

Title	Subject	Summary of Components			Material Thickness	CutSizeY	CutSizeX	Mass (Quantity)
		Revision	Quantity	Material				
BOLT HEX, M10 X 30, NYLOCNUT & WASHER	BUY OUT		2	Steel, Gr 4.6, e/galv				0.093 kg
CLEVIS SLING HOOK 8 MM	BUYOUT		1	Steel				0.580 kg
Straight grease nipple DIN 71412 A M8	Buyout		9	Steel				0.045 kg
Straight grease nipple DIN 71412 A M8	Buyout		4	Steel				0.020 kg
Conical grease nipple 45°, DIN 71412 B with square base M8	Buyout		2	Steel				0.021 kg
WASHER, FLAT, M10	B/O		4	Galvanized steel				0.008 kg
WASHER, FLAT, M16	BUYOUT		16	Galvanized steel				0.056 kg
WASHER, FLAT, M30	BUYOUT		6	Galvanized steel				0.302 kg
GREASE NIPPLE, M10, STRAIGHT	BUY OUT		2	Stainless Steel, 304				0.064 kg
BOLT, HEX, M16 X 70	BUY OUT		4	Steel, Gr 8.8, Black				0.534 kg
BOLT, HEX, M16 X 90	BUY OUT		2	Steel, Gr 8.8, Black				0.362 kg
Oval quick link 8	BUYOUT		1	Steel				0.097 kg
LOAD BINDER, CROSBY R10	BUYOUT		1	Steel, ASME B30.26				9.501 kg
MAIN SHAFT	CUT / MACHINE		1	Steel, BS970 EN 9				13.336 kg
BEARING	CUT / MACHINE		2	Steel, SAE 660, Ph Bronze				1.721 kg
PIPE #1	MACHINE		1	Steel, Pipe, ASTM A106 B				22.562 kg
OUTER DISC	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	201.00 mm	201.00 mm	1.466 kg
BEARING HOLDER	MACHINE		2	Steel, BS970 EN 3A BMS				1.892 kg
PIPE 32	MACHINE		1	Steel, Pipe, ASTM A106 B				24.837 kg
END PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	153.50 mm	153.50 mm	2.125 kg
HOLDER BASE	MACHINE		2	Steel, BS970 EN 3A BMS				1.411 kg
SHAFT CLAMP	MACHINE & FORM		2	Steel				0.261 kg
NYLOC, HEX, M10	BUYOUT		4	Steel, Gr 4.6, e/galv				0.057 kg
NYLOC, HEX, M16	BUYOUT		6	Steel, Gr 8.8, e/galv				0.226 kg
PIN, SPLIT, 4 X 30 MM	BUYOUT		3	Galvanized steel				0.013 kg
PIN, SPLIT, 8 X 50 MM	BUYOUT		3	Galvanized steel				0.086 kg
SCREW, CAP, M8 X 16	BUYOUT		2	Stainless Steel, 304				0.027 kg
SHORT LINK CHAIN 8 MM	CUT TO LENGTH		1	Steel, ASME B30.26				0.209 kg
BUSH	CUT / MACHINE		4	Steel, SAE 660, Ph Bronze				2.859 kg
GUSSET	PROFILE		8	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	80.00 mm	80.00 mm	1.428 kg
ROLLER BRACKET	PROFILE & FORM		2	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	250.00 mm	695.12 mm	21.072 kg
SHAFT, GREASE & LOCK	MACHINE		2	Steel, BS970 EN 3A BMS				6.837 kg
CLAMP PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	60.00 mm	92.70 mm	0.257 kg
IDLE ROLLER	WELD		2					29.839 kg
PIPE	MACHINE		2	Steel, Pipe, ASTM A106 B				16.921 kg
END PLATE	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	153.00 mm	153.00 mm	2.643 kg
BEARING HOLDER	MACHINE		2	Steel, BS970 EN 3A BMS				10.275 kg
DOOR HOOK	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	87.38 mm	449.47 mm	6.995 kg
DOOR HOOK, BOTTOM	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	116.47 mm	613.20 mm	5.555 kg
DOOR LOCK LINK ARM	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm			14.262 kg
PIVOT PIN	CUT / MACHINE		1	Steel, BS970 EN 3A BMS				0.083 kg
BINDER SUPPORT BUSH	MACHINE		2	Steel, BS970 EN 3A BMS				0.401 kg
RUBBER PROFILE	BUYOUT		1	Rubber, Nitrile				2.243 kg
SIDE SHELL RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	2993.72 mm	6046.52 mm	540.522 kg

