



Client:
Project:
Contract No:

Supply of Conveyor Pulleys

Quality Policy and Plan (QP)

Document No: TBA
Release Status: for review

TEFCO Engineering Pty Limited

ABN 35 054 554 611

3 Gibbens Rd, West Gosford, NSW, Australia, 2250
Ph: + 61 2 43254433

Contents

- 1. INTRODUCTION 4
- 2. SCOPE 4
 - 2.1 Quality System 4
 - 2.2 Quality Auditing 4
- 3. QUALITY STATEMENT / POLICY 4
- 4. QUALITY OBJECTIVES 5
- 5. REONSIBILITIES, AUTHORITIES AND COMMUNICATION 5
 - 5.1 General Manager 5
 - 5.2 Engineering Manager 5
 - 5.3 Manufacturing Manager 5
 - 5.4 fabrication manager 5
 - 5.5 Assembly SUPERVISOR 6
 - 5.6 Contract Administrator 6
 - 5.7 Expediter 6
 - 5.8 Logisitics Supervisor 6
 - 5.9 Yardsman 7
 - 5.10 Storeman 7
- 6. MANAGEMENT REVIEW AND QUALITY IMPROVEMENT 7
- 7. DESIGN CONTROL 7
 - 7.1 Design Data, Drawing and Modelling Control 7
 - 7.2 Issue of Design 7
 - 7.2.1 Pre-Construction 7
 - 7.2.2 For Construction 8
 - 7.2.2.1 Issuing Design Data to Project Folder 8
- 8. DOCUMENT AND DATA CONTROL 8
 - 8.1 Master Documentation 8
 - 8.1.1 Superseded Documents 8
 - 8.2 Email Correspondance 8
 - 8.3 Retention of Documents 8
 - 8.4 Computer System 8
- 9. PURCHASING AND CONTRACTING 9

TEFCO Engineering Pty Limited

ABN 35 054 554 611

3 Gibbens Rd, West Gosford, NSW, Australia, 2250
Ph: + 61 2 43254433

9.1	General Procurement.....	9
9.2	Sub-Contractor Selection and Monitoring.....	9
9.2.1	Brand Name Materials.....	9
9.2.2	Non Branded Materials.....	9
9.3	Site Material Inspection.....	9
10.	RECEIPT, STORAGE AND RETURN OF MATERIALS	9
10.1	Receipt inspection and storage.....	9
10.1.1	Receipt Notification.....	9
10.1.2	Inspection and Identification.....	10
10.1.3	Storage.....	10
10.2	Rejection of Materials.....	10
11.	PRODUCTION, MANUFACTURING, MACHINING & ASSEMBLY PROCESS.....	10
11.1	Process Control.....	10
11.2	Inspection and Testing.....	11
11.3	Customer Supplied Product	11
12.	CLIENT ISSUES.....	11
12.1	Submission, reviews and approvals.....	11
12.2	Client Reporting and Notifications.....	11
12.2.1	Reporting.....	11
12.2.2	Notifications	12
13.	NON-CONFORMING PRODUCT.....	12
13.1	Handling, Storage, Packaging and Delivery	12
14.	MONITORING.....	12
15.	RESOURCES	12

TEFCO Engineering Pty Limited

ABN 35 054 554 611

3 Gibbens Rd, West Gosford, NSW, Australia, 2250
Ph: + 61 2 43254433

1. INTRODUCTION

This quality plan (QP) has been developed to:

- (1) ensure that the needs and expectations of the client are met;
- (2) ensure that the project meets the contract quality requirements; and
- (3) provide a link between the each of the internal departments with matters relating to quality

2. SCOPE

This plan applies to the design, procurement, construction and delivery of.

The detail scope of work is specified in the Contract No: ????? and includes:

- (1). Design and Supply of ??? Pulley Assemblies.
- (2). ????

The work is to be performed in accordance with Specifications, Quality Assurance, the drawings and any other requirements included or referred to within the contract.

