

	Ragione sociale STEFFENINI ITALIAN VALVES S.R.L. Via Agro Castello, 20 24020 Casnigo (BG)	Valutazione dei rischi Denominazione: VALVOLA A SFERA Tipo: 1. TRUNNION 2. GALLEGGIANTE
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Ispezioni e Test eseguiti

STEFFENINI VALVES		INSPECTION & TEST PLAN				ITP NO.:																																	
CUSTOMER: PROJECT: NIA		CUSTOMER P.O. NO.:				S.V. REF. NO.:																																	
INSPECTION POINTS R1 = REVIEW POINT R2 = WITNESS POINT R3 = HOLD POINT R4 = MONITOR POINT R5 = SPOT WITNESS R6 = RANDOM		APPLICABLE DOCUMENTATION: CERTIFICATION EN 10204 3.1 FOR PRESSURE CONTAINING PARTS CERTIFICATION EN 10204 2.2 FOR OTHER MINOR COMPONENTS				REVISIONS <table border="1"> <tr> <th>Rev.</th> <th>PREPARED BY:</th> <th>VERIFIED BY:</th> <th>APPROVED BY:</th> <th>DATE:</th> </tr> <tr><td>1</td><td></td><td></td><td></td><td></td></tr> <tr><td>2</td><td></td><td></td><td></td><td></td></tr> <tr><td>3</td><td></td><td></td><td></td><td></td></tr> <tr><td>4</td><td></td><td></td><td></td><td></td></tr> <tr><td>5</td><td></td><td></td><td></td><td></td></tr> </table>				Rev.	PREPARED BY:	VERIFIED BY:	APPROVED BY:	DATE:	1					2					3					4					5				
Rev.	PREPARED BY:	VERIFIED BY:	APPROVED BY:	DATE:																																			
1																																							
2																																							
3																																							
4																																							
5																																							
SCOPE OF SUPPLY: Side Entry Ball Valves for std process																																							
Type: SIDE ENTRY TRUNNION BALL VALVES, BOLTED BODY																																							
SIZE:		CLASS:		CONNECTION:		OPERATOR:		BARE STEM																															
PART	MATERIAL	MATERIAL CONDITION	ACTIVITY	APPLICABLE DOCUMENT	ACCEPTANCE CRITERIA	INSPECTION			DOCUMENT TO BE ISSUED	NOTES																													
						QMS	CUSTOMER	TR																															
1 BODY & CLOSURES	A350 LF2	NORMALIZED	CHEM. & MECH. TESTS	ASTM	ASTM	100	R	100	R	CERTIFICATES EN 10204 3.1																													
2			MACHINING	DWG	DWG	100	R	100	R																														
3																																							
4			INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	H	100	R																														
5			- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														
6 BALL	A182 F316	SOL. ANNEALED	CHEM. & MECH. TESTS	ASTM	ASTM	100	R	100	R	CERTIFICATES EN 10204 3.1																													
7			MACHINING	DWG	DWG	100	R	100	R																														
8			INCOMING INSPECTION	P4 PROCEDURE	P4 PROCEDURE	100	H	100	R																														
9 SEAT RINGS	A182 F316	SOL. ANNEALED	CHEM. & MECH. TESTS	ASTM & D5	ASTM & D5	100	R	100	R	CERTIFICATES EN 10204 3.1																													
10			MACHINING	DWG	DWG	100	R	100	R																														
11			INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	H	100	R																														
12			- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														
13 STEM	A182 F316	SOL. ANNEALED	CHEM. & MECH. TESTS	ASTM	ASTM	100	R	100	R	CERTIFICATES EN 10204 3.1																													
14			MACHINING	DWG	DWG	100	R	100	R																														
15			INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	H	100	R																														
16			- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														
17 TOP COVER	A350 LF2	NORMALIZED	CHEM. & MECH. TESTS	ASTM	ASTM	100	R	100	R	CERTIFICATES EN 10204 3.1																													
18			MACHINING	DWG	DWG	100	R	100	R																														
19			INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	H	100	R																														
20			- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														
21 BOLTS/NUTS	A193B7/GR 2H	QUENCH. & TEMP	CHEM. & MECH. TESTS	ASTM	ASTM	100	R	100	R	CERTIFICATES EN 10204 3.1																													
22			INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	H	100	R																														
23			- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														
24 SEALS	PTFE		INCOMING INSPECTION	P54 PROCEDURE	P54 PROCEDURE	100	R	100	R	DECLARATION ON MTC																													
25	VITON + GRAPHITE		- TRACEABILITY	P59 PROCEDURE	P59 PROCEDURE	100	H	100	R																														