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SIDE SHELL LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	2993.72 mm	6046.52 mm	540.522 kg
ROOF PLATE	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	1249.62 mm	6001.33 mm	236.450 kg
FRONT PLATE RIB	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	8.00 mm	493.84 mm	2223.00 mm	69.442 kg
SLIDE PLATE	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	848.53 mm	1993.03 mm	61.505 kg
PLATE SUPPORT	CUT & DRILL		2	Steel, EN 10025-2 S355JR				15.596 kg
DOOR PIN POSITION PLATE	PROFILE		3	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	100.00 mm	240.00 mm	5.547 kg
ROTATING PIN#1	CUT / MACHINE		3	Steel, BS970 EN 3A BMS				0.898 kg
REINFORCING RIB RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	364.69 mm	1224.39 mm	8.368 kg
REINFORCING HORIZONTAL RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	403.90 mm	1174.93 mm	16.471 kg
REINFORCING HORIZONTAL LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	403.90 mm	1174.93 mm	16.471 kg
REINFORCING RIB LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	364.69 mm	1224.39 mm	8.368 kg
LOCK ARM	CUT		1	Steel, EN 10219 Grade S355 JR				6.789 kg
LOCK ARM PLATE	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	110.00 mm	66.00 mm	0.579 kg
BOTTOM REINFORCING PLATE	PROFILE		18	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	250.00 mm	250.00 mm	37.528 kg
REINFORCING PLATE BOTTOM	PROFILE		16	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	200.00 mm	270.00 mm	25.545 kg
LOCK HANDLE BASE	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	8.00 mm	180.23 mm	237.48 mm	0.942 kg
DOOR SEAL PLATE #1	CUT & FORM		1	Steel, EN 10025-2 S235 JR	4.00 mm	15.00 mm	3237.52 mm	1.525 kg
DOOR SEAL PLATE #2	CUT & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	15.00 mm	3162.12 mm	1.496 kg
TUBE, SQUARE	CUT		1	Steel, EN 10219 Grade S355 JR				1.342 kg
CLOSURE PLATE	CUT		2	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	54.00 mm	54.00 mm	0.182 kg
POCKET LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	107.03 mm	436.35 mm	1.260 kg
POCKET RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	107.03 mm	436.35 mm	1.260 kg
ROOF LIFTING LUG	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	95.00 mm	95.00 mm	3.952 kg
FRONT LASHING LUG	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	90.00 mm	120.00 mm	3.324 kg
BOTTOM LOCKING LUG	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	115.00 mm	160.00 mm	4.109 kg
BOTTOM BEAM	CUT TO SUIT		2	Steel, EN 10219 Grade S355 JR				227.591 kg
FRONT VERTICAL BEAM	CUT TO SUIT		2	Steel, EN 10219 Grade S355 JR				87.010 kg
EAR POST, RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2459.00 mm	36.904 kg
REAR BOTTOM POST	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	509.89 mm	2390.00 mm	32.233 kg
REAR TOP POST	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	637.63 mm	2390.00 mm	37.984 kg
REAR POST, LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2459.00 mm	36.836 kg
PIVOT BUSH#1	PROFILE & FORM		5	Steel, BS970 EN 3A BMS				2.450 kg
STIFFENER BEAM	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	305.19 mm	2390.00 mm	24.966 kg
FLOOR RIB	PROFILE & FORM		9	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	1680.93 mm	272.93 mm	122.250 kg
RIB #2 POST RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2432.83 mm	45.641 kg
RIB #2 BOTTOM	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	500.95 mm	2337.67 mm	32.209 kg
RIB #2 TOP	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	618.15 mm	2337.67 mm	36.497 kg
RIB #2 POST LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2432.83 mm	45.429 kg
FLOOR PLATE #1	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1250.00 mm	3000.00 mm	147.806 kg
FLOOR PLATE #2	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1250.00 mm	2995.00 mm	147.560 kg
RIB #3 POST RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2408.92 mm	44.951 kg
RIB #3 BOTTOM	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	497.61 mm	2289.83 mm	31.492 kg
RIB #3 TOP	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	609.05 mm	2289.83 mm	35.505 kg
RIB #3 POST LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2408.92 mm	45.085 kg
RIB SET #4	GENERAL ARRANGEMENT		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2385.00 mm	44.413 kg