2.1 QUALITY SYSTEM

TEFCO Engineering conducts its business in accordance with AS/NZS ISO 9001, and has selected relevant sections of the standard, which have been determined to be in the best interest of the company's performance and operation. This QP references parts of this Quality Management System to be incorporated into this project to satisfy the client quality requirements.

With award of the contract to TEFCO Engineering, the client recognises that TEFCO Engineering does not and at the date of release of this document has no future desire to gain formal accreditation of the company's Internal Quality System to AS/NZS ISO 9001 or any other recognised Quality Management System.

2.2 QUALITY AUDITING

TEFCO Engineering invites the Client and its direct Customer(s) to perform external audits pertaining to the requirements of the contract to verify that the systems within TEFCO Engineering are in compliance with the contract quality objectives.

3. QUALITY STATEMENT / POLICY

Tefco is committed to quality excellence and shall strive to consistently provide products and services that meet, or exceed, the expectations of our customers.

The customers' requirements shall be paramount and we will endeavour to continuously improve our performance to achieve that aim.

The success of the company will be ensured through teamwork and discipline of all members of the company.

Our guiding principles towards achieving our main goal of customer satisfaction are:

- Knowledge, experience and use of best industry practices
- Continuous improvement of products, processes and procedures
- Training and personal development for all our employees
- Continuous liaison with our customers and all business partners
- Providing a safe work environment for our employees and the whole community

4. QUALITY OBJECTIVES

Quality Objectives (QO) are measurable statements which can be reviewed via the use of TQM tools to report on the performance of TEFCO Engineering relating to contract performance.

The QO's appropriate to the contract are as follows:

- (1) Over the life of the project, less than 3 Non Conformances.
- (2) Re-work costs are limited to less than 1% of the contract value
- (3) Quality Documentation is reviewed and signed off by all parties on or before the nominated date.

5. REPONSIBILITIES, AUTHORITIES AND COMMUNICATION

Authorities and responsibilities for key positions are defined and communicated with Job Descriptions, Procedures and Work Instructions.

5.1 GENERAL MANAGER

The General Manager is the lead for this project and has the overall responsibilities to ensure that:

- (1) project responsibilities and authorities are communicated;
- (2) this quality plan is implemented and maintained;
- (3) reports on the performance company relating of the contract KPI;
- (4) the project team is made aware of client requirements;
- (5) liaising with client on matters of finance;
- (6) effective communication systems are established and maintained;
- (7) adequate resources are provided to meet project objectives;

5.2 ENGINEERING MANAGER - IS RESPONSIBLE FOR:

- (1) managing all activities associated with the design of the project in accordance with a design plan;
- (2) effective communication systems are established and maintained between Engineering/Manufacturing and Engineering/Procurement;
- (3) liaise with client on matters relating to design;
- (4) liaise with procurement to ensure that procured equipment meets the specific requirements;
- (5) liaise with manufacturing manager to ensure that manufactured equipment meets the specific requirements

The Engineering Manager, reports directly to the General Manager.

5.3 MANUFACTURING MANAGER- IS RESPONSIBLE FOR:

- (1) the daily operating and performance of the factory;
- (2) effective plan and co-ordinate plant, equipment, subcontractors and workers to ensure that the project schedule is maintained;
- (3) effective communication systems are established and maintained with departmental managers;
- (4) liaise with Engineering Manager on Technical Issues relating to design

The Manufacturing Manager, reports directly to the General Manager.

5.4 FABRICATION MANAGER- IS RESPONSIBLE FOR:

- (1) ensuring daily operation of the welding and fabrication area;

- (2) supervising the welding and fabrication area and ensuring that they meet the contract, design, quality, safety, environmental and other requirements;
- (3) effective plan and co-ordinate plant, equipment, subcontractors and workers to ensure that the project schedule is maintained;
- (4) liaise with Manufacturing Manager on fabrication progress;
The Fabrication Manager, reports directly to the Manufacturing Manager

