



DEHDASHT PETROCHEMICAL INDUSTRY COMPANY
DEHDASHT HIGH DENSITY POLYETHYLENE PROJECT



Contract No.: DPIC/98-12	DOCUMENT TITLE: Inspection & Test Plan (ITP) for Refrigeration Unit (PK-6101)	POI: IFA	Rev. D0
	DOCUM There is no test & inspection for main and auxiliary motor. As per MR there is a list of test & inspection for these items. So manufacturer is responsible for.	Sheet 1 of 13	

Review of following ITP is preliminary. After submission relevant data sheets and drawings for different equipment of refrigeration package, we will review it accordingly.

Inspection & Test Plan (ITP) for Refrigeration Unit (PK-6101)

PURCHASER'S COMMENT/APPROVAL STATUS				Purchaser: NARGAN		
1.	AP: Approved (Released for Manufacturing)	Requisition No.: DPIC98-12-001-000-ME-MR- 4150-0001-D1 Item No. (Tag No.): PK-6101 Vendor Doc. No.: DPIC9812-000-VD-1002-ME-ITP-0008				
2.	AN: Approved With Minor Comments (Fabrication may Proceed)					
✓ 3.	NF: Approved With Comments (Fabrication not Proceed)					
4.	RJ: Rejected					
5.	NR: Not be Returned					
Date	17-11-2021	Signature:				
DO	16-Nov-2021	Issue for Approval	M. R	M. M	A.V	
REV.	DATE ISSUE	Purpose of Issue	PREPARED	CHECKED	APPROVED	



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TABULATION OF REVISED PAGES

Page	Rev-D0	Rev-D1	Rev-D2	Rev-D3	Rev-D4	Page	Rev-D0	Rev-D1	Rev-D2	Rev-D3	Rev-D4	Page	Rev-D0	Rev-D1	Rev-D2	Rev-D3	Rev-D4
1	x					25											
2	x					26											
3	x					27											
4	x					28											
5	x					29											
6	x					30											
7	x					31											
8	x					32											
9	x					33											
10	x					34											
11	x					35											
12	x					36											
13	x																
14																	
15																	
16																	
17																	
18																	
19																	
20																	
21						45											
22						46											
23						47											
24						48											

Vendor shall submit following ITP's for refrigeration package:

- MV electric motor
- Lube oil system
- Machine Monitoring system
- Spare parts



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SIGN: ASME VIII DIV. 1	ITEM NO(S).: DEJDASHT PETROCHEMICAL Refrigeration Package	MANUFACTURER SERIAL NUMBER:
1	Scope	This Inspection and Test plan covers all activities that will be carried out in design and fabrication of equipment.
2	LEGEND OF THE TECHNICAL SURVEILLANCE	1) (H)= INSPECTION NOTIFICATION will be issued by manufacturer and inspection shall be performed at presence of notified party. Next fabrication stage is subject to acceptance of inspection. Vendor must notify parties activity) of the defecated inspection activity at least fifteen (15) days in advance.
		2) (SW)=10% OF TYPE/LOT WITNESSED. Action performed only on a certain number of pieces.
		3) (W)=WITNESSING. The Supplier shall inform the NOTIFIED PARTY of the date of the activity and the NOTIFIED PARTY reserves the right to witness the test. If the test is conducted at the notified date, the Supplier may proceed with the subsequent phase, even if the NOTIFIED did not witness the test.
		4) (R/A)=REVIEW OF TECHNICAL DOCUMENTS BEFORE COMMENCEMENT OF CONSTRUCTION. The technical documents shall be reviewed and approved before the commencement of construction
		5) (R)=REVIEW OF DOCUMENTS. Materials certificates, statement of compliance and reports of inspection and tests conducted by the Supplier shall be revised to assess their conformance with the requirements specified in the Code and Standards, Specifications and/or Purchase Order.
		6) (M) = KASRAVAND(Manufacturer) Inspection
3	Abbreviations	O = Owner (Dehdasht PC/PIDMCO) N = NARGAN V = Vendor SV = Sub Vendor TPI = Third Party Inspection on behalf of owner

Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY				REMARKS	
					SV	V	N	TPI		O/MC
A PROJECT PREPARATION										
A1	VERIFY CUSTOMER SPECIFICATION	ASME VIII DIV 1 (U-STAMP NOT REQUIRED)(Welding Standard) DETAILS AS PER QUALITY PLAN			Type	H		H		
					Date					
					Sign					
A2	PRE INSPECTION MEETING		MOM, ITP		Type					
					Date					
					Sign					
A3	BASIC DESIGN DRAFT DOCUMENT LIST P&ID , LAY-OUT				Type					
					Date					
					Sign					
A4	KICK-OFF MEETING CUSTOMER DETAILED DESIGN				Type	M		M		
					Date					
					Sign					



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All activities for vendor and sub-vendor shall be considered as a Hold Point.

Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS	
					SV	V	N	TPI	O/MC		
					Date						
B MATERIAL SELECTION / SUBCONTRACTOR ORDERING											
B0	GENERAL	ALL ITEMS SUITABLE FOR AMBIENT TEMPERATURE / OUTDOOR ALL ITEMS TO BE CONFORM ZONE 2 GROUP IIB T3	MATERIAL SUPPLY FABRICATION SCHEDULE QA / QC		Type	M	M				
					Date						
					Sign						
B1	COMPRESSOR – SUBCONTRACTED MAYEKAWA FACTORY JAPAN	DETAILS AS PER COMPRESSOR QUALITY PLAN MANUFACTURER STANDARD	TEST REPORT: -Noise test. - Vibration test - Performance test - Running test - Hydro test	MATERIAL CERTIFICATES	Type	See ITP of compressor					
					Date						
					Sign						
B2	MAIN MOTOR - SUBCONTRACTED	IEC with protection class as per Exd Hazardous Area Certificates IECex / Exd Zone 2 IIB T3	TEST REPORT - Unwitnessed routine test report		Type	See ITP of MV motor					
					Date						
					Sign						
B3	OIL PUMP MAYEKAWA FACTORY	MYCOM STANDARD	TEST REPORT incl; Hydro test result and performance test result	MATERIAL CERTIFICATES	Type	M	R	R	R		
					Date						
					Sign						
B4	PUMP MOTOR	MANUFACTURER STANDARD with protection class as per Exn HAZARDOUS AREA CERTIFICATE IECex / Exn Zone 2 IIB T3	TEST REPORT (Manuf. Std) - Unwitnessed routine test report		Type	M	R	R	R		
					Date						
					Sign						
B5	MAIN COUPLING	MYCOM STANDARD (Flexible disc type coupling)	SUITABLE FOR HAZARDOUS AREA	Material certificate, visual and dimensional inspection report	Type	M	R	R	R		
					Date						
					Sign						



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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS
					SV	V	N	TPI	O/MC	
B6	PRESSURE VESSELS Duplex Oil filter (with element)Oil separator (with coalescer)									
B6-1	Material Inspection & Certificate review (Pressure Part)	App DWG Project Documents, Material Standards	Material Certificate / Inspection report	Approved drawings. EN 10204-3.1 Project Documents, Material Standards	H	R	W	W	R	
B6-2	Visual and dimensional check of fabricated heads	App. DWG	Head Dim. Report	Drawing Welding Map	H	R	W	W	R	
B6-3	Fit-up and welding of shells and heads	WPS/PQR, WELD MAP	Inspection Report	ASME SEC VIII,IX, Project job specification	H	R	SW	SW	R	
B6-4	Marking of nozzles on heads prior to cutting	App. DWG	Inspection Report	Drawing	H	R	W		R	
B6-5	Fit-up and welding of nozzles to heads	App. DWG	Inspection Report	Drawing	H	R	SW	SW	R	
B6-6	NDT	Procedure + NDT Map	Inspection Report	Procedure + NDT Map	H	R	RA	R	R	
B6-7	Final Visual & Dimensional Check	App DWG/ ASME Sec VIII,IX	Inspection Report	App DWG/ ASME Sec VIII,IX	H	R	W	W	R	

