



TTI Inspection Services Co., Ltd.

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INSPECTION REPORT

REPORT NO.	CLIENT P/O NO.	DATE OF REPORT	TOTAL PAGES
TTI20170724-*****	PO2424-12-15	24 th July. 2017	7

CLIENT	*****	VENDOR	*****
INSPECTOR	Bill	PLACE OF INSPECTION	*****
DATE OF VISIT	22 th ~24 th July. 2017	TYPE OF INSPECTION	1- 10%Visual, 1%Marking and 10%Dimension check.
VALVE TYPE	Flanges		
ORDER QTY	4048PCS		

INSPECTION AND FINDINGS

1. Checking Results:

Check list as follow:

key	Qty	Description	check qty	Result and Findings
41	40	16"WNRF STD 150# ANSI B16.5	4	OK
42	30	18"WNRF STD 150# ANSI B16.5	3	OK
45	25	1/2"SWRF STD 150# ANSI B16.5	3	OK
46	150	3/4" SORF 300# ANSI B16.5	10	OK
52	40	12"SORF 300# ANSI B16.5	4	OK
54	10	20"SORF 300# ANSI B16.5	1	OK
58	2	5"WNRF 300# S40 ANSI B16.5	1	OK
62	10	24"WNRF 300# S40 ANSI B16.5	1	OK
63	30	3"WNRF 300# S80 ANSI B16.5	3	OK
67	20	3"WNRF 600# S40 ANSI B16.5	2	OK
69	20	12"WNRF 600# S40 ANSI B16.5	2	OK
70	40	8"SORF 600# ANSI B16.5	4	OK
71	14	1/2" WNRTJ 600# S40 ANSI B16.5	2	OK
72	20	6" WNRTJ 600# S40 ANSI B16.5	2	OK
73	20	8" WNRTJ 600# S40 ANSI B16.5	2	OK
74	20	10" WNRTJ 600# S40 ANSI B16.5	2	OK



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75	20	12" WNRTJ 600# S40 ANSI B16.5	2	OK
76	22	8"WNRTJ 300# S80 ANSI B16.5	3	OK
77	22	8"WNRTJ 600# S80 ANSI B16.5	3	OK
80	40	6" BLRF 150# ANSI B16.5	4	OK
91	20	1"BLRTJ 600# ANSI B16.5	2	OK
92	18	BLRTJ 600# ANSI B16.5	2	OK
93	20	1-1/2"ORIFICE SORF 300# B16.36	2	OK
94	12	2"ORIFICE SORF 300# B16.36	2	OK
96	12	6"ORIFICE SORF 300# B16.36	2	1,NPT thread can't pass through 2,Marking required"B16.36" actual marked"B16.5"
97	12	8"ORIFICE SORF 300# B16.36	2	1,NPT thread can't pass through 2, 1PCS NPT hole is too deep, need replace a new one 3. Marking required"B16.36" actual marked"B16.5"
100	6	6"ORIFICE WNRF 300# S40 B16.36		NPT thread can't pass through
101	8	8"ORIFICE WNRF 300# S40 B16.36		NPT thread can't pass through
102	6	1-1/2"ORIFICE WNRF 300# S80 B16.36		NPT thread can't pass through
104	9	4"ORIFICE WNRF 300# S80 B16.36	1	NPT thread can't pass through
114	45	8"SORF 150# ANSI B16.5	5	OK
115	12	12"SORF 150# ANSI B16.5	2	OK
116	12	14"SORF 150# ANSI B16.5		OK

2.Visual and Marking check

2.1 Pictures:



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Item45



Marking



Item67



marking



Item91



marking



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Item73



marking

2.2 Findings :



All RTJ end flanges had no ring groove number marking

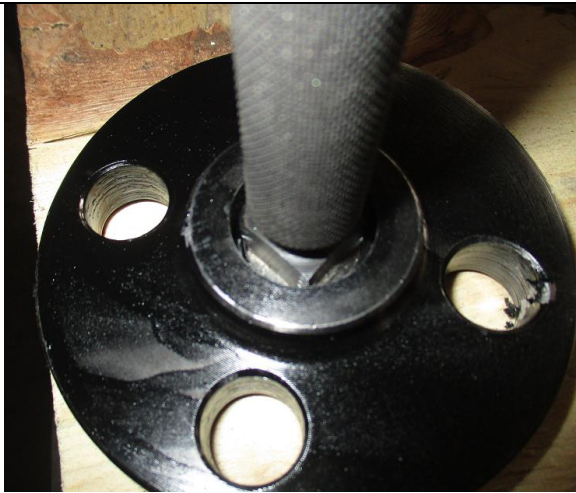


Item96,97, Marking required "B16.36" actual marked "B16.5"