5.5 ASSEMBLY SUPERVISOR- IS RESPONSIBLE FOR:

- (1) ensuring daily operation of the Lagging, Blasting, Painting, and Assembly areas;
- (2) supervising the Lagging, Blasting, Painting, and Assembly areas and ensuring that they meet the contract, design, quality, safety, environmental and other requirements;
- (3) effective plan and co-ordinate plant, equipment, subcontractors and workers to ensure that the project schedule is maintained;
- (4) liaise with Manufacturing Manager on assembly progress;
The Assembly Manager, reports directly to the Manufacturing Manager

5.6 CONTRACT ADMINISTRATOR- IS RESPONSIBLE FOR:

- (1) ensuring that the procurement of goods and services meet specified requirements;
- (2) co-ordinate all procurement related activities including calling for tenders and letting of contracts;
- (3) liaise with Expeditors to ensure goods and services are delivered in line with the Project Schedule;
- (4) liaise with Engineering Manager to ensure that supplied items meet design requirements, and that adequate levels of inspection, surveillance and verification are established and maintained;
The Contract Administrator, reports directly to the General Manager

5.7 EXPEDITER- IS RESPONSIBLE FOR:

- (1) ensuring that goods and services are received in line with project schedule;
- (2) update progress reports and schedules on procured goods and services;
- (3) designated levels of inspection, surveillance and verification are maintained;
- (4) liaise with Contract Administrator to ensure that procured goods and services meets both the contract and design requirements;
- (5) liaise with subcontractors and suppliers to ensure that contract, design and quality requirements are met;
The Expediter, reports directly to the Manufacturing Manager

5.8 LOGISTICS SUPERVISOR - IS RESPONSIBLE FOR:

- (1) the receipt and delivery of all goods on and off the site;
- (2) ensuring that all needs relating the packaging and transportation of equipment and goods is organised;
- (3) liaise with the client representative, with matters relating to delivery of goods to site;
- (4) liaise with Expeditors to ensure that goods are received from subcontractors and suppliers in line with the project schedule;
- (5) daily rounds of manufacturing's progress is update into the 'Manufacturing Database';
The Logistics Supervisor, reports directly to the Manufacturing Manager.

5.9 YARDSMAN- IS RESPONSIBLE FOR:

- (1) the unloading and loading of trucks of incoming and outgoing goods and equipment;
- (2) the collating of materials held in stock yard for up and coming factory work
- (3) liaising with Logistics Supervisor, to ensure that incoming goods are correct

The Yardsman, reports directly to Assembly Supervisor

5.10 STOREMAN- IS RESPONSIBLE FOR:

- (1) for the cataloguing and storage of acceptable materials;
- (2) the unloading and loading of trucks of incoming and outgoing goods and equipment;
- (3) the collating of materials held in stores for up and coming factory work
- (4) liaising with Logistics Supervisor, to ensure that incoming goods are correct

The Storeman, reports directly to Assembly Supervisor

6. MANAGEMENT REVIEW AND QUALITY IMPROVEMENT

Continual review and improvement of TEFCO operating systems is necessary in order to achieve project objectives.

Management shall review the status and adequacy of the Quality Plan and associated implemented systems to identify opportunities for improvement. The review shall be undertaken following any client comments, client audits, internal quality audits or any deficiencies in the system is identified.

7. DESIGN CONTROL

Design shall be controlled and managed in accordance Tefco Standard Practices and is the responsibility of the Engineering Manager.

7.1 DESIGN DATA, DRAWING AND MODELLING CONTROL

Design Data, including calculations, sketches, drawings and 3D models are maintained and controlled within the secured password protected Engineering Data Vault. Engineering data shall only be 'checked out' if there is intent to revise the data. Data is not too checked out if the need is only for information purposes only.

Data which is revised shall be immediately checked back to the vault to ensure that the latest version of all documents is available to the engineering team.

7.2 ISSUE OF DESIGN

Design data is either issued in three states:

- (1) pre-Construction release;
- (2) for Construction release; and
- (3) as built

7.2.1 Pre-Construction

Pre-Construction drawings are non approved drawings and are designation with a alphabetical - A, B, C, etc. and are stored on the engineering vault, and are not issued to the project production drawing folder.

