

# CHONGQING ACIR TRADING CO., LTD

## Procedure For Quality Control of BV Windlass

### 1. Scope

2. This procedure covers all activities of inspection from receiving material to shipment of windlass

### 3. Standards

- Building Specification ( as per final production drawing with signature of seller&buyer)

-Standards of BV class ( as per drawing approved by BV class)

### 4. Quality Control of Each Process

#### 1) Drawing Control

- all drawings relevant to windlass have prepared and supplied by ACIR MARINE on the basis of client's requirements and BV class requirements.

#### 2) Material Receive Control

- mill certificate of raw materials required  
- CCS certificate of structures

#### 3) Assembly Control

- Assembly of windlass should be done in accordance with drawings and standard relevant.

- All welding works should be done in approved WPS by qualified welders.

- All weld seams should be carried out the proper NDT method, NDT report required

- Dimension Inspection, Visual inspection, reports required

#### 4) Painting Control

- the surface must be clean before blasting

- paint film of windlass should be protected from any kind of damage during stock and handling.

#### 5) Pull Testing

- pull test at factory, factory test report

#### 6) Packing Control

- packing method in accordance with the relevant requirement

#### 7) Shipment Control

- Special care should be taken to prevent damage during loading

#### 8) Non-Conformity Control

-the rectification of defects shall be treated by manufacture if any deviation from specifications or drawings.

### 5. Check-list of required quality control documents

- Mill report of raw material

-UT report of welding seams, pictures

-Mill certificate ( including visual, dimension, pull test report)

-BV class certificate

-CCS certificate of motor, electrical cabinet