

GROUP-96

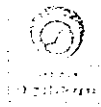
SCOPE OF INSPECTION

FOR PORTABLE FIRE EXTINGUISHER -
TYPE-HALON 1211, CAPACITY: 1.25KG, 2.5KG, 4KG, 5KG, & 6KG:
IS-11108

1. Anti-corrosive treatment will be checked on external & internal surface of body of extinguisher.
 2. Testing : Following tests will be conducted on the complete
----- extinguisher (With fittings)

 - i) Hydrostatic Pressure Test.
 - ii) Leakage Test.
 - iii) Drop Test.
 - iv) Burst Test.
 3. Performance Tests : Following will be conducted:

 - i) Minimum period for which jet is maintained.
 - ii) Maximum period to discharge 95% of content.
 - iii) Range of throw of Jet.
 4. Marking should be done as specified in relevant IS code.
- The above inspection will be carried out as per
IS-11108. The above inspection will be done as per Appendix A of
5. Material test certificates verification for major components.
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SCOPE OF INSPECTION FOR : FIRE EXTINGUISHERS

This inspection will involve the stage inspection as detailed below :

1. Raw material identification, correlation of raw material with material test certificate for major parts like body, gas cartridges, refills, gun metal cap etc. and verification with relevant IS standards.
2. Physical testing, witnessing of the same and chemical composition verification for conforming to code requirements for job above parts of Fire Extinguisher. Other parts will be accepted/rejected based on material test certificate only.
3. Period visits to workshop for stage-wise inspection before and during the manufacturing process.
4. Welding joints/welding seams will be checked as per relevant IS codes mentioned in Purchase Order.
5. Witnessing Hydro test & Burst test against each batch of production as per relevant standard of Fire Extinguisher, for e.g. DCP Fire Extinguisher - IS: 2171 etc.
6. Performance test will be carried on per lot/per batch basis as per relevant IS standard mentioned in Purchase Order.

In addition to above, for higher capacity DCP Fire Extinguisher i.e. more than 10 kg. DCP Fire Extinguisher following addition clause will be applicable.

- a. Design/approval for drawing as per IS:2825 requirement and welders approval before taking up for production/manufacturing of Fire Extinguishers.
- b. Spot radiography on completed body as per IS: 2825 clause II.

For CO2 Fire Extinguisher, there will be no stage inspection required. The CO2 Fire Extinguishers will be inspected as per following scope of inspection :

- 1) Check CO2 Fire Extinguisher body as per IS:2878 under approval from Explosive Department and correlation of COOE certification with CO2 cylinder body.
- 2) Hydro test as per standards.
- 3) Performance test will be carried out on per lot/per batch basis as per relevant IS codes.

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SCOPE OF INSPECTION FOR FIRE HOSE (IS: 636)

- 1) Visual Inspection
- 2) Tests as per IS:636
 - a) Type Tests
 - b) Acceptance Tests
 - c) Routine Tests

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SCOPE OF INSPECTION FOR FABRICATED 'Y' TYPE STRAINERS
/BASKET STRAINERS AS PER BPCL SPECIFICATION :

Inspection will be carried out at parties premises in stages as detailed below :

1. Identification of pipes, flanges, wire mesh, screens, plates, if any, by stamping and a sample of the same will be tested in third (3rd) party laboratory for Physical and Chemical Analysis by B.P.C.L.
 2. Final inspection will cover
 - a. Visual & Dimensional Checks.
 - b. Hydro Static Pressure Test at required pressure.
 3. The pressure drop V/s. Flow chart testing will be carried out in third (3rd) party laboratory at M/s.B.P.C.L. cost, if required.
 4. Material correlation from raw material stage to final product for body & flange.
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SCOPE OF INSPECTION FOR

ITEMS:

- 1) CAST STEEL GATE VALVES CONFORMING TO API:600, CLASS 150/3
- 2) CAST STEEL SWING CHECK VALVES BS:1868, CLASS 150/300.
- 3) CAST STEEL GLOBE VALVES BS:1873, CLASS 150/300.

1. Verification of foundry test certificates for all other chemical properties & correlation of heat numbers for body and bonnet.
2. Checking valve manufacturer's certificates for all other materials.
3. Checking overall dimensions of the valves for conformity to drawings/specifications.
4. All valves to be inspected for smooth operation of hand wheel & stem.
5. Valve Strip Test :

One valve out of ten valves for each size (provided order quantity for each size is ten or more) selected at random, to be stripped open for checking the following to conform to API: 600/ BS:1873.

- i) Body/Bonnet wall thickness. (Gate/Globe/Swing Check)
- ii) Stem Diameter.
- iii) Hardness of wedge/Body seat rings.
- iv) Wedge Travel Test (In case of Gate Valves)

6. Witnessing of Leak Tests :

- i) Pressure test with kerosene/water for shell and back seat for 100% valves.
- ii) Pressure test with kerosene/water for seat on 10% valves selected at random.
- iii) Air Seat Test on 10% valves selected at random. (Globe and Gate)

Test Pressures :

- a) Body : 425 PSI
- b) Seat : 300 PSI
- c) Air Seat : 100 PSI

7. Acceptance/Rejection & also repairs of the valves shall be as per API/BS standards.