PWHT (if any)	H	H	SW	SW	R
PMI test	H	H	W	W	R



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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS
					SV	V	N	TPI	O/MC	
B6-8	Hydrostatic and Leak Test	Hydrostatic test procedure	Inspection Report	Hydrostatic test procedure	H	R	H	H	R	
B6-9	Final Painting Inspection	App. Painting Procedure Painting project specification	Inspection Report	App. Painting Procedure Painting project specification	H	R	H	H	R	
B7	HEAT EXCHANGERS CONDENSOR ECONOMIZER OIL COOLER EVAPORATOR									
B7-1	Material Inspection & Certificate review (Pressure Part)	App DWG Project Documents, Material Standards	Material Certificate / Inspection report	Approved drawings. EN 10204-3.1 Project Documents, Material Standards	H	R	W	W	R	
B7-2	Visual and dimensional check of fabricated heads	App. DWG	Head Dim. Report	Drawing Welding Map	H	R	W	W	R	
B7-3	Fit-up and welding of shells and heads	WPS/PQR, WELD MAP	Inspection Report	ASME SEC VIII,IX, Project job specification	H	R	SW	SW	R	
B7-4	Marking of nozzles on heads prior to cutting	App. DWG	Inspection Report	Drawing	H	R	W		R	
B7-5	Fit-up and welding of nozzles to heads	App. DWG	Inspection Report	Drawing	H	R	SW	SW	R	
B7-6	NDT	Procedure + NDT Map	Inspection Report	Procedure + NDT Map	H	R	RA	R	R	

PWHT (if any)	H	H	SW	SW	R
PMI test	H	H	W	W	R



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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY						REMARKS
					SV	V	N	TPI	O/MC		
B7-7	Final Visual & Dimensional Check	App DWG/ ASME Sec VIII,IX	Inspection Report	App DWG/ ASME Sec VIII,IX	Type	H	R	W	W	R	
B7-8	Hydrostatic and Leak Test	Hydrostatic test procedure	Inspection Report	Hydrostatic test procedure	Type	H	R	H	H	R	
B7-9	Final Painting Inspection	App. Painting Procedure Painting project specification	Inspection Report	App. Painting Procedure Painting project specification	Type	H	R	H	H	R	
B8	BASE FRAME		PT -10 % OF MAJOR STRUCTURAL CONNECTIONS 100 % PT LIFTING LUG WELDS VT and DT	ACC. DATASHEET/ DRAWING SKID CONNECTION POINTS ANCHOR BOLT POSITIONS INSPECTION /CERTIFICATE 2.2 certificate → AWS D1.1	Type	M	R	W	SW	R	
B9	VALVES		MATERIAL CERTIFICATES 3.1 FOR MAJOR PARTS MANUFACTURER INSPECTION AND TEST RECORD NDE REPORT HYDROSTATIC REPORT VT and DT	ACC. DATASHEET/ DRAWING INSPECTION /CERTIFICATE	Type	M	R	SW	SW	R	
B10	PIPING		1. Carbon oil and refrigerant piping 10%. 2. SS Oil and refrigerant piping 10%. 3. Instrument air header 10%. Amount will be based on total amount of welded inches. VT and DT and welding visual check and PMI to be added. Witnessing of Pressure test in presence of inspectors to be finalized during PIM.	Material certificates	Type	M	R	W		R	

Extent of examination will be finalized during PIM.



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Item No.	Inspection Details	Requirements / Specifications / Codes	Verifying Document	Acceptance Criteria		INSPECTION ACTIVITY					REMARKS
						SV	V	N	TPI	O/MC	
B11	Redundant and Fault tolerant PLC modules for power supply, CPU, I/O cards and communication modules shall be configured with 2 (Two) separated rack (Master/Slave) and with Hot-Standby configuration.	IEC 61131-2	MATERIAL CERTIFICATES 3.1 SET POINT CERTIFICATE CALCULATIONS TEST REPORT	Material certificates	Type	M	R	SW	SW	R	
B12			MATERIAL CERTIFICATES 3.1	Material certificates	Type	M	R	SW	SW	R	
B13	INSTRUMENTATION	MANUFACTURER STANDARD (Pressure and temperature gauges are provided with 2.2 material certificates)	MATERIAL CERTIFICATES 3.1 (Manifolds are provided with 3.1 Material certificates) DIMENSIONAL AND CONSTRUCTION DWG HAZARDOUS AREA CERTIFICATION CALIBRATION REPORT (3.1 material certificates). 3 point calibration		Type	M	R	W		R	
B14	PLC	MANUFACTURER STANDARD: 1. Software Redundancy 2. Redundancy required for CPU, power supply, communication card 3. Solenoid and On/Off valves will be executed in Exd. 4. Approved project documents	DIMENSIONAL AND CONSTRUCTION DWG <u>SAFE AREA</u>		Type	M	R	W		R	