UESE ITALIA S.P.A. Via Felice Casati, 20 - 20124 Milano MI Tel.: +39 0418723000 PEC: unitedsafety@pec.it	Sistemi di controllo qualità ISO 9001 2015 EA37 ISO ISO 13485 Mandatario RDM ISO 45001 ISO 27001 ISO 14001	Direzione Tecnica: Corso del Popolo, 58/B – 30172 Venezia (VE) Tel.: 041 8723001 PEC: unitedsafety@pec.it
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PRESSURE TEST CERTIFICATE				PS7.PTC No.:
CUSTOMER				
CUSTOMER ORDER No.				
PROJECT <i>N/A</i>				
OMS ORDER Ref. No.			OMS ITEM N°	
TAG No. <i>N/A</i>		TAG No. <i>N/A</i>		S.N.
DN	PN	OPERATOR		
NPS	Class	Ende		
PRESSURE TEST IN ACCORDANCE WITH ITP No. :				
	PRESSURE [Bar]	DURATION (min)	ACC.CRITERIA	RESULTS
HYDROSTATIC BODY TEST				
SEAT HYDROSTATIC TEST (A)				
SEAT HYDROSTATIC TEST (B)				
PNEUMATIC SEAT TEST (A)				
PNEUMATIC SEAT TEST (B)				
HIGH PR. GAS SEAT TEST (A)				
HIGH PR. GAS SEAT TEST (B)				
FUNCTIONAL TEST				
SELF RELIEVING A				
SELF RELIEVING B				
	BTO	RUN	ETC	RESULTS
TORQUE TEST A				
TORQUE TEST B				
REMARKS:				
Pressure tests carried out at room temperature.				
<u>Test Fluid</u> -Hydraulic Test: clean potable water with Corrosion inhibitor 4%- Cl content <30 [ppm] -Pneumatic test: Clean Industrial air <u>Calibration</u> - All pressure gauges and test bench used during inspection are within calibration.				
O.M.S. Q.C. Dept.		TPI INSPECTOR		CUSTOMER Rep.
Date:		Date:		

Pagina 2 di 6
Documento: 7 Ispezioni e Test eseguiti

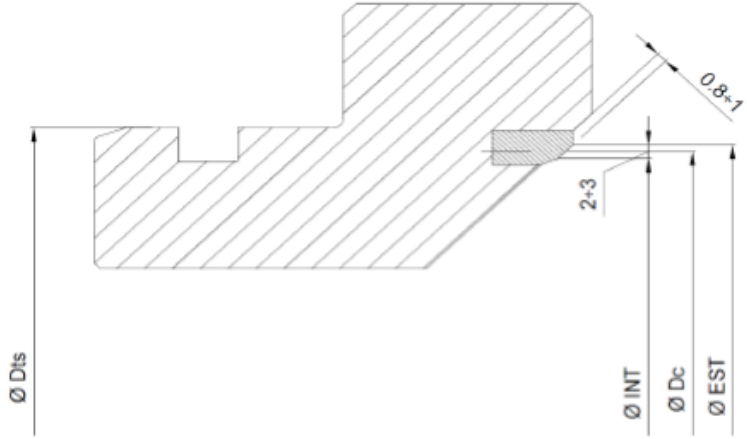
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STEFFENINI VALVES Steffenini S.r.l. Via Agro Castello, 20 24020 - Casnigo (BG) - ITALY	Valve DN	4"	CLC 004.2		
	Class	300			
	Tag no		Check	13/04/2017	
	Rev.	0	Appr.	0	

PISTON EFFECT CALCULATION (PE)

