



 Gachsaran Polymer Industries Company PIDMCO	<b>Gachsaran Polymer Industries Company</b> <b>HDPE Plant</b>				
	<b>Inspection And Test Plan (ITP) for</b> <b>Refrigerator Package</b>		 		
PO No.: GPIC-PT-MA-PO-000-3029	Document Number: VD-GPIC-MA-3029-3029-0003	Rev. 00	Page 1 of 8		

## Inspection And Test Plan (ITP) for Refrigerator Package

<b>Code1</b>	<input type="checkbox"/> <b>No Comment/ Approved</b> (Applicable Only for "FOR REVIEW" and "For Approval" Documents) No comment and the document are released for Manufacturing.
<b>Code2</b>	<input type="checkbox"/> <b>No Comment/ Approved with Note(s)</b> Vendor/Sub-Contractor shall correct, revise and resubmit the document. The document is released for Manufacturing if changes incorporated.
<b>Code3</b>	<input checked="" type="checkbox"/> <b>Commented</b> Vendor/Sub-Contractor shall correct, revise and resubmit the document by the date specified. The document shall be revised under the Status of "R: Revised Issue". All corrected documents shall be resubmitted before starting the Manufacturing Process.
<b>Code 4</b>	<input type="checkbox"/> <b>Not Accepted (Rejected )</b> Vendor/Sub-Contractor shall re-work / re-design / re-specify the contents of the document according to the comments / reasons for rejection. All corrected documents shall be resubmitted before starting the manufacturing. Vendor/Sub-Contractor shall not proceed with subsequent works of Material Supply or Manufacturing until receiving Code1/Code2 or No Code from PURCHASER. Vendor/Sub-Contractor shall resubmit the document with the same revision within 6 working days after receiving comments.
<b>No code</b>	<input type="checkbox"/> <b>No Code</b> ( Applicable Only for "For Information" Documents and "As Built DWGs") Document has been submitted for PURCHASER's Information (FI). Consistency, completeness and correctness of document content is in Vendor/Sub-Contractor's responsibility.
Above checking results by EIED shall in no way relieve Vendor of any liability, obligation and responsibility out of the purchase order and the mutual agreement in writing.	
 Energy Industries Engineering & Design co.	<b>Date:</b> 17.Feb, 2025 <b>Dept.:</b> MA <b>Signature:</b> F.Hamooni

Please provide ITP according to attached sample ITP

04					
03					
02					
01					
00	21-Jan-25	IFA	N.B	F.T	A.M
<b>Rev.</b>	<b>DATE</b>	<b>PURPOSE OF ISSUE</b>	<b>PREPARED</b>	<b>CHECKED</b>	<b>APPROVED</b>





**Gachsaran Polymer Industries Company  
HDPE Plant**



SHEET: 3 OF 8

DATE: 21.Jan.2025



REV.: 00

BY : MO

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

**ITEM NO(S): PK6101**

1	<b>SCOPE</b>	This Inspection and Test plan covers all activities that will be carried out in design and fabrication of equipment.
2	<b>LEGEND OF THE TECHNICAL SURVEILLANCE</b>	<p>1) (H)= INSPECTION NOTIFICATION will be issued by manufacturer and inspection shall be performed at presence of notified party. Next fabrication stage is subject to acceptance of inspection. Vendor must notify parties (see inspection activity) of the dedicated inspection activity at least fifteen (15) days in advance.</p> <p>2) (SW)=10% OF TYPE/LOT WITNESSED. Action performed only on a certain number of pieces.</p> <p>3) (W)=WITNESSING. The Supplier shall inform the NOTIFIED PARTY of the date of the activity and the NOTIFIED PARTY reserves the right to witness the test. If the test is conducted at the notified date, the Supplier may proceed with the subsequent phase, even if the NOTIFIED did not witness the test. <span style="border: 1px solid red; padding: 2px;">MC:PIDMCO</span></p> <p>4) (R/A)=REVIEW OF TECHNICAL DOCUMENTS BEFORE COMMENCEMENT OF CONSTRUCTION. The technical documents shall be reviewed and approved before the commencement of construction</p> <p>5) (R )=REVIEW OF DOCUMENTS. Materials certificates, statement of compliance and reports of inspection and tests conducted by the Supplier shall be revised to assess their conformance with the requirements specified in the Code and Standards, Specifications and/or Purchase Order</p> <p>6) (D) = Vendor Inspection</p>
3	<b>Abbreviations</b>	O= Owner (GPIC)    C= Contractor (EIED)    V= Vendor (HSE/RHINE)    SV = Sub Vendor    TPI = Third Party Inspection on behalf of owner

