



QUALITY PLAN

PRODUCT : GALVANISED STEEL POLES
 CUSTOMER :
 PURCHASE ORDER NO :
 NO OF PAGES : 1
 PREPARED BY : Dr. İlhami Pektaş

CUSTOMER APPROVAL	DISTRIBUTION	APPROVAL
		MITASPOLE INC.

PROCESS CYCLES		CONTROL CYCLES		CONTROL FREQUENCY	RESPONSIBLE	CONTROL INSTRUMENT	CONTROL METHOD	CONTROL PLACE	REACTION PLAN	REFERENCE	QUALITY REPORT	CUST.	
PROCESS	OPERATION	CONTROL CRITERIA											
1	RAW MATERIAL ACCEPTANCE	Incoming Steel Material Inspection	Dimensional Control	T 8.2.4-01	Quality Inspectors	Steel Tape, Calliper	Measurement	Raw Mat. Storage Area " Suppliers Facility and/or Independent Mechanic / Chem.Labratory	Incoming Material Quality Control Instruction T 8.2.4-01 T 8.2.4-08	EN 10025	Inspection Report Quality Certificates, Mechanical Test Reports, EN 10204	R	
			Visual Inspection			Inspection	W						
			Chemical Tests			Chemical Test							
			Yield Strength			Mech. Test							
			Tensile Strength			Mech. Test							
			Impact test			Mech. Test							
			Elongation %			Mech. Test							
			Material Test Certificates				D						
		R,D											
2	MANUFACTURING	Cutting Bending Flanges Assessorios Final Inspection	Length, Width, Hole Positions	T 8.2.4-02	Quality Inspectors	Steel Tape, Calliper, Micrometer	Measurement	Production Line	T 7.5.1-02-01, T 7.5.1-02-02, T 7.5.1-02-03, T 7.5.1-02-09, T 8.2.4-02/04	Production Cards, Drawings, Production Process Control Instruction	Dimensional Control Records 8.2.4-10 / 16	D	
			Bending Position, Bending Angle				Measurement					FP	
			Hole Diameter, Hole Position				Measurement					M,R	
			Dimension, Position, Angle				Measurement						
			Dimension, Position, Angle				Measurement						
3	WELDING	Tag Welding Longitudinal and Circumferential Welding Grinding NDT tests	Dimensions, Angle, Straightness, Flatness, Visual Inspection	T 8.2.4-02	Quality Inspectors	Steel Tape, Vernier, Protractor Combination Set	Measurement and Inspection	Production Line	T 7.5.1-02-05, T 7.5.1-02-06, T 7.5.1.02-07, T 8.2.4-04	EN 1011-1, 2 EN 287-1,2 EN 288-2 EN 5817 EN 1290	WPS, Control Records, FP 8.2.4-10, FP 8.2.4-12 FP 8.2.4-17/18/19	D	
			Visual Inspection										M
			Integrity of welds									M, P and Ultrasonic	R
4	GALVANIZING	Loading Surface Preparation Hot Dip Galvanising Unloading and Stacking Straightening Final Inspection	Visual Inspection	T 8.2.4-06 T 7.5.1-02-08	Quality Inspectors	Visual Inspection Micrometer Preece Test Visual Inspection Rope, Callipers Visual Inspection	Inspection Measurement Measurement Inspection Inspection	Galvanising Line	T 8.2.4-06	EN ISO 1461 ASTM A 123/153	Register of Coating Thickness / FP 8.2.4-12	D	
			Thickness of Coating										
			Adherence of Coating										
			Correctitude of Stacks										
			Dimensional Control										
			Visual Inspection										
5	PACKING&DELIVERY	Packing Final Inspection Delivery	Correctitude of Bundles	T 8.2.4-09/10	Quality Inspectors	Visual Inspection	Inspection	Packing and Delivery	T 8.2.4-09	Cusm. Spect. EN 40-5 8.2.4-09	FP 7.5.5-03 Package List, FP 8.2.4-09 Inspection Report,	VIS	
			Final Inspection									R	
			Visual Inspection									M	
6	FINAL INSP. and DOC.	Final Records and QA	Documentation Control	T 8.2.4-09	Quality Inspectors	Visual,Meter,Micrometer	Inspection		T 8.2.4-09	EN 40-5, FP 8.2.4-09	Mill Certificates, Inspector's Records	D	

Explanatories :

Key to Symbols : R is Review, W is Withness, H is Hold, D is Documentation, M is Monitor, DIM is Dimensional Control, VIS is Visual Inspection, T is Test.

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