shall be as Before order TCLs

is not correct BOM, Panel DWG, wiring DWG, ... issued by vendor

to be clarified This is reference of PLC ITP

Local Panel shall be mentioned too



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					SV	V	N	TPI	O/MC		
B15	POWER CONTROL	Approved Project Documents	To be specified.	MANUFACTURING STANDARD	Type	M	R	W		R	
B16	ELECTRICAL ITEMS	Approved Project Documents	HAZARDOUS AREA CERTIFICATE (Exd) Zone 2, IIB T3		Type	M	R	W		R	
C INSPECTION DOCUMENTS, PIPING											
C1	WELDING DOCUMENTS (WPS/PQR/WELDMAP)	ASME VIII Div 1, ASME IX	To be checked whether ASME B31.3 is applicable or not.		Type	R/A	R	R	R	R	
C2	WELDER'S QUALIFICATION	ASME IX	Report		Type	R/A	R	R	R	R	
C3	NDE PROCEDURES (UT/RT/MT/PT/HT)	ASME IX 1. Carbon oil and refrigerant piping 10%. 2. SS Oil and refrigerant piping 10%. 3. Instrument air header 10%. Amount will be based on total amount of welded inches.	NDT Map		Type	R/A	R/A	R/A	R	R	
C4	NDT OPERATORS	ASME V	Certificates		Type	R/A	R	R	R	R	



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To be checked whether ASME B31.3 is applicable or not.

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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria		INSPECTION ACTIVITY					REMARKS	
						SV	V	N	TPI	O/MC		
C5	Hydrostatic test procedure	ASME VIII DIV. 1	Report	To be completed by vendor.	Type	R	R	R	R	R		
C6	SURFACE PREPARATION & PAINTING COATING PROCEDURE	OEM STANDARD / SUPPLIER PROCEDURES	Report	To be completed by vendor.	Type	R	R	R	R	R		
D MATERIALS												
D1	INCOMING GOODS INSPECTION COMPONENTS	INSPECTION AND TECHNICAL SPECIFICATIONS	II part A and C		Type	M	R	R	R	R		
D2	VISUAL EXAMINATION AND DIMENSIONAL CHECK OF MATERIALS THICKNESS VERIFICATION	ASME II SA20 / ASME VIII DIV. 1	REPORT OF DIMENSIONAL INSPECTION REPORT	DIMENSIONS SURFACE CONDITION	Type	M	R	W		R		
D3	MATERIAL CERTIFICATION AND MARKING	ACC. TO PROJECT REQUIREMENTS (REFER TO PROJECT PACKAGE DATASHEET)	MATERIAL MAP	3.1.CERTIFICATE (For pressurized parts) 2.2 CERTIFICATE (for Non-pressurized parts)	Type	R	R	R	R	R		
D4	WELDING CONSUMABLES	MANUFACTURER STANDARD	3.1 MATERIAL CERTIFICATE	ASME Sec. II, part C	Type	R	M	W		R		
D5	NON PRESSURE RETAINING PARTS	ASMEVIII DIV1 (U-STAMP NOT REQUIRED)	2.2 MATERIAL CERTIFICATE (No PMI requirement for Valves/internals and equipment)	MANUFACTURING STANDARD	Type	M	R	R	R	R		
D6	BOLTING MATERIAL	As per relevant drawings	3.1 MATERIAL CERTIFICATE	Certificate	Type	M	R	W		R		



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Does it mean assembly activities in Kasravand shop?

