

LEGENDA		PERCENTAGE ON LOT *		DATE	REV	PRPD	CHKD	APP.D		
H :	HOLD POINT	1= 100%	3=10%							
W :	WITNESS POINT	2= 20%								
R :	RECORD REVIEW	* A LOT CONSIST OF VALVES OF THE SAME MATERIAL ,SAME ND ,SAME CLASS AND SAME CONFIGURAT.			0					
STEP N°	ITEM / CONTROL ACTIVITY	REFERENCE DOCUMENT / PROCEDURE	ACCEPTANCE CRITERIA	VERIFYING DOCUMENT	Orton	SIGN	CUSTOMER	SIGN	COMPANY	SIGN
0	PRE-MANUFACTURING ACTIVITIES									
0.1	CONTRACT REVIEW	INTERNAL ORDER ACK. / P. O requirement	P. O requirement	INTERNAL WORK ORDER	H/1		R/1		-	
0.2	ISSUE ORDER ACKNOWLEDGEMENT	-	P. O requirement	INTERNAL WORK ORDER	H/1		R/1		-	
0.3	PLACEMENT OF SUB-ORDERS	INTERNAL ORDER ACK. / P. O requirement	P. O requirement	SUB-ORDERS	H/1		R/1		-	
0.4	PLACEMENT OF SUB-ORDERS / CASTINGS	INTERNAL ORDER ACK. / P. O requirement	P. O requirement	SUB-ORDERS	H/1		R/1		-	
0.5	DOCUMENT REVIEW	P. O requirement	P. O requirement	INTERNAL WORK ORDER	H/1		R		-	
1	INCOMING MATERIAL									
1.1	CASTING BODY									
1.1.1	CHECK OF VENDOR TEST CERTIFICATE	EN 10204 3.1	ASTM A216 WCB / MATERIAL DATA SHEET A-VL-1-ON / CE ≤ 0.43 / Carbon ≤0.25% / Hardness ≤248 Hv10	MILL CERTIFICATE	R/1		R/1		-	
1.1.2	VISUAL and MARKING CHECK	MSS SP 55	MSS SP 55	CERTIFICATE	H/1		R/1		-	
1.1.3	REPAIR WELDING	NOT PERMITTED	NOT PERMITTED						-	
1.2	CASTING DISC									
1.2.1	CHECK OF VENDOR TEST CERTIFICATE	EN 10204 3.1	ASTM B148 C95800 / MATERIAL DATA SHEET H-VL-1-ON / Pb content ≤ 0,02%	MILL CERTIFICATE	R/1		R/1		-	
1.2.2	VISUAL and MARKING CHECK	MSS SP 55	MSS SP 55	CERTIFICATE	H/1		R/1		-	
1.2.3	REPAIR WELDING	NOT PERMITTED	NOT PERMITTED						-	
1.3	TRIM - SHAFT									
1.3.1	CHECK OF VENDOR TEST CERTIFICATE (CHEMICAL & MECHANICAL PROPERTIES)	EN 10204 3.1	ASTM B865 UNS N05500	MILL CERTIFICATE	R/1		R/1		-	
2	MACHINED COMPONENTS									
2.1	NDT - MT 100 % - BODY, INTERNAL & EXTERNAL SURFACE	D-100381-Q014	ASME VIII, Div. 1, Appendix 7	MT REPORT	H/1		R/1		-	
2.2	NDE - DP 100 % - DISC	D-100381-Q011	ASME VIII, Div. 1, Appendix 7	DP REPORT	H/1		R/1		-	
3	INTERMEDIATE TEST									
3.1	HYDROTEST ON BODY	D-100381-E005, G1-VE-X-0000-H03000030001	D-160362-E005, G1-VE-X-0000-H03000030001 ,G1-TE-Z-0000-SPC0117	HYDROSTATIC TEST REPORT	H/1		W/3		-	
4	FINAL INSPECTION & TESTING									
4.1	HYDROSTATIC & PNEUMATIC SEAT TEST AT AMBIENT TEMPERATURE	D-100381-E005, G1-VE-X-0000-H03000030001	D-160362-E005, G1-VE-X-0000-H03000030001 ,G1-TE-Z-0000-SPC0117	HYDROSTATIC &PNUEMATIC TEST REPORT	H/1		W/3		-	
4.2	FUNCTIONAL CHECK	TEST PROCEDURES D160362-Q-005, G1-VE-X-0000-H03000030001	D-160362-E005, G1-VE-X-0000-H03000030001 ,G1-TE-Z-0000-SPC0117	FUNCTIONAL TEST REPORT / CERT	H/1		W/3		-	
4.3	PAINTING CHECK	D-160362-E-900	D-160362-E-900	PAINTING TEST REPORT	H/1		W/3		-	
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4.4	VISUAL & DIM.CONFORMITY MARKING / TAGGING	APPROVED DRAWINGS	APPROVED DRAWING	CONFORMITY CERTIFICATE	H/1		R/1		-	
4.5	CLEANLISSNESS CHECKS /PACKING & SHIPPING INSP.	DOC D-160362-H-001,G1-PP-DWN-PRCKZ350052	D-100381-H001, G1-PP-DWN-PRCKZ350052	PACKING CONFORMITY CERTIFICATE	H/1		W/3		-	
4.6	ISSUE INSPECTION RELEASE CERTIFICATE	P.ORDER	P.ORDER	CUSTOMER INSPECTION RELEASE CERTIFICATE	H/1		H/1		-	
4.7	REVIEW OF DOCUMENTS	TEST CERTIFICATES	TEST CERTIFICATES	MDR	H/1		H/1		-	

ITP