Document Cover Sheet

Iron Bridge Project - SMPEI

Supplier/Subcontractor:	THEJO
Package/PO No:	PP010

Document Title:	Inspection and Test Plan - Installation of Fabric Conveyor Belts (THEJO)		
Supplier Document No:	THJ_FRM_410_CIV_IB2	**Revision:**	0
Civmec Document No:	C292-PP010-ITP-0002	**Revision:**	0
Client No:	662NSC2002-2000-IT-QA-0039	**Revision:**	0
Date:	01/11/2022		

Document Review Status

☒	**Reviewed:** No comments, subject to client's approval	**RVD**
☐	**Revise & Resubmit**: Revise as noted, work may proceed subject to incorporation of changes indicated	**RAR**
☐	**Do Not Proceed:** Revise and Resubmit, work may not proceed	**DNP**
☐	**Information:** Does not require Civmec approval; issued for information only	**INF**

Review of the document does not relieve the Supplier/Subcontractor of their responsibility for the due and proper performance of the Works in accordance with the Contract/Purchase Order.

Signed for Civmec: _____ **Date:** 01/11/2022

Name: Marcel Captuiex

Position: QC Inspector

End Client Document Review Stamp

Next Issue at Civmec Revision: _____ **Due by:** _____

CLIENT NAME:	**CIVMEC – Iron Bridge Project**	**DESCRIPTION:**	**Installation of Fabric Conveyor Belts at FMG Ironbridge**
CLIENT CONTACT:	Martin Thorpe		
SITE:	FMG - Ironbridge		
CONTRACT NUMBER:	C292-CM-AGR-010	DATE:	09/09/2022

SUMMARY OF REQUIREMENTS:		
Process Qualifications:		
Belt Splicing Procedures:		100-SP-ME-0004
Belt Installation Procedures:		Thejo Australia WIN Document
Traceability:		
Material		100-SP-ME-0004 FMG Supplied
Consumable (splice kit)		100-SP-ME-0004 FMG Supplied
Splice ID		100-SP-ME-0004

INSPECTION KEY:	
Surveillance	S
Monitor	M
Review	RV
Hold	H
Record	RC
Witness	W

RESPONSIBLE PERSON KEY:	
Field Supervisor	FS
Client:	
Client Engineer	CE
Client Inspector	CI
Quality Inspector	QC

Item	Process Activity	Controlling Document	Standard, Spec or Drawing	Verifying Document / Report	Thejo			Civmec			FMG	Remarks
					Resp. Person	Insp	Sign & Date	Resp. Person	Insp	Sign & Date	Sign & Date	
1.0	**Materials Receipt**											
1.1	Inspect Conveyor belting and splice kits • Belt dimensions to spec. • Ensure kits dimensions correct for splice. • Ensure splice kit is in date and unused. • No damage.	100-SP-ME-004 100-SP-ME-006 AS1332	AS1332 - Appendix A CMH Splice Diagrams CMH-IB-016 FMG – 100-SP-ME-0004- 5.13 FMG-100-SP-ME0006 - 6.3.2	FMG – 45-13004-TE-ME-0002 Signed ITP	FS	W		CE CI	S			

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1.2	Ensure splice kits stored as per manufacturers specifications under correct temperature and conditions.	100-SP-ME-004 662NSP2041-IM-QA-0002 Sect 4.1	CMH Splice Diagrams CMH-IB-016 662NSP2041-IM-QA-0002 Sect 4.1	FMG – 45-13004-TE-ME-0002 Signed ITP	FS	W		CE CI	S			
2.0	**Approvals**											
2.1	Check all tagging and certification of equipment. (Vulcanising Presses, Single use Thermocouples, Data Loggers) Ensure equipment is maintained and in safe working order.	100-SP-ME-004 100-ST-QA-002 TAPL Equipment Check List / Prestart Documentation	100-SP-ME-0004 Sect 5.13 100-ST-QA-0002-6.9	Equipment Register / Calibration Certificates	FS	H		CE CI	HR			Vulcanising presses shall be calibrated in accordance with manufacturers' recommendations
2.2	Belt Installation Procedure and splice design approved by client.	TAPL WIN Document FMG – 45-13004-TE-ME-0002 662NSP2041-0000-IM-QA-0002	CMH Splice Diagrams CMH-IB-016 FMG – 100-SP-ME-0004 662NSP2041-0000-IM-QA-0002 Sect 3.5	FMG – 45-13004-TE-ME-0002	FS	H		CE CI	H			
3.0	**Pull on Conveyor Belt**											
3.1	Conveyor signed off for belt Pull	Civmec Conveyor ITP C292-QU-ITP-005	FMG – 100-SP-ME-0004	Civmec Conveyor ITP C292-QU-ITP-005 Sec 11.1	FS	H		CE CI	H			Pre walk of system and sign off to commence belt install
3.2	Ensure pull ratios suit winch operation.	Thejo Australia Installation WIN	TAPL Belt Pull Calculation	TAPL Belt Pull Calculation	FS	W		CE CI	S			

