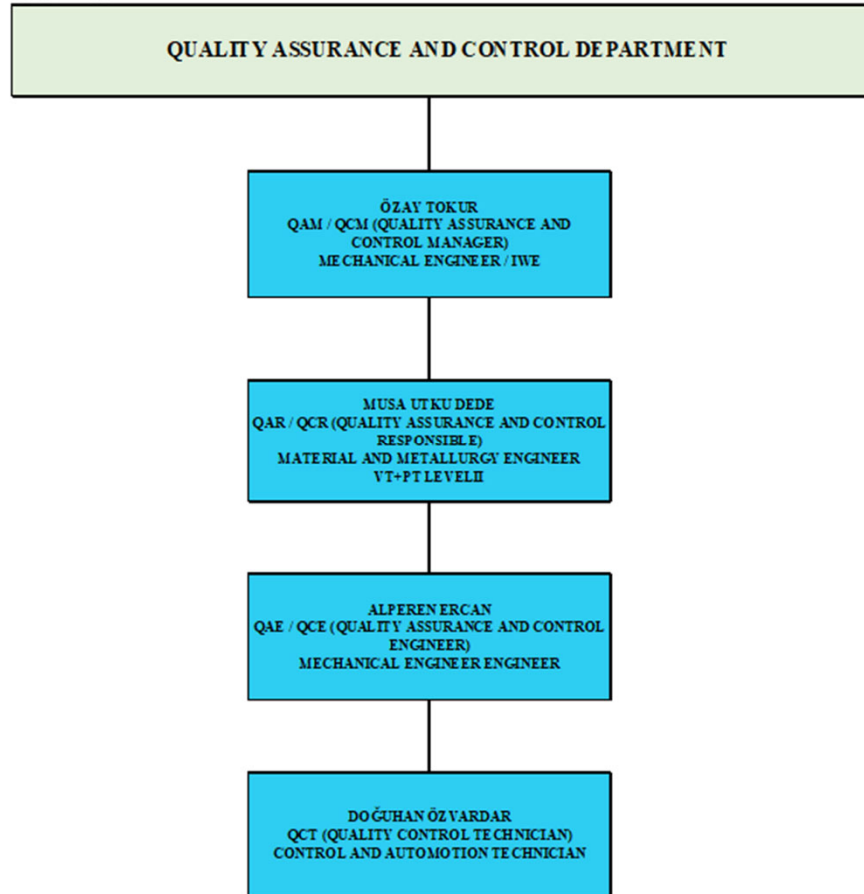


**Gemak
Quality
Department
QA/QC**



Quality Organization Chart

Date: 27.11.2023
Version: 0.01



Controls and Documentation

ITP (Control Test Plan)

- Penetrant Inspection (PT)
- Visual Inspection (VT)
- Radiographic Examination (RT)
- Weld Map Preparation and WPS-PQR Assignment
- Size and Dimension Control
- Surface Roughness Tests
- Pressure Tests (Tank and Jacket, Tube/Plate/Scraper Heat Exchanger)
- Mixer Tests
- Pump Tests
- Material Traceability

