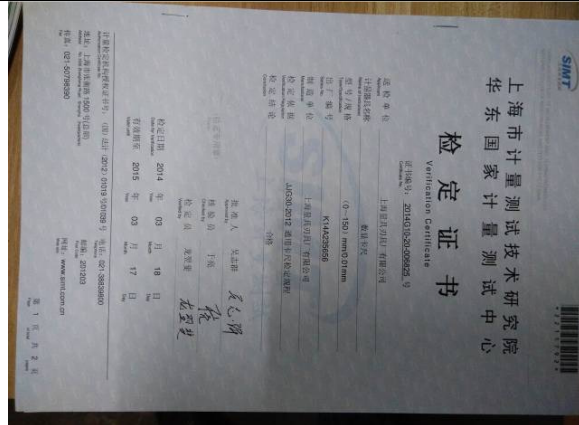
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Calibration certificate review



Calibration certificate review

ANNEXES Yes (Total number of pages: 1 page) No

Inspected by:

Name: Daozhou Zhang

Signature:

Date of issue: 17th ,Dec.,2014

Inspection centre: BV Quality Service

Checked by:

Name: Jacky Zhang

Signature:



Distribution: CLIENT MANUFACTURER

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Annexe 1- Subject inspection list

Item No	Description	QTY (Set)	Remark
1	Gasket,VCS,16''900LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	13	1 set including 40 Pcs retainers; 40 Pcs ZPS washer;20Pcs Mylar sleeves; 1PC G10/316 Gasket
2	Gasket,VCS,8''900LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	30	1 set including 24 Pcs retainers; 24 Pcs ZPS washer;12Pcs Mylar sleeves; 1PC G10/316 Gasket
3	Gasket,VCS,8''1500LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	22	1 set including 24 Pcs retainers; 24 Pcs ZPS washer;12Pcs Mylar sleeves; 1PC G10/316 Gasket
4	Gasket,VCS,10''900LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	22	1 set including 32 Pcs retainers; 32 Pcs ZPS washer;16Pcs Mylar sleeves; 1PC G10/316 Gasket
5	Gasket,VCS,12''900LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	26	1 set including 40 Pcs retainers; 40 Pcs ZPS washer;20Pcs Mylar sleeves; 1PC G10/316 Gasket
6	Gasket,VCS,18''900LB,Type F,SS core,Comprising PTFE,G10 Retainer,Mylar sleeves,G10/ZPS washer for RTJ Flange,ANSI B16.5	12	1 set including 40 Pcs retainers; 40 Pcs ZPS washer;20Pcs Mylar sleeves; 1PC G10/316 Gasket