3. Dimensions Check

- 1, Item96.97.100.101, 1042,104, the NPT gauge can't pass through
- 2, item97, 1pcs, the NPT hole was too deep, it was scraped;

3.1 Pictures:





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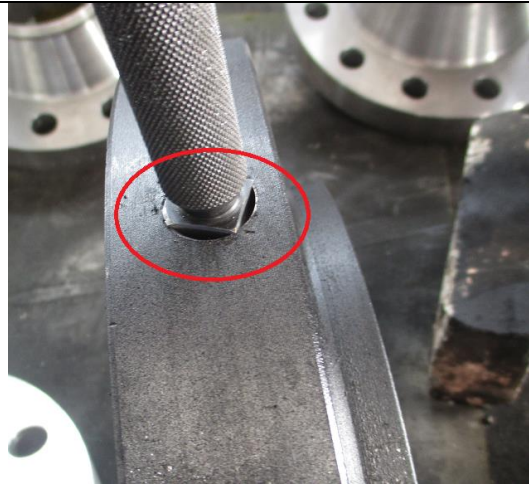
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3.2 Findings :



NPT thread can't pass through, factory had finished reworking all NPT thread.



Item97, 1PCS NPT hole is too deep, factory said they scraped it, and replaced a new one

4. Factory corrective actions



Item56, 1" WNRF 300# S40 ANSI B16.5, Most of them had painting problem in bore surface



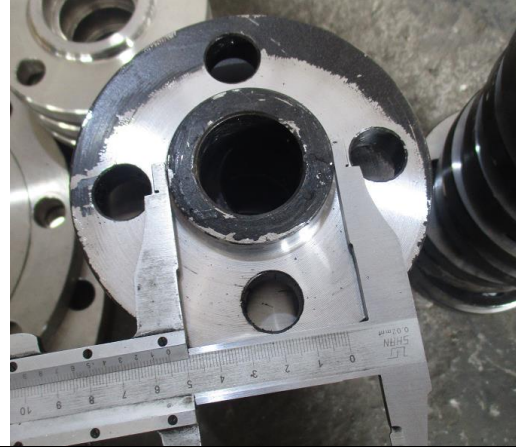
Factory had repaired it



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ITEM47, 1"-300LB RF SO Flange, the diameter of Hub was more than standard, which would effect installing of nut.



ITEM 47, 1"-300LB RF SO flanges, the Hub diameter was over standard.

Factory had reworking them



Item95.99, B16.36 flanges marked " B16.5"

Factory had modified the marking



Item 108~113, LF1 material marked" LF1"

Factory had modified the marking



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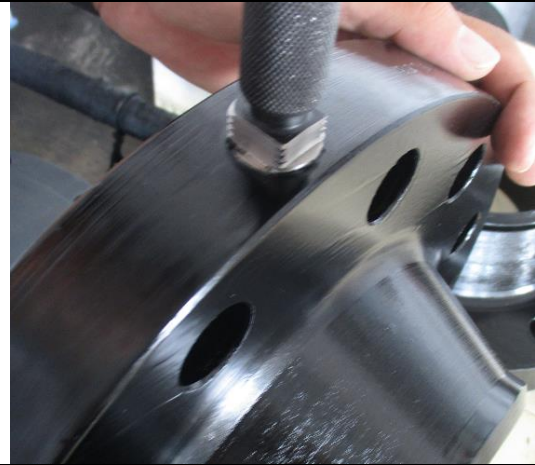
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Item 95,98,99,103, the NPT gauge can't pass through, need reworking



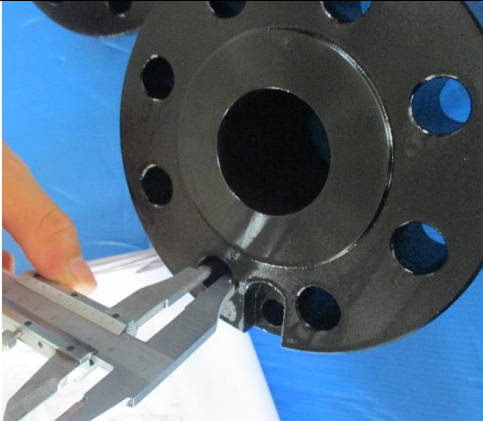
Item 85,98,99,103, NPT gauge can't pass through

Factory had finished reworking



All RTJ end flanges had no ring groove number marking

Factory had add the ring number marking



Item103, bolt hole diameter require 19mm, actual dimension is 18mm, which need reworking

Item103, 4pcs flanges, NPT hole position were deviated

Factory said they scraped all total 6pcs flanges and they will finish replacing new ones in one week.

By now, we finished CS flanges inspection..

END OF THE REPORT

WRITTEN BY: Bill

CHECKED AND APPROVED BY: Ruiyong