gemak PROMAK		INSPECTION AND TEST PLAN (ITP)				NESOS		DATE / TARİH		7.10.2019	
PROJECT NO:		DRAWING NO:						DOC NO / DOK. NO		F 35	
PROJ. NO: 24008		ÇİZİM NO: 24008-01, 24008-02A, 24008-03A, 24008-04A, 24008-05A, 24008-06A, 24008-07B, 24008-09A, 24008-10A, 24008-10B, 24008-10C, 24008-10D, 24008-11A, 24008-11B, 24008-11C, 24008-02						REV. / REVİZYON		R00	
								SHEET NO / SAYFA NO		3	
SERIAL NO SERİ NO	APPROVALS / ONAYLAR	ACCEPTANCE CRITERIA KABUL KRİTERİ	INSPECTION FREQUENCY MUAYENE SIKLIĞI	VERIFYING DOCUMENT DOĞRULAMA BELGESİ	MANUFACTURER INSPECTION İMALATÇI MUAYENELERİ		NB INSPECTION ONAYLI KURULUŞ MUAYENELERİ				
					TYPE TİP	SIGNATURE İMZA	TYPE TİP	SIGNATURE İMZA			
I											
1	PQRS, WPSS & WPGS KAYNAK YÖNTEM ONAYI, YÖNTEM ŞARTNAMESİ VE KAYNAKÇI SERTİFİKALARI	EN 15614-1, EN 9606-1, EN 15609-1	100%	APPROVED WPGS, PQRS, WPGS ONAYLI PQR, WPS, WPG	R&APP	<i>[Signature]</i>	R&APP				
2	NDT OPERATOR CERTIFICATES NDT OPERATOR SERTİFİKALARI	EN ISO 9712	100%	NDT CERTIFICATES NDT SERTİFİKALARI	R&APP	<i>[Signature]</i>	R&APP				
3	DESIGN TASARIM		100%	DESIGN DATA SHEET DİZAYN VERİLERİ	R&APP	<i>[Signature]</i>	R&APP				
4	ENGINEERING DRAWINGS / ÇİZİMLER		100%	DRAWINGS ÇİZİMLER	R&APP	<i>[Signature]</i>	R&APP				
II	MATERIAL CONFORMITY / MALZEME UYUMLULUĞU										
5	REVIEW OF MATERIAL CERTIFICATES MALZEME SERTİFİKALARININ GÖZDEN GEÇİRİLMESİ	EN 10204 3.1	100%	MATERIAL CERTIFICATES MALZEME SERTİFİKALARI	R&APP	<i>[Signature]</i>	R&APP				
6	MATERIAL TRACEABILITY MALZEME İZLENİBİLİRLİĞİ	DRWS	100%	MATERIAL MAP REP. MALZEME HARİTASI	R&APP	<i>[Signature]</i>	R&APP				
7	REVIEW OF FILLER MATERIAL CERTIFICATES SARF MALZEME SERTİFİKALARININ GÖZDEN GEÇİRİLMESİ	EN 10204 2.2	100%	FILLER MAT CERTIFICATES SARF MALZEME SERTİFİKALARI	R&APP	<i>[Signature]</i>	R&APP				
III	INPROCESS INSPECTION İMALAT ESNASINDA MUAYENELER										
8	DIMENSIONAL CHECK, FIT-UP INSPECTION BEFORE WELDING KAYNAKTAN ÖNCE MONTAJ VE BOYUT KONTROLÜ	EN 13920 C/F	100%	DIM. AND FIT-UP REPORTS CHECKED ON THE TECHNICAL DRAWING BOYUT VE MONTAJ TEKNİK RESİM ÜZERİNDE KONTROL EDİLİR	DT&VT	<i>[Signature]</i>	R				
9	PRE-WELDING INSPECTION (WPS, WPG CONFORMITY) KAYNAK ÖNCESİ KONTROL	DRWS, WPSS, WELDER CERTIFICATES	100%	WELDING&NDT MAP REP. KAYNAK&NDT HARİTALARI	VT&R	<i>[Signature]</i>	R				
10	DURING WELDING INSPECTION (AMP, VOLTAGE, SPEED CHECK) KAYNAK ESNASINDA KONTROL (AMP, VOLTAJ, HIZ KONTROLÜ)		1 WELD/DAY	WELDING SURVEILLANCE KAYNAK KONTROL	VT(S)	<i>[Signature]</i>	N.A.				
11	AFTER WELDING INSPECTION (VISUAL INSPECTION OF WELDS) KAYNAK SONRASI MUAYENE (GÖRSEL MUAYENE)	EN ISO 5817 CLASS B, EHEDG	100%	VISUAL INSPECTION CHECKED ON THE TECHNICAL DRAWING GÖRSEL MUAYENE TEKNİK RESİM ÜZERİNDE KONTROL	VT&R	<i>[Signature]</i>	VT&R				
12	DIMENSIONAL CHECKING AFTER WELDING KAYNAK SONRASI BOYUT KONTROLÜ	EN 13920 C/F	100%	DIMENSIONAL REPORTS (F 100) BOYUT KONTROL RAPORLARI (F 100)	VT&R	<i>[Signature]</i>	VT&R				
13	NDT (VT&PT) AFTER WELDING KAYNAK SONRASI ZAHİRİ/ATÖZ MUAYENE (VT&PT)	EN 3452-1, EN 23277 LEVEL2 (PT), EN 1435, EN ISO 5817 B, EHEDG	SEE TABLE EN 13445(V=0,85)	LIQUIT PENETRANT TEST (F 101) LIQT PENETRANT TEST RAPORU (F101)	W&R	<i>[Signature]</i>	R				
14	WELDING&NDT TRACEABILITY KAYNAK VE NDT İZLENİBİLİRLİĞİ	DRWS	100%	WELDING KAYNAK	R	<i>[Signature]</i>	R				
IV	PROOF TEST / DAYANIKLILIK TESTİ										
15	BASING TESTI PRESSURE TEST	EN ISO 13445	100%	HYDROSTATIC TEST REPORT (F 104) HİDROSTATİK TEST RAPORU (F 104)	W&VT	<i>[Signature]</i>	H&VT				
V	FUNCTION TEST / FONKSİYON TESTİ										
16	AGIGATOR TEST KARIŞTIRICI TEST		100%	AGIGATOR TEST REPORTS (F 102) KARIŞTIRICI TEST RAPORLARI (F102)	W&R	<i>[Signature]</i>	R				
VI	FINAL INSPECTION SON KONTROL										
17	CHECK HANDLING AND MARKING GÖZDEN GEÇİRME VE MARKALAMA	EN ISO 13445	100%	VISUAL INSPECTION REPORT GÖRSEL MUAYENE RAPORLARI	VT	<i>[Signature]</i>	R&APP				

