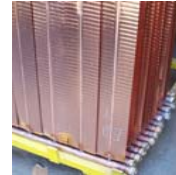


PANEL QC & PROCESS FLOW DIAGRAM



Station 1	Station 2	Station 3	Station 4	Station 5	Station 6	Station 7
← Nonconformity → Conformity	← Nonconformity → Conformity	← Nonconformity → Conformity	← Nonconformity → Conformity	← Nonconformity → Conformity	← Nonconformity → Conformity	← Nonconformity → Conformity
Dimensions & Materials Checkpoint	Pipe & AL Case Dimensions Checkpoint	Welding Checkpoint	Pressure Test Checkpoint	Paint & Coating Checkpoint	Final Product Checkpoint	Final Pre-shipment Checkpoint
QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC ZONE Use "Process Defect Form" in case of Non-conformity
QC Action: Warehouse Rep. And QC Engineer checks the specs for the material during arrival of material. Reference Source Raw Materials Technical Spec Sheets	QC Action: Worker in each station is responsible for the QC of the previous station. Reference Source "Order Form"	QC Action: Worker in each station is responsible for the QC of the previous station. + Each welder marks his initials on the bottom corner of the fintube on the rightmostside. Reference Source Welding Procedure	QC Action: Worker in each station is responsible for the QC of the production process carried out at the previous station. Pressure Test is inspected at this station. "T" sign is marked next to the initials of the welder, signifying that the panel is tested at 9 bar pressure. Reference Source + Hydrostatic test Procedure for panels	QC Action: Worker in each station is responsible for the QC of the production process carried out at the previous station.	QC ACTION: QC Engineer checks conformity of each panel with the "Final QC Form". Possible QC defects are marked on the form. QC label is stamped with "ok" if conformity is met. Reference Source: Final QC Form + QC label	QC ACTION: "QC" Stamp is marked on the carton box when the package is ready for loading. Reference Source: Final QC Form + Packaging Procedure



EACH PERSONNEL IS ALSO A QC PERSON.
QC ENGINEER IS RESPONSIBLE FOR THE QUALITY CONTROL OF ENTIRE PRODUCTION PROCESSES AND PERSONNEL.

BOILER QC & PROCESS FLOW DIAGRAM PART I - BEFORE INNER COATING



Station 1	← Nonconformity → Conformity	Station 2	← Nonconformity → Conformity	Station 3	← Nonconformity → Conformity	Station 4	← Nonconformity → Conformity	Station 5	← Nonconformity → Conformity
Dimensions & Materials Checkpoint		Boiler Assembly Checkpoint		Welding Checkpoint		Pressure Test Checkpoint		Close Loop Assembly Checkpoint	
QC Action: Warehouse Rep. And QC Engineer checks the specs for the material during arrival of material.	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC Action: Worker in each station is responsible for the QC of the previous station.	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC Action: Worker in each station is responsible for the QC of the previous station. + Each welder marks his initials on the tank body.	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC Action: Worker in each station is responsible for the QC of the production process carried out at the previous station. Pressure Test Inlet orientation and welding defects are inspected at this station. "T" sign is marked signifying that the tank is tested at 9 bar pressure.	QC ZONE Use "Process Defect Form" in case of Non-conformity	QC Action: Worker in each station is responsible for the QC of the production process carried out at the previous station.	QC ZONE Use "Process Defect Form" in case of Non-conformity
Reference Source Raw Materials Technical Spec Sheets		Reference Source Raw Tank Technical Drawings		Reference Source Welding Procedure + Boiler Technical Drawings		Reference Source Boiler Technical Drawings + Hydrostatic test Procedure		Reference Source Tank Technical Drawings	



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HEACH PERSONNEL IS ALSO A QC PERSON.
QC ENGINEER IS RESPONSIBLE FOR THE QUALITY CONTROL OF ENTIRE PRODUCTION PROCESSES AND PERSONNEL.

BOILER QC & PROCESS FLOW DIAGRAM PART- II AFTER INNER COATING



Station 1	← Nonconformity → Conformity	Station 2	← Nonconformity → Conformity	Station 3	← Nonconformity → Conformity	Station 4	← Nonconformity → Conformity	Station 5	← Nonconformity → Conformity
Coating Checkpoint		Assignment of Serial Numbes		Insulation and Casing Checkpoint		Final Product Checkpoint		Final Packaging Checkpoint	
<p>QC Action: Boilers that arrive after coating are inspected one by one visually by the QC engineer and are marked as follows:</p> <p>OK: Good coating XOK: Minor problems at coating XX: Problematic coating / should be consulted with Production Manager</p> <p>Reference Source: "Coating QC forms" "Coating QC Procedure"</p>	<p>QC ZONE Use "Process Defect Form" in case of Non-conformity</p>	<p>QC Action: Each tank that has the coating QC mark is given a serial number by the QC Engineer. The serial numbers are recorded in the "Boiler serial numbers Database".</p> <p>Reference Source: "Tank Serial Numbers Database"</p>	<p>QC ZONE Use "Process Defect Form" in case of Non-conformity</p>	<p>QC Action: Worker in each station is responsible for the QC of the previous station. Aluminium labels are marked as stated by the "Order Form". AL labels are screwed on the tank together with the QC label. If order is OEM, only QC label with the serial number is stuck on the product.</p> <p>Reference Source: "Tank Serial Numbers Database"</p>	<p>QC ZONE Use "Process Defect Form" in case of Non-conformity</p>	<p>QC ACTION: QC Engineer checks conformity of each tank with the "Final QC Form". Possible QC defects are marked on the form. QC label is stamped with "ok" if conformity is met.</p> <p>Reference Source: Final QC Form + QC label</p>	<p>QC ZONE Take note on the "Final QC form" in case of Non-conformity</p>	<p>QC ACTION: All components that need to be inside the package are listed in the "Order Form". "Final QC Form" is marked as each component is placed in the package. "QC" Stamp is marked on the carton box when the package is ready for loading.</p> <p>Reference Source: Final QC Form + Packaging Procedure</p>	<p>QC ZONE Take note on the "Final QC form" in case of Non-conformity</p>



NOTES

EACH PERSONNEL IS ALSO A QC PERSON.
QC ENGINEER IS RESPONSIBLE FOR THE QUALITY CONTROL OF ENTIRE PRODUCTION PROCESSES AND PERSONNEL.