7.2.2 For Construction

For Construction drawings are approved drawings and are designated with a numerical revision status – 0, 1, 2 etc. which denotes that the document has been review and approved both by Tefco and the client. Approved for Construction drawings are issued to the Project Drawing Folder.

7.2.2.1 Issuing Design Data to Project Folder

For Construction design data is to be placed in the Electronic Production Folder on the TEFCO Engineering Server. The data which is in the Electronic Production shall be the latest version, with all other versions delete. The need for keeping superseded versions of design data in Production folder is not required as the Engineering department is mandated with maintaining its own superseded design data within the Engineering vault.

The maintenance of this process is the responsibility the Engineering Manager

8. DOCUMENT AND DATA CONTROL

Documents such as specifications, drawings, standards, procedures, instructions that are necessary for describing accurately an item with it quality requirements are considered as quality-related documents. This is also the case for procedures and instructions, which specify critical manufacturing processes, testing, installation, and running operations.

All quality-related documents must be verified by the General Manager to ensure that they are clear, complete, and non-ambiguous. Each quality-related document will be created according to the relevant standards and procedures and be uniquely identified with a code, which includes the documents issue and revision status.

8.1 MASTER DOCUMENTATION

Master Project Electronic Documents are to be filed in the Project Folder on TEFCO Engineering Minerva Server.

Hardcopy files are to be filed in the Project Folder.

8.1.1 Superseded Documents

Electronically superseded documents are to be filed in a subfolder of the Master document location under superseded, where an electronic superseded copy of the document is unable to be created, the documents is to be pdf and transferred to the superseded folder for reference.

Hardcopy superseded documents are to be marked "Superseded" & retained for reference purposes.

'Note' the latest copy of any document is to be foremost document in the Hardcopy Project Folder.

8.2 EMAIL CORRESPONDANCE

All email correspondence with reference to this project shall have the TEFCO Job Number TBA in the title spaced, facilitating search of the email database.

8.3 RETENTION OF DOCUMENTS

All electronic and hardcopy documents shall be retained for a minimum of 7 years, where the retention of these documents are unable to sustained, the documents are to be packaged and issued to the client with the appropriate declaration documentation completed.

8.4 COMPUTER SYSTEM

The electronic file share for the project shall be backed up on a daily basis

9. PURCHASING AND CONTRACTING

At the start of the project, a procurement program/schedule shall be prepared identifying supply and subcontract packages, key dates, etc.

The progress of procurement activities is to be regularly updated by the expediter, and added to the overall project schedule.

9.1 GENERAL PROCUREMENT

Procurement of general day-to-day items including consumables and the hire of equipment is the responsibility of the expediter who shall review the project schedule to forecast daily needs of manufacturing.

9.2 SUB-CONTRACTOR SELECTION AND MONITORING

9.2.1 Brand Name Materials

Brand Name materials, equipment and vendor items are nominated within the contract or design documentation. Any changes from the items nominated shall require approval from both the Engineering Manager and client.

9.2.2 Non Branded Materials

Suppliers and subcontractors of Non-Branded equipment should be carefully evaluated. The selection of any supplier/subcontractor shall base upon:

- (1) their ability to supply goods and services in line with the project schedule;
- (2) their ability to supply goods & services in line with contract, design & quality requirements
- (3) their historical performance in the supply of goods and services

9.3 SITE MATERIAL INSPECTION

Where site inspection of material is required, the expediter task to control the particular subcontractor/supplier is responsible to ensure that inspections are performed and completed in a timely manner in accordance with the project schedule.

Where the expediter is not sufficiently qualified to perform an inspection, the expediter shall organise for suitable persons to perform the inspection.

Site inspections are to be recorded on Inspection Test Records (ITR's) where the required by the Inspection and Test Plan or TEFCO Engineering procedures.