Add:OWNER/MC

Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY				REMARKS	R E V
					SUB-VENDOR (SV)	VENDOR (V)	EIED(C)	O/TPI		

**A PROJECT PREPARATION**

A1	PRE INSPECTION MEETING				D	D	H	H		
A2	BASIC DESIGN DRAFT DOCUMENT LIST P&ID , LAY-OUT				H	H	R/A	R		
A3	KICK-OFF MEETING CUSTOMER DETAILED DESIGN				D	H	H	H		
A4	PREPARE FINAL DESIGN DOCUMENTS FOR APPROVAL				H	H	R/A	R		
A5	VENDOR DESIGN DOCUMENTS REVIEW				H	H	R/A	R	As per VPIS	

shall be attached to this ITP

**B MATERIAL SELECTION / SUBCONTRACTOR ORDERING**

B0	GENERAL	ALL ITEMS SUITABLE FOR AMBIENT TEMPERATURE / OUTDOOR ALL ITEMS TO BE CONFORM ZONE 2 GROUP IIB T3	MATERIAL SUPPLY FABRICATION SCHEDULE QA / QC		D	D	-	-		
B1	COMPRESSOR- MAYEKAWA (MYCOM) FACTORY	DETAILS AS PER COMPRESSOR QUALITY PLAN  MYCOM STANDARD Procedures	TEST REPORT : - Noise test - Vibration test - Performance test - Running test - Hydro test	MATERIAL CERTIFICATES	D	D	<del>R</del>	<del>R</del>		
B2	MAIN MOTOR	AS PER MANUFACTURER'S TEST PROCEDURES HAZARDUS AREA CERTIFICATES	TEST REPORT ( Manuf. Std ) - Unwitnessed routine test report		D	D	R	R		
B3	OIL PUMP- MAYEKAWA FACTORY	MYCOM MANUFACTURER STANDARD Test Procedure	TEST REPORT incl; Hydro test result and performance test result	MATERIAL CERTIFICATES	D	R	R	R		
B4	OIL PUMP MOTOR	MANUFACTURER STANDARD HAZARDOUS AREA CERTIFICATE	TEST REPORT ( Manuf. Std ) - Unwitnessed routine test report		D	R	R	R		
B5	MAIN COUPLING	API671 with Deviation (Flexible disc type coupling)	SUITABLE FOR HAZARDOUS AREA	MATERIAL CERTIFICATES	D	R	R	R		

**NOTE :** **CERTIFIED COMPLETE:** **ENDORSEMENTS:**



**Gachsaran Polymer Industries Company  
HDPE Plant**



SHEET: 4 OF 8

DATE: 21.Jan.2025



REV.: 00

BY : MO

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

**ITEM NO(S): PK6101**

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2	<b>LEGEND OF THE TECHNICAL SURVEILLANCE</b>	<p>1) (H)= INSPECTION NOTIFICATION will be issued by manufacturer and inspection shall be performed at presence of notified party. Next fabrication stage is subject to acceptance of inspection. Vendor must notify parties (see inspection activity) of the dedicated inspection activity at least fifteen (15) days in advance.</p> <p>2) (SW)=10% OF TYPE/LOT WITNESSED. Action performed only on a certain number of pieces.</p> <p>3) (W)=WITNESSING. The Supplier shall inform the NOTIFIED PARTY of the date of the activity and the NOTIFIED PARTY reserves the right to witness the test. If the test is conducted at the notified date, the Supplier may proceed with the subsequent phase, even if the NOTIFIED did not witness the test.</p> <p>4) (R/A)=REVIEW OF TECHNICAL DOCUMENTS BEFORE COMMENCEMENT OF CONSTRUCTION. The technical documents shall be reviewed and approved before the commencement of construction</p> <p>5) (R )=REVIEW OF DOCUMENTS. Materials certificates, statement of compliance and reports of inspection and tests conducted by the Supplier shall be revised to assess their conformance with the requirements specified in the Code and Standards, Specifications and/or Purchase Order.</p> <p>6) (D) = Vendor Inspection</p>
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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY				REMARKS	R E V
					SUB-VENDOR (SV)	VENDOR (V)	EIED(C)	O/TPI		

