


 Interim
 Final

INSPECTION REPORT N°

MCWANE / CBE / FCRI / Endurance Test / IR / 001

BV Job nr: IND.C.4.13.0381

PROJECT: Endurance test witness for RSGV DN 300, PN16	Ref: FCRI Report No: FCRI/ET/266/2014-15
BV Client: M/s McWANE Services Private Ltd., Coimbatore	P/o nr: Inspection Call ref No: E-Mail dated 05.08.13 from McWANE to BV.
Manufacturer: M/s McWANE Services Private Ltd., Coimbatore	P/o nr: Nil.
Inspection requested by: M/s McWANE Services Private Ltd., Coimbatore	

SUPPLY / SUBJECT OF INSPECTION	ITEM / TAG Nr	QTY
Resilient Seated Gate Valve (Witness of Endurance Test) Brand: Kennedy Valve	Valve Size: DN 300 Pr Rating: PN 16 Model No: Series-31 Serial No: A14F02-001	1 No.

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
Procedure	MS-TP-002	02	McWANE	10.02.14
Standard Reference	EN 1074 – Part 1	Amend No: 15230	Bsi	23.12.04
Standard Reference	EN 1074 – Part-2	Amend No: 15231	Bsi	23.12.04
Scope	Witness of Endurance test as per Clause 4.10 of Procedure MS-TP-002 at FCRI, Palakkad	02	McWANE	10.02.14

INSPECTIONS : <u>Inspection place & Date or Period:</u> M/s FCRI, Palakkad 25.06.14. <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 type="checkbox"/> Visual examination, checks <input checked="" type="checkbox"/> Witnessing tests <input type="checkbox"/> Manufacturing progress status <input type="checkbox"/> Vendor assessment <input type="checkbox"/> Final inspection <input type="checkbox"/> Packing (for details see continuation sheet) <u>Stamping :</u> <input checked="" type="checkbox"/> No <input type="checkbox"/> <input type="checkbox"/>	Results of inspection : <input checked="" type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory <u>Non Conformities Reports (NCR):</u> o NCR's issued during reported period :No. o List of outstanding NCR's : Nil. <u>Main Conclusions & Remarks:</u> (for details see continuation sheet) o The Endurance test witness as per above referred procedures & EN Standard and found satisfactory. For more details please refer Sheet 02 of 02. <u>Next visit scheduled:</u> Nil. <u>PO Status:</u> Complete.
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(continued)

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1. Introduction

- The under signed surveyor had visited M/s FCRI, Palakkad on 25.06.14 for Endurance test witness as per above referred procedures & EN Standard.

2. Applicable Documents & Status of Approval

- As stated above in tabular column in Sheet 01 of 02.

3. Details of inspection activities carried out with respect to scope of work

1. Engineering procedure for Endurance test of RSG valve – MS-TP-002 / Rev:"02" – Reviewed.
2. Witnessed Endurance Test of Resilient Seated Gate Valve of size DN300, PN 16 (Valve sl no: A14F02-001 / Valve Body Heat No: A113K314) with Rotork Actuator (Type: K600 F14A / 2.2 KW / 48 RPM / Max Torque: 610 Nm) as per above said procedure at FCRI, Palakkad for 2500 cycles at rated pressure 16 bar and operations found satisfactory.
3. Witnessed Shell Leak test after completion of 2500 cycle at 25 bar for holding time of 10 Minutes and Found No Leakage and No Pressure drop.
4. Witnessed High Pressure Seat Leak test after completion of 2500 cycle at 18 bar for holding time of 10 Minutes and Found No Leakage and No Pressure drop.
5. Witnessed Low Pressure Seat Leak test after completion of 2500 cycle at 0.5 bar for holding time of 10 Minutes and Found No Leakage and No Pressure drop.
6. Reviewed Endurance test report issued by FCRI, Found satisfactory.
7. Reviewed dimension report of Stem, Seal, Wedge & Bush (before and after 2500 cycle completion) and its report endorsed.
8. Visual inspection carried after 2500 cycle completion and found satisfactory except rubbing mark on the sealing side of rubber wedge.
9. Gauges and instruments used for testing performance of above said valve found within calibration due date.

4. Results of Inspection

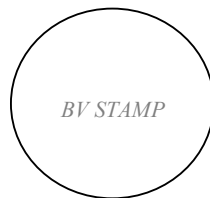
The Subjected Valve Endurance test witnessed as per above referred procedure and found satisfactory.

5. **Problems pending Nil.**

ANNEXES Yes (Total number of pages:.) No

Inspected by:

Name:... N.Balakrishnan



Checked by:

Name:... N.Balakrishnan



Date of issue: 18.07.2014

Inspection centre: BV, Coimbatore

Signature:

Distribution: Mcwane BV, Chennai BV, Coimbatore