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RIB #4 POST RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	600.02 mm	2242.00 mm	34.518 kg
RIB #4 BOTTOM	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	630.19 mm	2385.00 mm	44.662 kg
FRONT POST RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1532.19 mm	2361.00 mm	135.037 kg
FRONT TOP POST	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	368.65 mm	2194.00 mm	25.437 kg
FRONT POST LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	416.76 mm	2194.00 mm	27.046 kg
FRONT BOTTOM POST	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1532.19 mm	2361.00 mm	135.046 kg
BEAM CLOSURE	PROFILE & FORM		6	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	90.00 mm	218.90 mm	4.667 kg
DOOR LIFT PLATE	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	60.00 mm	270.00 mm	1.401 kg
BEAM STIFFENER	PROFILE & FORM		2	Steel, EN 10025-2 S355 JR (HRP)	8.00 mm	161.00 mm	1766.84 mm	35.885 kg
CORNER INSERT, RH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	164.00 mm	253.63 mm	1.393 kg
CORNER INSERT LH	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	164.00 mm	253.63 mm	1.393 kg
RIB #4 TOP	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	494.34 mm	2242.00 mm	30.776 kg
CLAMP SHAFT	CUT / MACHINE		2	Steel, BS970 EN 3A BMS				1.427 kg
HOOK LIFT CHANNEL	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	335.58 mm	1002.00 mm	31.773 kg
HOOK LIFT GUSSET	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	20.00 mm	355.00 mm	575.00 mm	31.558 kg
FIXED BUSH	MACHINE		2	Steel, BS970 EN 3A BMS				19.542 kg
ROTATING BAR	CUT / MACHINE		1	Steel, BS970 EN 9				13.254 kg
BACKING PLATE	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	250.00 mm	500.00 mm	15.300 kg
BUSH GUSSET	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	115.00 mm	150.00 mm	1.739 kg
ROTATING BAR COLLAR	CUT / MACHINE		2	Steel, BS970 EN 3A BMS				1.033 kg
HOOK PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	20.00 mm	320.00 mm	700.00 mm	35.602 kg
HOOK PLATE FILLER LH	PROFILE & FORM		2	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	786.19 mm	131.92 mm	6.124 kg
HOOK PLATE FILLER RH	PROFILE & FORM		2	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	131.92 mm	786.19 mm	6.124 kg
STOPPER BLOCK	CUT		2	Steel, EN 10025-2 S355 JR (HRP)	20.00 mm	40.00 mm	80.00 mm	1.009 kg
BOTTOM ANGLE	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	8.00 mm	237.31 mm	2190.00 mm	32.948 kg
BOTTOM LIP	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	8.00 mm	189.83 mm	2190.00 mm	26.305 kg
DOOR POST HINGE SIDE	CUT		1	Steel, EN 10219 Grade S355 JR				41.533 kg
DOOR POST WITH LOCK PINS	CUT & MACHINE		1	Steel, EN 10219 Grade S355 JR				41.319 kg
TOP STRONG BACK	CUT		2	Steel, EN 10219 Grade S355 JR				74.429 kg
SLIDE PLATE, OUTER	CUT		2	Steel, EN 10025-2 S355 JR (HRP)	20.00 mm	40.00 mm	2229.00 mm	28.114 kg
SLIDE PLATE, INNER	CUT		2	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	40.00 mm	2150.00 mm	21.694 kg
DOOR BACKING PLATE	CUT		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	642.00 mm	2110.00 mm	42.714 kg
STRONG BACK LINK PLATE	CUT		3	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	100.00 mm	100.00 mm	2.328 kg
DOOR HOLD PIN	CUT / MACHINE		3	Steel, BS970 EN 9				2.708 kg
DOOR HOLD HEAD	CUT / MACHINE		3	Steel, BS970 EN 3A BMS				0.284 kg
POST CLOSURE PLATE	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	86.00 mm	86.00 mm	1.393 kg
STRONG BACK CLOSURE PLATE	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	86.00 mm	125.00 mm	1.352 kg
BOTTOM LOCK ROUND	CUT / MACHINE		2	Steel, BS970 EN 3A BMS				0.491 kg
DOOR HINGE PLATES	PROFILE		6	Steel, EN 10025-2 S235 JR	40.00 mm	45.00 mm	80.00 mm	5.172 kg
DOOR HINGE BUSH	CUT / MACHINE		6	Steel, BS970 EN 3A BMS				2.542 kg
HINGE BUSH	CUT / MACHINE		3	Steel, BS970 EN 3A BMS				2.234 kg
HINGE BASE	PROFILE & FORM		3	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	80.00 mm	275.57 mm	6.278 kg
HINGE PIN	CUT / MACHINE		3	Steel, BS970 EN 3A BMS				1.798 kg
HINGE HEAD	CUT / MACHINE		3	Steel, BS970 EN 3A BMS				0.213 kg
BACKING PLATE	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1792.00 mm	2170.00 mm	153.271 kg

