

# PROJECT SURVEILLANCE PLAN (PSP) - INSPECTION TEST PLAN (ITP)

FLSmidth Contract No.:		PSP-ITP ID:	ITP-SF001	<b>FABRICATIONS (STANDARD)</b>	(MDR) Manufacturer Data Report to Include:		
Equipment:		PSP-ITP Revision No.:	0		Procedures	FLS Checklists <sup>(1)</sup> :	
Customer:					Material Certificates (MTR's)		
Customer P.O.:					Initialed PSP-ITP		
Project Mgr. Approved:					Photos		
Q.A. Dept. Approved:					Reports by Supplier		
Date:							

No.	Activity	Notes / Description of Activity <sup>(2)</sup>	Controlling Specification <sup>(2)</sup>	Acceptance Criteria	Verification Document: FLS Checklist <sup>(1)</sup> , PSP-ITP, Photos, Report by Supplier	Supplier Record (Date & Initials)	FLSmidth			FLS Initials		Customer			Customer Initials	
							W	H	DR	W	H	DR	W	H		DR
							See Cover Page for Legend & Customer Notifications									
(1) PRE MANUFACTURING DOCUMENT REQUIREMENTS																
1.1	Review Welding Procedures	WPS/PQR shall be reviewed and approved by FLS prior to start of fabrication.	FLS Engineering Drawings and Specifications, FLS Specification 1000024422	FLS Engineering Drawings and Specifications, FLS Specification 1000024422				H			N/A		H		N/A	
1.2	Welders Qualification Records	Required list of qualified personnel will be maintained by the supplier. All personnel performing welding operations shall be qualified in accordance with applicable code, records shall be maintained by the supplier and made available for review at any time.			CERTIFICATES AT SUPPLIER			H	DR		N/A		DR		N/A	
1.3	Review Coating Specification	Paint per specification attached to purchase order.	FLS Engineering Drawings and Specifications	FLS Engineering Drawings and Specifications				H			N/A		H		N/A	
1.4	Non Destructive Examination (NDE) Procedures	NDE procedures shall be reviewed and approved by FLS prior to start of fabrication.	FLS Engineering Drawings and Specifications, FLS Specification 1000024422	FLS Engineering Drawings and Specifications, FLS Specification 1000024422				H			N/A		H		N/A	
1.5	NDE Personnel Qualification Records	Required list of qualified NDE personnel will be maintained by the supplier. All personnel performing NDE operations shall be qualified in accordance with ASNT SNT-TC-1A, records shall be maintained by the supplier and made available for review at any time.	ASNT SNT-TC-1A	ASNT SNT-TC-1A	CERTIFICATES AT SUPPLIER				DR		N/A		DR		N/A	

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							W	H	DR	W	H	DR	W	H	DR	
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(2) MANUFACTURING																
2.1	Material Certifications, Type & Traceability	Verify all material to be to the proper ASTM specification. Verify that material to be used is per FLS engineering drawings and PO. All MTR's shall be maintained by the supplier and provided as part of the final documents to FLS. MTR's to include the heat number, drawing / item number, project number and PO number.	FLS Engineering Drawings and Specifications	FLS Engineering Drawings and Specifications	PHOTOS AND REPORTS				DR	N/A			DR	N/A		
2.2	Verification of Welding through NDE (VT)	Verify welding with NDE using approved procedures and FLS drawings and specifications.	FLS Engineering Drawings and Specifications, FLS Specification 1000024422	FLS Engineering Drawings and Specifications, FLS Specification 1000024422			W		DR	N/A		W		DR	N/A	
2.3	Verification of Final Dimensions	Verify that all dimensions are in accordance with FLS drawings and specifications.	FLS Engineering Drawings and Specifications, FLS Specification 1000024422	FLS Engineering Drawings and Specifications, FLS Specification 1000024422	REPORT		W		DR	N/A		W		DR	N/A	
2.4	Prior to Painting: Surface Preparation	Surface preparation shall be per approved procedure and FLS requirements, and applicable FLS specification.	FLS Engineering Drawings and Specifications	FLS Engineering Drawings and Specifications	REPORT		W			N/A		W			N/A	
2.5	Coating Inspection	All finished coatings shall be visually inspected for appearance, sag, or other visible defects. All coating shall be inspected to FLSmidth requirements. Dry film thickness to be recorded between coatings.	FLS Engineering Drawings and Specifications	FLS Engineering Drawings and Specifications			W		DR	N/A		W		DR	N/A	
2.6	Final Inspection	On site check that all finished fabrications shall have met FLS requirements, including dimensional, welding, and painting when applicable.	FLS Engineering Drawings and Specifications	FLS Engineering Drawings and Specifications	SUPPLIER ITP		W			N/A		W			N/A	

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							W	H	DR	W	H	DR	W	H	
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<b>(3) QUALITY RELEASE</b>															
3.1	Packaging Requirements	Photos will be provided of the following for all equipment: nameplate/serialization identification, shipping labels, applicable equipment protection(e.g., corrosion preventative coatings on machined surfaces, wood protection on flanges, shrink wrap, etc...), and of the equipment on trailers or in shipping containers. Photos of packaging identification on all items shipping separately from the main assemblies(e.g., nuts, bolts, screws, gaskets, and other hardware) shall also be supplied.	Purchase Order	Purchase Order, FLS Engineering Drawings	PHOTOS AND REPORTS					DR	N/A				
3.2	Quality Release	All quality documentation complete and submitted with photos to QA department.	Purchase Order	Purchase Order, FLS Engineering Drawings and Specifications, FLS Specification 1000024423	ALL VERIFICATION DOCUMENTS PER THIS DOCUMENT (MDR LIST)			H		DR	N/A		H		DR
<b>Notes:</b> 1: FLSmidth at its discretion has the right to accept supplier Quality forms for any inspection activities provided that they are either an equivalent or meet a higher standard than what is outlined in standard FLSmidth's Checklists or Forms.															