10. RECEIPT, STORAGE AND RETURN OF MATERIALS

10.1 RECEIPT INSPECTION AND STORAGE

Goods and materials which are delivered to site shall be received and stored in accordance with following:

10.1.1 Receipt Notification

Prior to delivery of any goods to TEFCO factory site, the Logistics Supervisor is to be noted on the impending delivery.

Delivery Notice shall be made to the Logistics Supervisor 24 hours prior to arrival and shall include:

- (a) copy of the Supplier/Subcontractor Delivery Docket (DD); and
- (b) copy of any material/test certification

Failure to notify the Logistics Supervisor of deliveries may result in rejection of materials (See Section 10.2)

10.1.2 Inspection and Identification

On arrival of goods and materials, the Yardsman notifies the Logistics Supervisor to ensure that correct documentation has been received in advance. For deliveries which failure to receive adequate documentation, the materials are to be rejected, (See Section 10.2).

The Yardsman/Storeman is to review the documentation received by the Logistics Supervisor against the delivery documentation and the goods, including:

- (1) Quantity;
- (2) Description of Supply;
- (3) Batch/Heat/Lot Numbers, etc

If the goods are deemed acceptable, it may be unloaded and prepared for storage.

The delivery docket shall be signed and dated on unloading, and then forward to the main office for processing.

Failure of any part of receipt inspection, refer to section 10.2 for rejected materials/goods.

10.1.3 Storage

Materials are to be marked with a minimum of:

- (a) Project/Job Number;
- (b) Equipment Identification Number;
- (c) Heat/Lot Number (if applicable); and
- (d) Equipment Location

Materials/goods are then to be storage in the appropriate location to prevent damage or lose.

10.2 REJECTION OF MATERIALS

Where materials/goods have been rejected on receipt one of two rectification actions may be pursued.

- (1) For documentation or associated errors; the goods are not to unloaded and the supplier/subcontractor contacted for correct documentation to send to TEFCO Logistics Supervisor, failure to resolve this issue a suitable timeframe then;
- (2) The materials are to be returned to the Supplier/Subcontractor at their cost, unless otherwise instructed by either, the General Manager, Manufacturing Manager or Engineering Manager.

Any return of material shall be accompanied with a goods return noted, outlining the reason for rejection.

11. PRODUCTION, MANUFACTURING, MACHINING & ASSEMBLY PROCESS

11.1 PROCESS CONTROL

Manufacturing, Fabrication, Machining and Assembly process shall be handle in accordance with procedure <Procedure No.> utilising the following documents and tools:

- (1) approved drawings and specifications;
- (2) inspection and Test Plans (ITP), and reference documents;
- (3) relevant standards, codes and regulations; and
- (4) manufacturing database

Welding procedures will be prepared in accordance with AS/NZS 1554, using Work Procedure Specification (WPS) form <Form No.> and Welding Procedure Qualification Record (PQR) for (Form No.).

All welders shall be qualified to the appropriate procedures and certificates held on file.

11.2 INSPECTION AND TESTING

All materials and work shall be subject to inspection and testing in accordance with the contract, applicable codes, laws, regulations the approved Inspection and Test Plan (ITP).

ITP's shall identify all those inspections, tests, and hold/witness points to be carried out by TEFCO Engineering and its subcontractors during the execution of the contract. ITP's shall be submitted to the client for review and approval.

ITP's shall nominate all the applicable codes/standards to be applied and the acceptance criteria. Where no code or standard exists, the relevant department authority shall nominate the acceptance criteria.

Inspection and Test Records (ITR) shall be used to record the activities outlined in the ITP's and be used as Objective Quality Evidence (OQE) in support of meeting the Quality Standard as stipulated in the contract. The results of these ITR's are to be entered into TEFCO Engineering Manufacturing Database.

A hold/witness point may only be released once, each of the witness criteria have been signed and dated by all parties nominated on the ITP.

Hold/Witness points may be signed by the:

- (a) General Manager;
- (b) Engineering Manager; and/or
- (c) Manufacturing Manager

On behalf of TEFCO Engineering, it is the responsibility of the client to ensure that adequately qualified personnel are used for their nominated inspection/hold/witness points.