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BOTTOM CHANNEL	PROFILE & FORM		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	2170.00 mm	220.00 mm	18.917 kg
TOP CHANNEL	PROFILE & BEND		1	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	2170.00 mm	200.19 mm	17.257 kg
VERTICAL CAHNNEL	PROFILE & FORM		7	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	1539.00 mm	190.19 mm	81.424 kg
CLOSURE PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	50.00 mm	100.00 mm	0.470 kg
STOPPER BAR	MACHINE		2	Steel, BS970 EN 3A BMS				1.410 kg
BOTTOM CLOSURE PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	5.00 mm	48.00 mm	140.93 mm	0.442 kg
LIFT HOOK PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	12.00 mm	250.00 mm	270.00 mm	9.032 kg
TOP PLATE	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	50.00 mm	190.00 mm	1.498 kg
BACKING PLATE	PROFILE		4	Steel, EN 10025-2 S355 JR (HRP)	10.00 mm	55.00 mm	180.00 mm	2.989 kg
DOOR CATCH PLATE LUG	PROFILE		2	Steel, EN 10025-2 S355 JR (HRP)	6.00 mm	82.18 mm	150.07 mm	0.672 kg
DOOR CATCH PLATE	PROFILE		1	Steel, EN 10025-2 S355 JR (HRP)	16.00 mm	115.98 mm	278.49 mm	2.261 kg
CATCH	BEND TO SUIT		1	Stainless Steel, 316				0.150 kg
CATCH BASE	PROFILE & BEND		1	Steel, EN 10025-2 S355 JR (HRP)	4.00 mm	40.00 mm	178.93 mm	0.208 kg



Quality Control plan

Client	Durban Solid Waste	Title / Description				QCP No.			
Drawing no.	WCC-000000	Manufacturing of Waste compaction container				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party	Name of person	
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
1.	Materials								
1.1	Plate material thickness and grade check		V						
1.2	Hot rolled profiles profile size, tolerance and grade check		V						
1.3	Buyout items general dimension and grade check		W						
2	Parts & sheet metals								
2.1	Profile & form plate materials as per tolerances		V						
2.2	Machine parts as per drawing & tolerances		V						
2.3	Cut and drill all hot rolled profiles		V						
2.3	Blast and paint all hot rolled profiles.		W		V				
3	Primary structure (WCC-010100)								
3.1	Assemble bottom beams, plates and bottom channels								
3.2	Dimension check		H						
3.3	Welding to suit								
3.4	Final inspection		H		W				



