Revision history				
Revision no.	**Date**	**Modifications**	**Issued by**	**Authorised by**
0	21.12.2021	Initial Issue	Sam Boniface	Richard Connor

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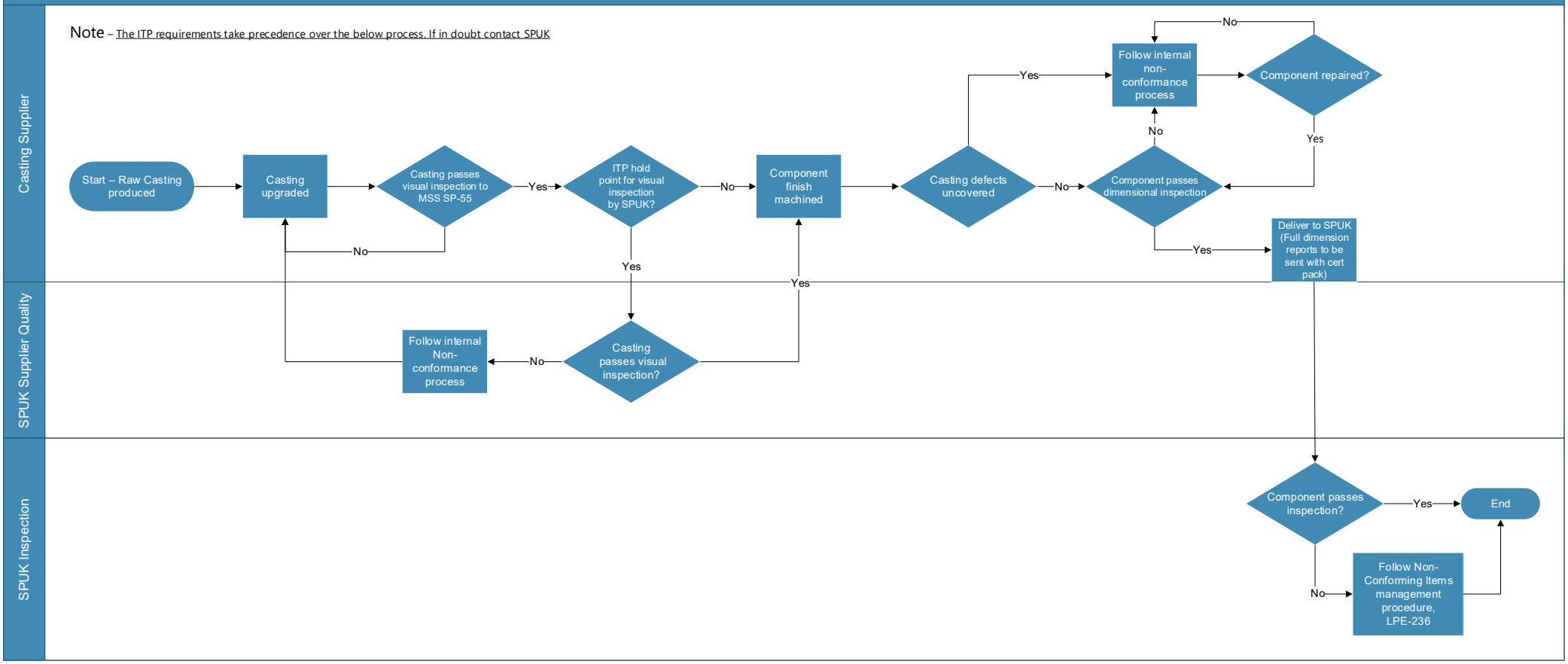
1 Scope