Any defects or non-conformities shall be rectified and the whole or any part of the work shall be re-tested as required

11.3 CUSTOMER SUPPLIED PRODUCT

Customer-supplied property for this contract is:

- (1) ????

Items are subject to verification (such as review and/or receipt inspection) to ensure they are in good order and are of an acceptable standard. In the event of problems, the Contract Administrator will raise corrective action reports and notify the client. Verification is sufficient to determine that items are as specified but design review is not included. Tests of equipment may be included if required to determine suitability.

12. CLIENT ISSUES

12.1 SUBMISSION, REVIEWS AND APPROVALS

Documentation required for submission, review and approvals are as specified in the contract.

12.2 CLIENT REPORTING AND NOTIFICATIONS

The following reports will be submitted to the client in accordance with the contract requirements.

12.2.1 Reporting

The following periodic reporting is required under the contract requirements:

Report Title	Report Format	Frequency
Contract Program	Excel Spreadsheet	Monthly
Progress Review	Excel Spreadsheet	Monthly
Progress Payment Claim	Excel Spreadsheet	Monthly

12.2.2 Notifications

The following notification period is required under the contract requirements:

Notification	Notification Period
Witness and Hold Points for Inspection	Five (5) working days

13. NON-CONFORMING PRODUCT

Non-Conforming equipment produced by Contractors, collaborating parties, and Tefco Engineering shall be segregated from the conforming materials.

Re-occurrence of problems leading to non-conformance should be eliminated or minimised by implementing appropriate corrective and preventative actions. No repair on non-conforming equipment shall be undertaken prior to the written agreement to do so by the appropriate level of the project management.

Where simple rework or adjustment is necessary to achieve required values, this is not considered as non-conformity as several test runs may be necessary to adjust or tune the systems. Non conformity is recorded if repeat testing establishes that replacement, repair, or reprogramming of system components is necessary.

13.1 HANDLING, STORAGE, PACKAGING AND DELIVERY

These operations are part of the Quality Assurance. Particular attention must be paid to long-term storage of assembled equipment and life supporting components which may degrade with time and/or sunlight, which must be done in such a way that is should not be necessary to re-commission or re-test any equipment after a long storage period.

14. MONITORING

Monitoring is performed against the project plan/schedule but out of necessity, these frequently change. TEFCO Engineering monitors the resource and time required to achieve acceptable criteria (the project quality objectives) by review of its own and sub-contractors performance. Time and cost analysis is included and although possibly not affecting the jobs on which they were obtained, results are incorporated within overall review and improvement.

Test manuals provide records of how a facility performed at the time of commissioning or supply. Data is used within service and warranty to determine system, process and product operating parameters.

15. RESOURCES

TEFCO Engineering and it's sub-contractors identify resources required to meet the contract requirements through planning actions.

TEFCO ENGINEERING PTY LIMITED

3 Gibbens Road, West Gosford, NSW, 2250 Phone (02) 43254433 Fax (02) 43254622

INSPECTION TEST PLAN (ITP)		Preparation Date	17 th March 2009	By: PJB	
		Revision Number	Original		
		Client Accept Date		By:	
Client: BMA Project Ref: Crinum North Pulleys. Order No: TBA Client contact: TBA		Tefco Job No: TBA Document No: Job TBA ITP 01 Item: Pulleys Qty: ?? Dr. No: 750-??? Thru 750-???		Key to inspection activities H = Hold Point S = Client or Third Party Surveillance Check R = Review W = Management or Client Witness Point O = Operator acceptance OK	
Job description:	Manufacture ?? Pulleys and Rolls				
Inspection interval:	Full			MDR Required?	YES
Product ID:	Stainless Steel nameplate on pulley outside face				