Quality Control plan

Client	Durban Solid Waste	Title / Description				QCP No.			
Drawing no.	WCC-000000	Manufacturing of Waste compaction container				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party	Name of person	
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
4	Main body (WCC-010000)								
4.1	Install roof plate								
4.2	Install side plate								
4.3	Install hook lift unit (WCC-010200)								
4.4	Install hook plates (WCC-010300 & WCC-010400)								
4.5	Install side roller base (RS6-0100)								
4.6	Install middle roller support parts (MR10-0201)								
4.7	Dimension check		V						
4.8	Weld parts								
4.9	Install cover plates (WCC-010015, WCC-010016, WCC-010017)								
4.10	Weld cover plates								
4.11	Install hooking mechanism parts tack weld only		H						
4.12	Final Inspection		H		W				



Quality Control plan

Client	Durban Solid Waste	Title / Description				QCP No.			
Drawing no.	WCC-000000	Manufacturing of Waste compaction container				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party	Name of person	
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
5									
5.1	Assemble of door unit (WCC-020100)								
5.2	Dimension check		V						
5.3	Weld of door unit								
5.4	Assemble of hinge units (WCC-020200 & WCC-020300)								
5.5	Weld hinge units to door (WCC-020000)				W				
5.6	Final inspection		H		W				
6	Main assembly								
6.1	Add 2 x 26 mm spacers to door frame near hinges								
6.2	Install door lock mechanism								
6.3	Install door and lock with door lock mechanism								
6.4	Space weld hinges to main body								
6.5	Test door open and close		H						
6.6	Test door lock for open and close sequence		H						
6.7	Install bottom door lock arm								
6.8	Install bottom door lock rounds onto door frame								
6.9	Test door lock for open and close sequence		H		W				



eThekweni Municipality:
Cleansing & Solid Waste

Kruger Projects & Designs

Engineering: Mechanical · Marine · Structural

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Quality Control plan

Client	Durban Solid Waste	Title / Description						QCP No.			
Drawing no.	WCC-000000	Manufacturing of Waste compaction container						Date:			
Order no.								Revision:			
Client		Name of person		KPD		Name of person		3 rd Party		Name of person	
Item No.	Activity	Comments	Intervention						Supporting documentation		
			1	Sign	2	Sign	3	Sign			
6.10	Full weld all hinges and other parts										
6.11	Container and door number welded onto frames										
6.12	Final inspection		H		H						
7	Sliding door										
7.1	Assemble sliding door (WCC-030100)										
7.2	Dimension and flatness check										
7.3	Weld sliding door										
	Assemble and weld door lift hooks (WCC-030200)										
7.4	Assemble door lift hooks to sliding door										
7.5	Dimension check										
7.6	Final inspection		H		H						
Approval of Quality Control Plan											
Client			KPD				3 rd Party				
Name			Name			Name					
Date			Date			Date					
Sign:			Sign:			Sign					
A = Action / step completed. W = Witness. H =Hold point. V = Verification. R = Review. S = Surveillance. NCR = Non-conformance report. D = Prepare document for document packaging											



Quality Control plan

Client		Title / Description				QCP No.			
Drawing no.		Welding inspection & repair generic plan				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party	Name of person	
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
1	Inspection of all welding seams								
1.1	Mark all approved seams with green marker / black tick mark near middle of weld where possible		A						
1.2	Mark all seams that has small imperfections for engineer to comment. This will be seams with a fillet size less than 0.7 x minimum plate thickness. Or unless noted otherwise on drawing. Engineer to determine if this is a critical weld		A						
1.3	Mark all weld seams which is not smooth, clean, without imperfections and that is not complete		A						
1.4	Document all works on document or drawing as required		A		W				
2	Cleaning of welds that is not approved								
2.1	Clean all areas that has to be welded by removing all the paint in area (plus 15 mm border all round) by mechanical means. Needle gun, sanding disc or grinder.		A						
	Note: No grinding into parent material allowed								
2.2	Remove imperfections from weld seams by means of angle grinder / sanding disc		A						