Valve class = 300

Operating pressure Po [Mpa] = 5,17



$PE(Oper. pressure) = Po \left(\frac{N}{mm^2} \right) \times \frac{\phi_{Dts}^2(mm^2) - \phi_{Dc}^2(mm^2)}{4} \times \pi =$		10263,18
Ø Dc =	118,8	Ø EST = 121,5
Ø Dts =	129	Ø INT = 115,8

PISTON EFFECT VERIFICATION (PE) (AT 6bar)

$1,5 \leq \left(Po(0,6) \left(\frac{N}{mm^2} \right) \times \frac{\phi_{Dts}^2(mm^2) - \phi_{Dc}^2(mm^2)}{4} \times \pi \right) / F_{Molle}(N) \geq 1,8$	
Piston Effect PE (6bar) =	1191,08
F _{Molle} =	1967,00 x N° 7 Molle - 281 N
	VERIFICATO Value PE = 1,65

SEAT INSERT VERIFICATION

$1,5 \leq \frac{\phi_{Dts}^2(mm^2) - \phi_{Dc}^2(mm^2)}{\phi_{EST}^2(mm^2) - \phi_{INT}^2(mm^2)} \geq 2$	
VERIFICATO	Seat Insert geometry value = 1,87

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Steffenini Valves		MATERIAL TRACEABILITY REPORT EN 10204 3.1			PS7.MTC No.:
CUSTOMER					
CUSTOMER ORDER No.					
PROJECT N/A					
OMS ORDER Ref. No.				OMS ITEM N°	
TAG.No.		N/A		Q.TY 1	SERIAL No.
DN	PN		OPERATOR		
NPS	Class		Ends		
PARTS	MATERIAL	CERT 3.1 No	CERT 3.2 No	HEAT No	REMARKS:
BODY	ASTM A350 LF2				
CLOSURE	ASTM A105				
BALL	ASTM A182 F316				
GLAND PLATE	ASTM A105				
LOWER TRUNNION	N/A				
STEM	ASTM A182 F316/316L				
SEAT RINGS	ASTM A182 F316/316L				
STUDS	ASTM A193 Gr. B7				
NUTS	ASTM A194 Gr. 2H				
DECLARATION OF CONFORMITY: O.M.S. declares that the product and the materials used for components are in compliance with the Order Requirements and applicable drawings.					
VISUAL INSPECTION: Visual and dimensional inspection carried out with satisfactory results and in accordance with applicable Drawings and Bill of Material.					
O.M.S. Q.C. Dept.		TPI INSPECTOR		CUSTOMER Rep.	
Date: 26/10/2015		Date:		Date:	

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STEFFENINI VALVES	PIANO DI PROGETTO Mod. PS6.1	Pagina 1 di 2
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COMMESSA N°	TIPO/MODELLO	DN/RATING
JOB N° 20001000100 01	BALL VALVE	4" 300

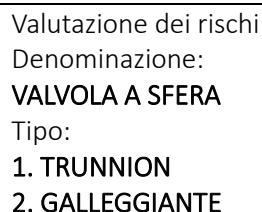
Fasi di PROGETTO		Data Inizio		Data Fine	
		Prev.	Eff.	Prev.	Eff.
A	PROGETTAZIONE PER IL CLIENTE	11/19	11/19	11/19	11/19
A.1	RIESAME FINALE	11/19	11/19	11/19	11/19
B	PROGETTAZIONE PER LA PRODUZIONE	11/19	11/19	11/19	11/19
B.1	RIESAME	11/19	11/19	11/19	11/19
C	VERIFICA DELLA PROGETTAZIONE	11/19	11/19	11/19	11/19
D	VALIDAZIONE DELLA PROGETTAZIONE 1 (Lista di Riscontro)	-	-		
E	VALIDAZIONE DELLA PROGETTAZIONE 2 (collaudo)	11/19	11/19	31/12/2020	9/2020

Strumenti per prove e misurazioni:

■ Banco di collaudo		
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Componenti dell'equipe di lavoro e responsabilità		Fasi di partecipazione				
		A	B	C	D	E
Sales Manager		x				
Quality Manager					x	
General Manager					x	
Design & Development Manager			x	x		
Purchasing Manager						
Production Manager						x
Quality Control Manager					x	x

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Mod. PS6.1 – Rev.: 0 – Pagina 2 di 2

Data Apertura	Il Resp. Progettazione
11/2020	GC