Ref No.	Description of Inspection Activity	Location	Control Document	Tefco Procedure	Acceptance Criteria	Confirming or Verifying Document	Include document in MDR Yes/No	INSPECTION						
								TEFCO		CLIENT		Third Party		
								Activity	Sign	Activity	Sign	Activity	Sign	
1	Prepare this ITP	Tefco	Tefco QA Manual	Procedure T-02P-04	Client Order	Approved ITP	Yes	H		H				
2	Order materials	Tefco	Tefco QA Manual	Procedure T-06P-01	Client Order Client Spec Pulley Drawings	Purchase Order	No	S						
3a	Receive Materials & Material certificates	Tefco	Tefco QA Manual	Procedure T-08P-01	Client Order Client Spec Pulley Drawings	Material certs for Plate, Shafts	Yes	R		S				
3b	Rolled shell Ovality & Diameter	ER Curtain	Tefco QA Manual	Procedure T-08P-01	Barrelling not to exceed 3mm Roundness within 2mm	Tefco Printout	No	R		S				
4	Welder Qualification	Tefco	Tefco QA Manual	Procedure T-09P-01	AS2980-2004	Copy of test certificate	Yes	H		R				
5	Welding Procedure	Tefco	Tefco QA Manual	Procedure T-09P-01	AS1554.1 2004	Qualified WPS register	Yes - Letter of Conformance	H		H				
6	Stress relieve Pulley Body	Tefco	Tefco QA Manual	Procedure T-08P-01	Table 2.1 AS4458-1997	Tefco Printout	Yes	R		S				
7	Dimensional Control	Tefco	Tefco QA Manual	Procedure T-10P-01	Pulley Drawings	Inspection reports	Yes	H		W				
8a	NDT – Ultrasonic welds	Tefco	Tefco QA Manual	Procedure T-10P-01	AS2207-1994 Level 2	NDT Report	Yes	S		R				
8b	NDT – Ultrasonic plate 50mm or thicker	Tefco	Tefco QA Manual	Procedure T-10P-01	AS1710-1986 Level 2	NDT Report	Yes	S		R				

								INSPECTION					
Ref No.	Description of Inspection Activity	Location	Control Document	Tefco procedure	Acceptance Criteria	Confirming or Verifying Document	Include document in MDR Yes/No	TEFCO		CLIENT		Third Party	
								Activity	Sign	Activity	Sign	Activity	Sign
8c	NDT – Ultrasonic all Shafts	Tefco	Tefco QA Manual	Procedure T-10P-01	AS1065-1988 Level 2	NDT Report	Yes	S		R			
8d	NDT - Ultrasonic finished shell thickness	Tefco	Tefco QA Manual	Procedure T-10P-01	AS2452.1-2004	Tefco Report	Yes	S		R			
8e	NDT – Check Balance	Tefco	Tefco QA Manual	Procedure TWI-10	ISO 1940-1 2003 Grade 6.3	Tefco Report	Yes	S		R			
8f	NDT – Check TIR over lagging	Tefco	Tefco QA Manual	Procedure T-10P-01	0.5mm over Poly Lagging 1.5mm over Rubber lagging 2.0mm over ceramic Lagging	Tefco Report	Yes	S		R			
8g	Check lagging adhesion	Tefco	Tefco QA Manual	Procedure TWI-06	AS1683-14 Minimum 9N/mm	Tefco Report	Yes	S		R			
9	Bearing clearance & Location	Tefco	Tefco QA Manual	Procedure T-10P-01	Client Drawings +/- 1.5mm on Ctrs Bearing clearance tables	Tefco Report	Yes	H		W			
10	Surface Treatment	Tefco	Tefco QA Manual	Procedure T-09P-01	Client Spec as detailed on Pulley Drawings	Coating report & Photos	Yes	H		H			
11	Final Inspection	Tefco	Tefco QA Manual	Procedure T-10P-01	Client Order Client Drawings	Final Inspection Report	Yes	H		H			
12	Release	Tefco	Tefco QA Manual	Procedure T-10P-01	Client Order	QA release Del'y Docket	Yes Yes	H		R			
13	Complete & Submit MDR	Tefco	Tefco QA Manual	Procedure T-02P-04	Client Order	Completed MDR	Yes	R		R			