

P.O. NO. :	 	Q.C. PLAN NO. :
REF. No.:		Rev. No. : 1
Form Code : FO-QCM-001	Q.C. Plan For Spiral Wound Gaskets	Rev. Date : 1400.08.20

CUSTOMER NAME :

Abbreviations :

T.P.I. : Third party inspector

API : American Petroleum Institute

ASME : American Society of Mechanical Engineers

P.A.I. : Purchaser's Authorized Inspector

AM : Aforementioned

Gasket Construction Type :

1- Inspection of the Inner Ring Production Processes :

1-1 : Inspection after Cutting	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

1-2 : Inspection after Angulation	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

1-3:Dimensional Check	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By calliper	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

1-4:Hardness test	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By Hardness Tester	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASME B16.20 (API 601) ☐
PLD 106 ☐
Others ☐

ASME B16.47 SERIES A ☐
BS 3381 ☐

ASME B16.47 SERIES B ☐
JIS ☐

2 - Inspection of the Centring Ring Production Processes :

2-1 : Inspection Cutting	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

2-2 :Inspection Grooving	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

2-3:Dimensional Check	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By calliper	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

2-4:Hardness test	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By Hardness Tester	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASME B16.20 (API 601) ☐ ASME B16.47 SERIES A ☐ ASME B16.47 SERIES B ☐ PLD 106 ☐ BS 3381 ☐ JIS ☐ Others ☐							
---	--	--	--	--	--	--	--

3 - Inspection of the Sealing Element Production Processes :

3-1:Dimensional Check	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By calliper	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

3-2 :Spot Welding check	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASME B16.20 (API 601) ☐ ASME B16.47 SERIES A ☐ ASME B16.47 SERIES B ☐ PLD 106 ☐ BS 3381 ☐ JIS ☐ Others ☐							
---	--	--	--	--	--	--	--

4- Inspection of the Centring Ring Marking Process :

4-1 : Random Check of the Marked Rings	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASME B16.20 (API 601) ☐ ASME B16.47 SERIES A ☐ ASME B16.47 SERIES B ☐ PLD 106 ☐ BS 3381 ☐ JIS ☐ Others ☐							
---	--	--	--	--	--	--	--

5 - Coating Inspection :

5-1 : Inspection of the Coating Thickness	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By elkometer ☐ As attached certificate ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

5-2 : Inspection of Coating Quality and Solidarity :	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASTM B695 ☐

6 - Montaging Process Inspection :

6-1 : Random Inspection of Montaged Gaskets	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	
6-2 : Type test for montaged gasket	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	By Type Test's Equipment	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

INSPECTION CRITERIA : ASME B16.20 (API 601) ☐ ASME B16.47 SERIES A ☐ ASME B16.47 SERIES B ☐
 PLD 106 ☐ BS 3381 ☐ JIS ☐
 Others ☐

7- Inspection of the Packing Process :

7-1 :To Check the Packed items According to P.O. Specifications and Packing List :	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

7-2 : Confirmation of the Gasket Suitable Layout in the Box :	Inspec. Type	Q.C. Inspec. Result	T.P. Inspec. Result	Remarks	Q.C. Reinspec. Result	T.P. Reinspec. Result	Remarks
	Visual ☐ Instrumental ☐	Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐		Acc. ☐ Rej. ☐	Acc. ☐ Rej. ☐	

Inspection by P.A.I. / T.P.I. :

a) Is not inspected ☐

b) Is inspected dated and A/M results are confirmed by two parties . ☐

RAMAN CO. Q.C. Dpartment Final Result:

1-Ordered gaskets have passed successfully all the Related Q.C. steps and ready for final inspection or shipment.

2-The attached certificates for raw materials are confirmed by Q.C. Dept.

P.A.I. / T.P.I. :

NAME :

SIGNATURE :

DATE :

Q.C. MANAGER :

NAME :

SIGNATURE :

DATE :