

Report no. 10-7487-SQ	Project no. 2468541	Report date: 20-Jan-2011	Office: China
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REPORT OF ACTIVITY

General scope of activity: Third Party Inspection of Fugitive Emission Production test for DBB Valve	Dates of all related activity: 17 Dec 2010 and subsequent dates
Client: Company name: PT KOROSI SPECINDO. Address: JL. PANGERAN JAYAKARTA NO 76, JAKARTA 10730 Contact(s): Mr. Yohan Sutandar Tel/Fax: +86-21-6267576 / 6289919 PO/shop/contract or job no:	Supplier: Company name: PT KOROSI SPECINDO. Address: JL. PANGERAN JAYAKARTA NO 76, JAKARTA 10730 Contact(s): Mr. Yohan Sutandar Tel/Fax: +86-21-6267576 / 6289919 PO/shop/contract or job no:
Subvender - 1: NA Company name: Address: Contact(s): PO/shop/contract or job no:	Subvender - 2: NA Company name: Address: Contact(s): PO/shop/contract or job no:
Component description(s): Model KS DBB Valve	Results: Meets requirements <input checked="" type="checkbox"/> Subject to condition(s) noted <input type="checkbox"/> Does not meet requirements <input type="checkbox"/>

This is to certify that the undersigned representative of **ABSG Consulting Inc.** did at the request of **Messrs. PT KOROSI SPECINDO** attended **Hefei General Machinery & Electrical Products Inspection Institute** plant located at **NO.888 Changjiang Road (w) Hefei City Anhui Province P.R. of China** on the 17th Day of Dec 2010, and subsequent dates in order to carryout the scope of services described below.:

1.0 The Application Standards:

MESC SPE 77/312 June 2007

2.0 Scope of Inspections:

Witness of Fugitive Emission Production test

3.0 Inspection Details:

The below captioned documents were reviewed by inspector.
All the calibration test reports of test machine were duly review and found that all machines and gauges were well calibrated.

Description of Valves:



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Drawing No.: 281201-09
 Type : Model KS DBB Valve
 Part number: KSDBB-PC-300-RF-FS
 Pressure Rating: 720PSI
 Bottom Connection: Flange 2" Class 300 RF
 Upper Connection: 1/2" NPTF
 Vent: 1/2" NPTF

F-F or E-E dimension: 330mm
 Serial number: 2710802

Materials

Body/ Connection end: AISI 316L SS
 Stem/Ball: AISI 316L SS
 Body connection packing: CARBON GRAPHITE
 Stud/Nut: AISI 304L SS

Non-metallic materials

Ball seat : RTFE
 Stem Packing: CARBON GRAPHITE

Test details

The Fugitive Emission Production test was conducted according to MESC SPE 77/312 June 2007.
 Test equipment: SFJ-231 Helium Mass Spectrometer (with sniffing gun)
 HELIUM >97% purity

Before test, the valve 5 mechanical cycles be applied, and measured the toque of Primary isolation valve is 1.9Nm, measured the toque of Secondary isolation valve is 9.8Nm.

The design toque is less than 20Nm.

During the time of the testing, no mechanical adjusting happened.

The Primary isolation ball, the Secondary isolation ball and vent valve in half open position during the time of the testing.

Test result of Fugitive Emission Production test

Item	SPE 77/312 required Value	Actual Value					
		Static			Dynamic		
		Primary	Secondary	Vent	Primary	Secondary	Vent
Test pressure (Bar)	18.0	18.0			18.0		
Holding time	10min	10min			10min		
Test Temperature (°C)	Ambient	Ambient			Ambient		
Leakage rate from body/bonnet seat (Pa · m ³ /s)	8.0 E-07 max	5.2 E-08			N.A		
Leakage rate from stuffing box (Pa · m ³ /s)	1.42 E-06 max	5.1 E-08	5.1 E-08	5.1 E-08	N.A		
Leakage rate from stem seat (Pa · m ³ /s)	1.42 E-06 max	5.2 E-08	5.2 E-08	5.2 E-08	5.2 E-08	5.2 E-08	5.2 E-08
Background Niose (Pa · m ³ /s)	Not required	4.8E-08					

Conclusion: the test result is satisfactory according to SPE 77/312.

Note: The stem outside diameter is 8.0 mm, and the gasket circumference between body and bonnet is 45mm.

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4.0 Conclusion:

Inspections of the DBB valves (S/N. 2710802) were carried out within the confine of the scope of inspection indicated herein and with the issuance of this report deems satisfactorily completed. Meeting requirements of Fugitive Emission Production test (Tightness Class B), as specified in MESC SPE 77/312 June 2007.

Report prepared and submitted without prejudice.


Zhang Peng
Technical Representative
ABS Consulting



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