Quality Control plan

Client		Title / Description				QCP No.			
Drawing no.		Welding inspection & repair generic plan				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party		Name of person
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
2.3	Inspection of all affected areas to confirm that welding seam is ready for reworks.		A		W				
3	Welding procedure								
3.1	Select correct welding procedure for each weld that has to be repaired		A						
3.2	Confirm that machine settings, welding material and shield gas are correct for procedure		A						
3.3	Confirm that the welding operator is adequately trained for the type of weld required		A						
3.4	Cleaning and preparation of weld		A						
3.5	Weld repair in progress to be monitored		A						
3.6	Weld inspection as required		A						
3.7	Weld approval by inspector / engineer		A		W				
4	Safety								
4.1	Full PPE as per HSE		A						
4.2	Welding area is safe as per HSE		A						
4.3	Fire prevention / welding damage to others plan are in action.		A						
5	Welding works								



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Thursday, 26 January 2017



Quality Control plan

Client	Durban Solid Waste	Title / Description				QCP No.		DSW-QP-01	
Drawing no.	WCC-000000	Painting of Waste compaction container: Container, door and sliding door				Date:			
Order no.						Revision:			
Client		Name of person		KPD	Name of person		3 rd Party		Name of person
Item No.	Activity	Comments	Intervention						Supporting documentation
			1	Sign	2	Sign	3	Sign	
	Container, door and sliding door								
1	Cleaning								
1.1	Remove all sharp edges & burrs		W						
1.2	Remove surface oxidation and mill scale by blasting / mechanical means		W						
1.3	Chemical wash		H						
1.4	Dry time after washing		W						
1.5	Install grease nipples / blank of to suit		W						
1.6	Masking / protection of items that do not need to be painted.		W						
2	Painting				S				
2.1	Apply primer coat x 1		W						
2.2	Drying time								
2.3	Thickness test		V						
2.4	Apply of intermediate coat x 1		W						
2.5	Drying time								
2.6	Thickness test		V						
2.7	Apply of final coating x 1		W						
2.8	Drying time								
2.9	Final thickness test		V		W				



eThekweni Municipality:
Cleansing & Solid Waste

Kruger Projects & Designs

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Quality Control plan

Client	Durban Solid Waste	Title / Description						QCP No.	DSW-QP-01		
Drawing no.	WCC-000000	Painting of Waste compaction container: Container, door and sliding door						Date:			
Order no.								Revision:			
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Item No.	Activity			Comments		Intervention				Supporting documentation	
				1	Sign	2	Sign	3	Sign		
3	Report										
3.1	Complete report for each unit					A		W			
3.2	3 rd. party inspection of paint works							V			
3.3	3 rd. party acceptance of painting works							H			
Approval of Quality Control Plan											
Client 1				KPD 2				3 rd Party 3			
Name				Name				Name			
Date				Date				Date			
Sign:				Sign:				Sign			
A = Action / step completed. W = Witness. H =Hold point. V = Verification. R = Review. S = Surveillance. NCR = Non-conformance report. D = Prepare document for document packaging											



Quality Control plan

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The following is required for to determine if fabricator will have the right resources / equipment to manufacture Waste Compaction Container to standards as required.

Fabrication facility details

Item	Description	Details	Own	Hire	Comments	Notes
1.1	Plate profile equipment					
1.2	Plate bending equipment					
1.3	Steel profile cutting					
1.4	Steel plate cutting					
1.5	Steel plate bending					
1.6	Steel plate rolling					
2	Handling					
2.1	Overhead gantry				5 ton min.	
2.2	Truck mounted crane				20 ton meter.	
2.3	Fork lift				3 ton min.	
2.4	Pallet trucks					
3	Painting					
3.1	Blasting bay size					
3.2	Paint bay size					
3.3	Paint system					
4	Welding					
4.1	Welding bay (small parts)					
4.2	MIG Units					



4.3	MAW Units					
5	Workshop					
5.1	Floor width					
5.2	Floor length					
5.3	Clearance				4.3 m clearance	
5.4	Door size #1					
5.5	Door size #2					

All of the following equipment to be calibrated.

Item	Description	Qty.	Calibrated	Comments
1	Tape measures			
2	Spirit level			
3	Digital protractor			
4	Vernier			
5	Paint thickness measurement unit			