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3.3	Ensure winch and anchor points in place.	Thejo Australia Installation WIN	Thejo Australia Installation WIN	THJ_FRM049 Belt Movement Checklist	FS	W		CE CI	S			
3.4	Confirm correct direction of travel. Ensure cable runs over rollers. Check belt orientation. Care and prevention of damage to idlers, pulleys and conveyor equipment.	Thejo Australia Installation WIN	Thejo Australia Installation WIN, Pre belt pull Checklist	Thejo Australia Installation WIN, THJ_FRM049 Belt Movement Checklist	FS	W		CE CI	S			
3.5	Set up Conveyor roll in belt stand. • Ensure correct direction of travel and belt covers. • Ensure shaft size for the roll belt.	Thejo Australia Installation WIN	Thejo Australia Installation WIN	Thejo Australia Installation WIN, THJ_FRM049 Belt Movement Checklist	FS	W		CE CI	R			
3.6	Attached winch cable to conveyor for pull. • Ensure correct direction of pulling plate and sling. • Ensure correct pulling plate is selected (refer to belt pulling calculation). • Check thimble winch rope for damage.	Thejo Australia Installation WIN	Thejo Australia Installation WIN	Thejo Australia Installation WIN, THJ_FRM049 Belt Movement Checklist	FS	W		CE CI	S			

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3.7	Pull Conveyor onto system. • Ensure correctly rated winch for pull. • Ensure pulling crew briefed on procedure* • Ensure 2-way communication working. • Ensure spotter follows belt end during pull. • Ensure all scrapers backed off. • Ensure conveyor brakes and / or holdbacks are released • Ensure drive pulley is turning in direction of pull. • Ensure minimum belt radius is maintained. • Ensure belt tracks within idlers. • For Aerobelt 800, talcum powder to be used if dry pull encounters issues.	Thejo Australia Installation WIN	Thejo Australia Installation WIN	Thejo Australia Installation WIN, THJ_FRM049 Belt Movement Checklist	FS	W		CE CI	S			Each Splice shall be marked with unique number on both sides of Belt prior to tensioning. Edges of each splice shall be marked on each side of belt to allow splice length measurements to be taken.
4.0	**Set Up for Splicing**											
4.1	Prepare Splicing area. • Vulcaniser beams, access and tables erected and secured. • Safe access and walkways provided. • Protection against dust and weather elements. • Equipment available for control and humidity. • Framework and scaffolding for covers in place.	100-SP-ME-004 100-SP-ME-006	Belt Manufacturers Installation Manual FMG-100-SP-006-6.3.2	FMG – 45-13004-TE-ME-0002	FS	W		CE CI	S			

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4.2	Assemble Vulcaniser, Set up splice. • Check environmental conditions. • Check humidity. • Safety check / MSDS. • Prepare workstation including tables and Vulcanising beams. • Position belts mark and mark out.	100-SP-ME0004		FMG – 45-13004-TE-ME-0002	FS	W		CE CI	S			
4.3	Prepare Belt Ends. • Belt end in position. • Strip cords and prep skives. • Buff skives. • Ensure covers clean. • Check splice drawing. • Check step lengths. • Check weather elements before proceeding. • Cut cords. • Test Samples to be done	100-SP-ME0004	CMH Technical & Splice Diagrams CMH-IB-016 FMG-100-SP-ME-0004 – CL 5.13.2 AS1333 Appendix	FMG – 45-13004-TE-ME-0002	FS	H		CE CI	S			
4.4	Prep Belt. • Check humidity. • Check cords coated to splice specs. • Check alignment. • Check belt clamps.	100-SP-ME0004	CMH Technical & Splice Diagrams CMH-IB-016	FMG – 45-13004-TE-ME-0002	FS	H		CE CI	S			
4.5	Layup. • Check alignment and layup. • Check layup procedures. • Carry out visual inspections/ measurement checks.	100-SP-ME0004	CMH Technical & Splice Diagrams CMH-IB-016	FMG – 45-13004-TE-ME-0002	FS	H		CE CI	H			

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4.6	Cook Belt. • Check edge bars of correct thickness and placing. • Check assembly of heating plates. • Check distribution plates. • Check safety water fittings and pump. • Check electrical connections. • Assemble beams and bolts. • Check safety equipment. • Check pumps. • Check thermos leads. • Confirm Vulcaniser assembly. • Vulcanise to splice spec – temperature, pressure and time. • Record all times, temps and pressure. • Belt marking and splice number included in splice	100-SP-ME0004	CMH Technical & Splice Diagrams CMH-IB-016 FMG-100-SP-ME-0004 Sect 5	FMG – 45-13004-TE-ME-0002	FS	H		CE CI	W R			
4.7	Cool down Vulcaniser and remove from system. • Check top and bottom covers of splice (QA). • Check skives and buff all skives. • Durometer reading.	100-SP-ME-0004 100-SP-ME-0006	CMH Technical & Splice Diagrams CMH-IB-016 FMG-100-SP-ME-0004 Sect 5	FMG – 45-13004-TE-ME-0002 Compliant Durometer Reading record	FS	W		CE CI QC	W			Test Pieces to be tested and results recorded as compliant before the splice is accepted by FMG FMG-100-SP-ME-0004 – CL 5.13.2 AS1333 Appendix I

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5.0	**Final walk down – Construction Verification**											
5.1	Area clean and free of debris. Punch items identified and recorded Rectification of discrepancies complete. As-builts/redline mark ups accepted	FMG – 45-13004-TE-ME-0002	CMH-IB-016	This Document Signed off	FS	H		CE CI QC	H			
5.2	Document review and acceptance. • ITRs complete and all associated reference documents supplied • Identified punch items complete and closed out in PIMS. • All associated NCRs closed. • All associated TQs closed.	100-ST-QA-0001	Schedule of Works. 100-ST-QA0001 Sect 2.8	MDR	FS	R		CE CI QC	R			

Name	Signature	Date