Item No.	Inspection Description	References / Specifications / Codes	Inspection Point	Acceptance Criteria	Material traceability record	INSPECTION ACTIVITY					REMARKS		
						SV	V	N	TPI	O/MC			
E INSPECTION & TESTING DURING FABRICATION													
E1	ASSEMBLY START	INTERNAL PRODUCTION SCHEDULE / INSPECTION SCHEDULE	PT -10 % OF MAJOR STRUCTURAL			Type	M					R	
E2	TRANSFER OF MATERIAL, IDENTIFICATION, MARKING & TRACEABILITY		WELDING AND MATERIAL TRACEABILITY LISTS		Material traceability record	Type	M	R	R	R		R	
E3	PIPING		WPS/PQR NDE REPORT See line seq. No C3	Piping design conform to ANSI B31.3		Type	M	R	R	R		R	
E4	PNEUMATIC TEST PROCEDURE TO UNIT	NDE FOR PIPING SECTIONS ASME B31.3 DISMOUNTING OF SAFETY VALVES PRIOR START OF PNEUMATIC TEST	PNEUMATIC TEST PROCEDURE PNEUMATIC TEST REPORT	PNEUMATIC TESTING ON COMPLETE UNIT 1.1 X DESIGN PRESSURE FOR 30 MIN.		Type	M	W	W	W		R	Timer period of PMI will be informed. No specific dates are consider to be informed in advance by Vendor.
E5	MOUNTING / POSITIONING VESSELS	Vendor STANDARD				Type	M					R	
E6	MOUNTING / POSITIONING COMPRESSOR	Vendor STANDARD				Type	M					R	

With refer to part G, the reason of submission of part F (mostly assembling stages) is not clear.



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							SV	V	N	TPI	O/MC		
E7	MOUNTING TUBING AND INSTRUMENTATION	Vendor STANDARD				Type	M					R	
E8	PRE-ALIGNMENT MOTOR	Vendor STANDARD				Type	M					R	
E9	OIL FLUSHING	Vendor STANDARD oil flushing instruction	NO VISUAL SCALE 2 H RUNNING OIL FLUSHING REPORT OFR-72522	NO VISUAL SCALE 2 H RUNNING		Type	M	R	R	R		R	
F INSPECTION													
F1	DIMENSIONAL INSPECTION OF SKID CONNECTION POINTS	Vendor STANDARD	SKID CONNECTION POINTS – ANCHOR BOLT POSITIONS	WITHIN TOLERANCE REPORT / AS BUILT DRAWING		Type	M	R	W			R	
F2	PARTS AND COMPONENT INSPECTION	Vendor STANDARD	P&ID COMPONENT (ORDER) LIST			Type	M	R	W			R	
F3	SYSTEM PRESSURE TEST MINIMUM LEAK TEST AT OPERATING PRESSURE	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) (Welding Standard) DETAILS AS PER QUALITY PLAN	PRESS REPORT ME-F-7.6.0-01-SO72522- Leak test report	MANUFACTURING STANDARD		Type	M	W	W	W		R	
F4	PMI TEST (WELDS)	According to weld-NDT Map (If applicable)	Report	ASME Sec. II, part A and C		Type	-	S W	SW	SW		R	
F5	PAINTING	OEM STANDARD/SUPPLIER_(Painting Standard) PAINT SPECIFICATION	THICKNESS VISUAL INSPECTION and measurement via instrument. PAINT INSPECTION REPORT	ACC SPECIFICATION		Type	M	W	W	W		R	
F6	ELECTRICAL WIRING	WIRING CHECK				Type	M	W	W	W		R	
F7	INSPECTION OF JUCTION BOX, LOCAL PANEL AND PLC	FACTORY ACCEPTANCE TEST 1.VISUAL INSPECTION JUNCTION BOX, LOCAL PANEL AND PLC 2. CONTINUITY, POWER UP & WET LOOP CHECK 3. FUNCTION TEST (REDUNDANCY, LOGIC)	TEST REPORT FAT TEST PROCEDURE	LOGIC DIAGRAM CONTROL NARRATIVE DRAWINGS, DATA SHEETS		Type	M	H	H	H		R	
F9	FINAL INSPECTION	Vendor STANDARD	NAME PLATES CONFIRMATION	RELEASE NOTE		Type	M	H	H	H		R	



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						SV	V	N	TPI	O/MC		
G SHIPMENT AND LOADING												
G1	PACKING AND MARKING PREPARATION FOR SHIPMENT DETAILED PACKING LIST AND LOOSE DELIVERY LIST	Packing Procedure	PACKING INSPECTION VISUAL INSPECTION COMPLETENESS CHECK	PACKING LIST	Type	M	R	R	R	R		
G2	Vendor data book	Final data book, ITP, etc.	A COMPLETE PACKAGE OF INSPECTION AND TEST RECORD/CERTIFICATE MANUFACTURED RECORD	VDB index list	Type	M	R/A	R/A	R	R		

Inspection of preservation check	H	H	W	W	R
Manufacturer compliance certificate	H	R	R	-	R
Issue of shipping release note	R	R	R	R	H