**B MATERIAL SELECTION / SUBCONTRACTOR ORDERING (CONTINUE)**

B6	RECEIVER	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) (Welding_Standard)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) PAINTING INSPECTION DIMENSIONAL CHECK HYDROSTATIC TEST	VD-GPIC-MA-3029-3029-0024	H	H	R	R		
	OIL SEPARATOR (WITH COALESCERS)	ASME VIII DIV 1 (U-STAMP NOT REQUIRED)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) DIMENSIONAL CHECK HYDROSTATIC TEST PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0024	H	W	R	R		
	OIL FILTER	ASME VIII DIV 1 (U-STAMP NOT REQUIRED)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS NDE REPORTS CLEANLINESS TREATMENT INTERNAL INSPECTION (Visual Examination) VISUAL CHECK DIMENSIONAL CHECK HYDROSTATIC TEST PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0024	H	H	R	R		
			MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS		H	W	R	R		



**Gach saran Polymer Industries Company  
HDPE Plant**



SHEET: 5 OF 8

DATE: 21.Jan.2025



REV.: 00

BY : MO

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

**ITEM NO(S): PK6101**

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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY				REMARKS	REV
					SUB-VENDOR (SV)	VENDOR (V)	EIED(C)	O/TPI		

**B MATERIAL SELECTION / SUBCONTRACTOR ORDERING (CONTINUE)**

B7	HEAT EXCHANGERS 1. CONDENSER 2. OIL COOLER 3. ECONOMIZER 4. CHILLER (EVAPORATOR)	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) TEMA	WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0027	H	H	R	R		
			DIMENSIONAL CHECK		H	H	W	W		
			HYDROSTATIC TEST		H	H	H	H		
B8	BASE FRAME	MANUFACTURER STANDARD Design Suitable for This Series of Compressor	PT -10 % OF MAJOR STRUCTURAL CONNECTIONS 100 % PT LIFTING LUG WELDS 100 % RT BUTT WELDS IN MAJOR SUPPORTING BEAMS	ACC. Vendor DATASHEET/DRAWING  SKID CONNECTION POINTS – ANCHOR BOLT POSITIONS  INSPECTION /CERTIFICATE	D	R	R	R		
B9	VALVES	ASME/MFR STD For Special Valves	MATERIAL CERTIFICATES 3.1 FOR MAJOR PARTS HYDROSTATIC REPORT PAINTING INSPECTION	ACC. Vendor DATASHEET/DRAWING  INSPECTION /CERTIFICATE	D	R	R	R		
B10	PIPING	ASTM	1) CARBON OIL AND REFRIGERANT PIPING 10% . 2) SS Oil AND REFRIGERANT PIPING 10% . 3) INSTRUMENT AIR HEADER 10% . AMOUNT WILL BE BASED ON TOTAL AMOUNT OF WELDED INCHES.	MATERIAL CERTIFICATES	D	R	R	R		
B11	SAFETY VALVES	ASME VIII DIV 1 without U-Stamp	MATERIAL CERTIFICATES 2.2 SET PRESSURE TEST REPORT CALCULATIONS TEST REPORT	INSPECTION CERTIFICATE VD-GPIC-MA-3029-3029-0041	D	R	R	R		
B12	Smaller components within instrumentation routing, such as TUBING AND GASKETS and bolting .		MATERIAL CERTIFICATES 3.1	INSPECTION CERTIFICATE	D	R	R	R		
B13	INSTRUMENTATION	Pressure, Temperature and Level Guages and Transmitters are provided with 2.2 material certificates.	MATERIAL CERTIFICATES 2.2 HAZARDOUS AREA CERTIFICATE CALIBRATION REPORT	INSPECTION CERTIFICATE VD-GPIC-MA-3029-3029-0038	D	R	R	R		

**NOTE :** **CERTIFIED COMPLETE:** **ENDORSEMENTS:**



**Gachsaran Polymer Industries Company  
HDPE Plant**



SHEET: 6 OF 8

DATE: 21.Jan.2025

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**



REV.: 00

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

BY : MO

**ITEM NO(S): PK6101**

1	<b>SCOPE</b>	This Inspection and Test plan covers all activities that will be carried out in design and fabrication of equipment.
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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY				REMARKS	R E V
					SUB-VENDOR (SV)	VENDOR (V)	EIED(C)	O/TPI		