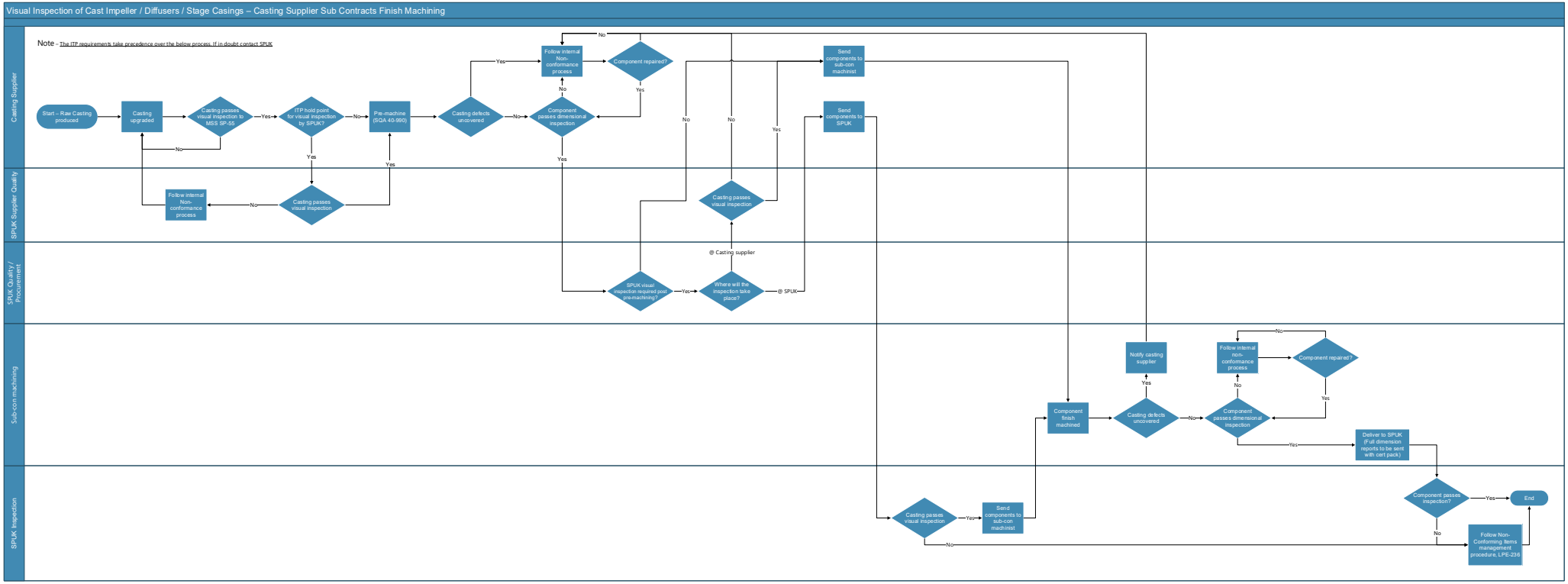
The purpose of this document is to illustrate the route for machining and inspection of castings that are supplied finish-machined to Sulzer.

2 Referenced Documents

MSS SP-55	Quality Standard for Steel Castings for Valves, Flanges, Fittings, and Other Piping Components - Visual Method for Evaluation of Surface Irregularities
SQA 40-990	Pre-Machining and Finish Machining of Impellers & Diffusers
LPE-236	Non-Conforming Items

Visual Inspection of Cast Impellers / Diffusers / Stage Casings – Casting Supplier To Finish Machine




Visual Inspection of Cast Impeller / Diffusers / Stage Casings – Casting Supplier Sub Contracts Finish Machining
Casting Supplier
SPUK Supplier Quality
SPUK Quality / Procurement
Sub-con machining
SPUK Inspection
Note - The ITP requirements take precedence over the below process. If in doubt contact SPUK
Start – Raw Casting produced
Casting upgraded
Casting passes visual inspection to MSS SP-55
ITP hold point for visual inspection by SPUK?
Pre-machine (SQA 45-990)
Casting defects uncovered
Component passes dimensional inspection
Follow internal Non-conformance process
Component repaired?
Send components to sub-con machinist
Send components to SPUK
Follow internal Non-conformance process
Casting passes visual inspection
Casting passes visual inspection
@ Casting supplier
SPUK visual inspection required post pre-machining?
Where will the inspection take place?
@ SPUK
Component finish machined
Casting defects uncovered
Notify casting supplier
Follow internal non-conformance process
Component repaired?
Component passes dimensional inspection
Deliver to SPUK (Full dimension reports to be sent with cert pack)
Casting passes visual inspection
Send components to sub-con machinist
Component passes inspection?
End
Follow Non-Conforming Items management procedure, LPE-236