

SUPPLIER/CONTRACTOR COVER SHEET



P1000 Pilgangoora Expansion Project

DOCUMENT DETAILS

PO / CONTRACT NUMBER	CONTR V2325		
SUPPLIER / CONTRACTOR:	Control Systems Technology		
SDRL CODE:	G01	REVISION:	C
DOCUMENT NUMBER:	P1000-V2325-G01-001	REVISION DATE:	15/11/23
DOCUMENT DESCRIPTION:	Inspection Test Plan		

PLS DOCUMENT REVIEW STAMP

Document Number	P1000-V2325-G01-001
Revision	C
Accepted	
Mr Sam Dalais - Pilbara Minerals Limited	
Nov 24, 2023, 8:40 AM GMT+8:00	

Review of the document does not relieve the Contractor/Supplier of its responsibility for the due and proper performance of the Works in accordance with the Contract.

ADDITIONAL COMMENTS

Inspection and Test Plan Beltweigher Manufacture

ITP for Job No.	Purchase Order No.	Project: Pilgangoora Tantalum-Lithium	Customer: Pilbara Minerals
33969	2037437	Description 1 x PCS2 253-WT-601	End User: Pilgangoora Operations

Task no & Date	Task Description	Loc Code	Inspection and Test Activity	Applicable document procedure	Acceptance Criteria	Verifying document	Inspection and Verification			
							CST		Client	
							Activity	Sign	Activity	Sign
1	System Configuration	D	Check purchase order/contract reflects proposal/sales handover form and enter requirements in job and manufacturing tab. Ensure customer specifications, data sheets and drawings are obtained in order to design appropriate equipment.	PRO-D-002 Contract Rev.	Customer spec, CST design spreadsheets updated and entered into job, manuf. tab reflects all equipment to be supplied.	ITP – this document, copies of documents found in job and entries into CST Jungle database system.	R			
2	Customer drawings	D	Check General Arrangement and Electrical drawings are as per system configuration.	PRO-A-002 Doc. & Data Control	CST design spreadsheets & equipment data sheets	Customer Approved Drawings (minimum status "approved as noted")	H		R	
3	Welder Procedures and qualifications (Client to advise NDT requirements)	A	Ensure CST standard weld procedures have been accepted by client, including standard CST practice of only 100% visual (client to advise additional NDT)	AS/NZ 1554.1.2014 Category SP	CST Weld procedures WPS CST-C-01/11 & CST-C-02/11(A) & (B)	Customer approval of procedures and	H			
4	Manufacturing Drawings Note: these drawings are proprietary and not required to be approved by client	D	Ensure detail drawings for manufacture have been checked for errors – CST internal Squad Check	PRO-E-001 Design Mech.	Squad checking procedure	Drawings signed off for issuing to factory	R			
5	Procurement	M	Delivery Inspection of any non stock items.	PRO-H-001 Receiving I&T	Delivery docket as per CST order and	Signed off delivery documents	D,V			

<p>Location Code</p> <p>A - Administration M - Mechanical Shop E - Electrical Shop O - Outside Supplier D - Design Office</p>	<p style="text-align: center;">Inspection and Verification Code</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none;">W - Witness Point</td> <td style="width: 50%; border: none;">F - Functional Test</td> </tr> <tr> <td style="border: none;">H - Hold</td> <td style="border: none;">S - Soak Test</td> </tr> <tr> <td style="border: none;">D - Dimensional Inspection</td> <td style="border: none;">R - Review and Approve – CST</td> </tr> <tr> <td style="border: none;">V - Visual Inspection</td> <td style="border: none;">A - Review and Approve –Buyer</td> </tr> <tr> <td style="border: none;">M - Monitor progress</td> <td style="border: none;"></td> </tr> </table>	W - Witness Point	F - Functional Test	H - Hold	S - Soak Test	D - Dimensional Inspection	R - Review and Approve – CST	V - Visual Inspection	A - Review and Approve –Buyer	M - Monitor progress	
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Inspection and Test Plan Beltweigher Manufacture

ITP for Job No.	Purchase Order No.	Project: Pilgangoora Tantalum-Lithium	Customer: Pilbara Minerals
33969	2037437	Description 1 x PCS2 253-WT-601	End User: Pilgangoora Operations

No.	Location	Code	Description	Process	Inspection Requirements	Material Register & Certificates	Witness	Hold	Dimensional	Visual	Monitor
			Steel, profiles, load cells, enclosures, rolls.		inspection requirements from procedure	Material Register & Certificates					
6	Manufacturing - Mechanical	M	Initial Assembly check – check hole locations and parts fit as per General Arrangement	PRO-G-001 Process cont.	GA & Manuf. Drawings	A1 check sheet signed off. Material register & Certs	D, V				
7	Manufacturing - Mechanical	M	Assembly check after welding – 100% visual check of all welds, and recheck hole locations and parts fit.	PRO-H-002 In Process I&T.	GA & Manuf. Drawings AS1554.	Check Manuf. Dwgs QA boxes & sign off A2 check sheet	D,V				
8	Testing – Electronics (FAT)	E	Test operation, I/O and comms (as applicable) with simulated tacho and load cells - FAT.	PRO-H-002 In Process I&T 08021790.doc	Electrical drawing & WIM check sheet	Sign off on WIM check sheet 09510091.doc	F,S				
9	Manufacturing - Electronics	E	Check assembly of stock and bought in components.	PRO-G-001 Process cont.	Electrical and enclosure Drawings	Sign off on WIM check sheet 09510091.doc	V				
10	Surface Finish	O	Inspect Surface Finish – check paint/galvanising QA sheet meets requirement as specified.	PRO-H-001 Receiving I&T	Paint to Spec PIL-20000-STS-ST-001	Paint/Galvaniser Contractor QA sheet	W				
11	Certification of Calibration Weights	M	Certify Weights & Record Serial No.	PRO-H-002 In Process I&T	Weights certified within 0.1%	NATA Certified Certificate.	V				
12	Final Inspection	M	Returned goods from finishing to be checked as per approved Finishing Procedure Buy-off sheet JC-S-002. Check Fits and Clearances	PRO-H-003 Final I & T	All threads free running, all clearances as per CST Dwgs.	Signed Finishing procedure sheet JC-S-002 -WTS-FOR-052 IRC issuance	F,V			H	

Location Code	Inspection and Verification Code
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13	Packing and Shipping	M	Check BOM against Packing List	PRO-J-001 Handling, Store	Assembly Dwg	CST Packing List & Photos	H		R	
14	QA, Documentation	A	Scan all Check sheets, Cutting lists & Job cards into Jungle.	PRO-G-001 Process Control,	All completed	ITP (mech.) – This document Complete MDR	R		A	

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