**C SUBVENDOR INSPECTION DOCUMENTS, PIPING**

C1	WELDING DOCUMENTS (WPS/PQR/WELD MAP)	ASME VIII Div 1, ASME IX Not Applicable			R/A	R	-	-		
C2	WELDER'S QUALIFICATION	ASME IX	CERTIFICATES		R/A	R	R	R		
C3	NDE PROCEDURES (UT/RT/MT/PT/HT)	ASME V 1) Carbon oil and refrigerant piping 10% . 2) SS Oil and refrigerant piping 10%. 3) Instrument air header 10% . Amount will be based on total amount of welded inches.	NDT Map		R/A	R	R/A	R		
C4	NDT OPERATORS AND INTERPRETERS QUALIFICATION	ASME V	CERTIFICATES		R/A	R	R	R		
C5	LEAK TEST PROCEDURE (PNEUMATIC AND/OR HYDRAULIC)	ASME VIII DIV. 1	MANUFACTURING STANDARD		R	R	R	R		
C6	MYCOM STANDARD / VENDOR PROCEDURES COATING PROCEDURE	MYCOM STANDARD / VENDOR PAINTING PROCEDURE		VD-GPIC-MA-3029-3029-0063	R	R	R	R		
C7	RUST PRESERVATION PROCEDURE	MANUFACTURER STANDARD			R	R	R	R		

NOTE : CERTIFIED COMPLETE: ENDORSEMENTS:





**Gachsaran Polymer Industries Company  
HDPE Plant**



SHEET: 8 OF 8

DATE: 21.Jan.2025

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**



REV.: 00

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

BY : MO

**ITEM NO(S): PK6101**

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**E INSPECTION (CONTINUE)**

E3	PMI TEST (WELDS)	According to weld-NDT Map (If applicable)	INSPECTION CERTIFICATE	ASTM	D	W	SW	SW	Time period of PMI will be informed.No specific dates are consider to be informed in advance by Vendor	
E4	PAINTING	MYCOM STANDARD / VENDOR PAINTING PROCEDURE	THICKNESS VISUAL INSPECTION AND MEASUREMENT VIA INSTRUMENT. PAINT INSPECTION REPORT	VD-GPIC-MA-3029-3029-0063	D	W	R	W		
E5	INSTRUMENT WIRING	MANUFACTURER STANDARD	Instrument, Junction Box and Local Control Panel location and Cable Routing Layout	VD-GPIC-MA-3029-3029-0047	D	W	R	R		
E6	INSPECTION OF JUCTION BOX, LOCAL PANEL AND PLC	FACTORY ACCEPTANCE TEST FOR PLC 1) VISUAL INSPECTION JUNCTION BOX, LOCAL PANEL AND PLC 2) CONTINUITY, POWER UP & WET LOOP CHECK 3) FUNCTION TEST ( REDUNDANCY, LOGIC)	TEST REPORT FAT TEST PROCEDURE	VD-GPIC-MA-3029-3029-0037	D	W	W	W		
E7	RUST PREVENTION FOR STORAGE	VENDOR STANDARD	NITROGEN CHARGING -0.5 BAR	VD-GPIC-MA-3029-3029-0007	D	D	R	R		
E8	FINAL INSPECTION		NAME PLATES CONFIRMATION	RELEASE NOTE	D	H	H	H		
E9	APPROVAL OF CONCESSION REQUEST AND NON-CONFORMANCE REPORTS				D	R	R/A	R/A		

**F SHIPMENT AND LOADING**

F1	PACKING AND MARKING PREPARATION FOR SHIPMENT DETAILED PACKING LIST AND LOOSE DELIVERY LIST	PACKING INSPECTION	PACKING INSPECTION: VISUAL INSPECTION COMPLETENESS CHECK PACKING LIST	VD-GPIC-MA-3029-3029-0007	D	H	R	R		
F2	DOCUMENTATION	AS PER APPROVED VPIS INCLUDING FINAL DATA BOOK, ITP, ETC.	A COMPLETE PACKAGE OF INSPECTION AND TEST RECORD/CERTIFICATE MANUFACTURED RECORD	VPIS & REPORTS	D	R/A	R/A	R/A		

NOTE : CERTIFIED COMPLETE: ENDORSEMENTS: