



صناعات الخليج المتحدة للأنابيب ش.م.م
UNITED GULF PIPE MANUFACTURING CO. LLC

SITP PIPE



صناعات الخليج المتحدة للأنابيب ش.م.م.
UNITED GULF PIPE MANUFACTURING CO. LLC

Specific Inspection Testing Plan

Specific Inspection Testing Plan									
Ref. No.	ITP/01	Rev.	00	Applicable Standards	Date				
Product	HDPE Gravity Pipes								
Project									
Client									
				Consultant					
				Contractor					
S.NO.	Product/ Inspection detail	Factory Applicable Procedure	Specification/ International Standards	Record Format No.	Hold/witness/ Review Points			Acceptance/ Criteria	Frequency
Legend for intervention point: H: Hold point W: Random Witness R: Review P: Perform					UGPM	Consultant	Client/TPI		
1	Raw Material								
1.1	Density (Granule)	Doc.ref.no.16	ISO 1183	H 9.14	P	RW	R	≥0.95g/cm ³	Once for each batch of raw material from manufacturer
1.2	Melt flow index @ 5Kg Load (Granule)	Doc.ref.no.04	ISO 1133	H 9.13	P	RW	R	≤0.6 g/10min	
1.3	Moisture	Doc.ref.no.15	UGPM Internal Standard	-	P	RW	R	0.08% M.C	
Document No.ITP/01		UGPM		Reviewed by consultant		Approved by			
Rev.NO.00 Date:10.01.2010									



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2	Product							
2.1	Dimensional Check (Diameter, Wall thickness, Visual check(Appearance))	Doc.ref.no. 01	DIN-16961-2, EN-13476-1,3	H 9.24	P	RW	R	Procedure... and smooth surface
2.2	Melt flow index @ 5Kg Load (Moulding)	Doc.ref.no. 03	ISO 1133	H 9.13	P	RW	R	≤0.6 g/10min
2.3.a	Ring Stiffness (ISO)	Doc.ref.no. 02	ISO 9969	H 9.6	P	RW	R	As per clients min requirement
2.3.b	Ring Stiffness (DIN)	Doc.ref.no. 02	DIN 16961	H 9.3	P	RW	R	As per clients min requirement
2.4	Heat Reversion	Doc.ref.no. 06	DIN 8075	H 9.18	P	RW	R	5%
2.5	Density(Moulding)	Doc.ref.no. 16	ISO 1183	H 9.14	P	RW	R	≥0.950 g/cm ³
2.6	Tensile Strength	Doc.ref.no. 14	ISO 527	H 9.30	P	RW	R	As per min requirement of tender specification

One Sample per run (Batch)

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Product	HDPE Gravity Pipes									
Project						Consultant	PARSONS INTERNATIONAL & COMPANY L.L.C			
Client	OMAN WASTEWATER SERVICE COMPANY					Contractor				
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4	<u>Packing/ Inspection detail</u>									
4.1	Packing Inspection									
4.2	Transportation									
4.3										
5	Release note									
6	Final Manufacturing record book(MRB)									
Document No.ITP/01		Prepared by(FPS)v UGPM)		Reviewed by consultant		Approved by OWSC				
Rev.NO.00										
Date:10.01.2010										



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SITP MANHOLE



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Specific Inspection Testing Plan

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Ref. No.	ITP/02	Rev.	00	Applicable Standards		Date					
Product		Manholes & Chambers made of HDPE				Consultant					
Project						Contractor					
Client											
S.NO.	Product/ Inspection detail	Factory Applicable Procedure	Specification/ International Standards	Record Format No.	Hold/witness/ Review Points			Acceptance/ Criteria	Frequency		
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					UGPM	Consultant	Client/ TPI				
1	Product										
1.1	Check dimensions (diameter, height, thickness, profile type) and visual inspection	Doc.ref.no 01	EN ISO 3126	9.24	P	RW	R	As per client's drawing and smooth surface	Each Manhole		
1.2	Impact test for welding	Doc.ref.no 09		9.24	P	RW	R	No Cracks	Monthly		
1.3	Vacuum test for weld integrity	Doc.ref.no 10	EN 13598-2	9.24	P	RW	R	No Leakage	Monthly		
1.4	Load bearing capacity	Doc.ref.no 11	BS7158	9.24	P	RW	R	No Collapse/ No Cracking	Monthly		
1.5	Impact Resistance (Base)	Doc.ref.no 12	EN 13598-2 Annex C	9.24	P	RW	R	No Cracks	Quarterly		
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2	<u>Riser and ladder</u>								
2.1	Ring Stiffness of Riser	Doc.ref.no 02	ISO 9969	9.6/9.3	P	RW	R	≥2KN/sq.m	Monthly
2.2	Strength of ladder (Vertical)	Doc.ref.no 13	EN 13598-2	9.24	P	RW	R	Deformation ≤ 10mm	Monthly
2.3.	Pull out Resistance (Horizontal)	Doc.ref.no 14	EN 13598-2	9.24	P	RW	R	No Pull Out	Monthly
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3	<u>Fitness for purpose</u>									
3.1	Tightness of elastomeric sealing ring		EN 13598-2		At Site, after installation	RW	R	No Leak	Random	
3.2	Water tightness of base-riser connection		EN 13598-2		At Site, after installation	RW	R	No Leak	Random	
3.3	Water tightness between elements and accompanying components		EN 13598-2		At Site, after installation	RW	R	No Leak	Random	
3.4	Water tightness of telescopic part		EN 13598-2		At Site, after installation	RW	R	No Leak	Random	
3.5	Water tightness of Manhole/ HCC	Doc.ref.no 15	EN 13598-2	9.24	At Site, after installation	RW	R	No Leak	Random	
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