LEGEND		MANUFACTURER APPROVAL		NB APPROVAL	
AÇIKLAMALAR		İMALATÇI ONAYI		ONAYLI KURULUŞ ONAYI	
R&APP	REVIEW AND APPROVAL / GÖZDEN GEÇİR VE ONAYLA	DATE:	SIGN:	DATE:	SIGN:
R	REVIEW / GÖZDEN GEÇİR	TARİH	İMZA	TARİH	TARİH
DT	DIMENSIONAL INSPECTION / BOYUT KONTROL				
VT	VISUAL INSPECTION / GÖRSEL KONTROL				
VT (S)	SPOT VISUAL INSPECTION / RASTGELE GÖRSEL KONTROL	2.02.2024	<i>[Signature]</i>		
W	WITNESS / ŞAHİTLİK				
H	HOLD POINT / BEKLEME NOKTASI				



MANUFACTURE DATA REPORT FOR

PROJECT NO
XXXX

Chapter 1 ITP (INSPECTION TEST PLAN)

Chapter 2 WELDING DOCUMENTATION

- 2a WELD MAP
- 2b WPS - PQR
- 2c WELDER CERTIFICATES
- 2d WELDING CONSUMABLE CERTIFICATES
- 2e NDT PERSONEL CERTIFICATES

Chapter 3 350 LT CREAM PAST. BALANCE TANK

- 3a General Drawing
- 3b Material Certificate
- 3c Dimensionel Report & Visual Test Report
- 3d Surface Roughness Test Report
- 3e Penetrant Test Report
- 3f CE Declaration Of Confirmation
- 3g Tank Tag

Chapter 4 150 LT CREAM PAST. WATER BALANCE TANK

- 4a General Drawing
- 4b Material Certificate
- 4c Dimensionel Report & Visual Test Report
- 4d Surface Roughness Test Report
- 4e Penetrant Test Report
- 4f CE Declaration Of Confirmation
- 4g Tank Tag

Chapter 5 150 LT COOLING WATER BALANCE TANK

- 5a General Drawing
- 5b Material Certificate
- 5c Dimensionel Report & Visual Test Report
- 5d Surface Roughness Test Report
- 5e Penetrant Test Report
- 5f CE Declaration Of Confirmation
- 5g Tank Tag

Chapter 6 350 LT WHEY PAST. BALANCE TANK

- 6a General Drawing
- 6b Material Certificate
- 6c Dimensionel Report & Visual Test Report
- 6d Surface Roughness Test Report
- 6e Penetrant Test Report
- 6f CE Declaration Of Confirmation
- 6g Tank Tag



new generation
factories

Our Documents and Applicable Regulations

- TS EN ISO 9001:2015
- ISO 14001:2015
- EHEDG (Europe Hygienic Engineering & Design Group)
- FCM
- UKCA
- CE
- EN ISO 9712 NDT Personnel Certification



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Standards and Directives Used

Application Directives/Regulations

- **2006/42/EC** Machinery Safety Directive
- **FCM** Food Contact Material
- **2014/68/EU** PED (Pressurized Equipment Directive)
- **2014/35/EU** Low Voltage Directive
- **214/30/EU** Electromagnetic Compatibility

Reference Standards

- **EN 15614-1, EN15609-1, EN15608** WPS/PQR
- **EN 9606-1** Welders Certification
- **EN 13445** Unfired Pressure Vessels
- **EN 1672-1-2, ISO 14159 (EHEDG)** Food Processing Machinery Hygienic Design Standard
- **EN9712** NDT Personal Calcification and Certification
- **EN 3452-1** Non-Destructive Testing Penetrant Test and its general principles.
- **EN23277** PT Test and acceptance criteria - Level2
- **EN1435** Radiographic Examination of Weld Joints
- **EN 13920** Welding - General Tolerances for Welded Structures
- **EN5817** Quality Levels for Weld Defects
- **TS EN ISO 14732** Competence standard of Weld Operators and Weld adjusters
- **ASME Section V** Non-Destructive Testing Methods
- **TS EN ISO 14122** Work Platforms, Walkways, Stairs, Step ladders and Railings.
- **EN 60204-1 CLAUSE 18.2** COUNTINUITY TEST
- **EN 60204-1 CLAUSE 18.3** ISOLATION TEST
- **EN 60204-1 CLAUSE 18.4** HIGH VOLTAGE TEST
- **EN 60204-1 CLAUSE 18.5** PROTECTION AGAINST RESIDUAL VOLTAGES
- **TS EN 61000-4-2** ELECTROSTATIC DISCHARGE IMMUNITY TEST
- **TS EN 61000-4-4** ELECTRICAL FAST TRANSIENT/BURST IMMUNITY TEST
- **TS EN 61000-4-5** SURGE IMMUNITY TEST
- **TS EN 61000-4-6** IMMUNITY TO CONDUCTED DISTURBANCES INDUCED BYRADIO FREQUENCY FIELDS
- **TS EN 55011** RADIATED EMISSION

GEMAK **CE**

CE DECLARATION OF CONFORMITY

MANUFACTURER

NAME : GEMAK GIDA ENDÜSTRİ MAKİNALARI VE TİC. A.Ş.
ADDRESS : ALCI OSM. MAHALLESİ 2032 CAD. NO:1/1
TEMELLİSİNAN/ANKARA
CONTACT : TEL: 0 312 641 32 52 FAX: 0 312 394 77 95
WEB: www.gemak.com.tr

NAME AND ADDRESS OF THE PERSON
AUTHORISED TO COMPILE THE
TECHNICAL FILE : Necil BÜYÜKPAMUKÇU
ALCI OSM. MAH. 2032 CADDE NO:1/1
TEMELLİSİNAN/ANKARA

The item of equipment which identified below has been subject to internal manufacturing checks with monitoring of the final assessment by GEMAK GIDA ENDÜSTRİ MAKİNALARI VE TİC. A.Ş.

NAME	MODEL	SERİ NO
SCC(SOUTH CAERNARFON CREAMERIES) CHEESE PLANT CIP UNIT	PRO CIP-2	21151-01

APPLICABLE DIRECTIVES :
LOW VOLTAGE DIRECTIVE 2014/53/EU
ELECTROMAGNETIC COMPATIBILITY DIRECTIVE 2014/53/EU
MACHINE SAFETY DIRECTIVE 2006/42/AT

APPLICABLE STANDARDS :
EN ISO 12100:2010
CONTINUITY TEST (EN 60204-1 CLAUSE 18.2)
ISOLATION TEST (EN 60204-1 CLAUSE 18.3)
HIGH VOLTAGE TEST (EN 60204-1 CLAUSE 18.4)
PROTECTION AGAINST RESIDUAL VOLTAGES (EN 60204-1 CLAUSE 18.5)
ELECTROSTATIC DISCHARGE IMMUNITY TESTS (EN 61000-4-2)
ELECTRICAL FAST TRANSIENT/BURST IMMUNITY TESTS (EN 61000-4-4)
SURGE IMMUNITY TESTS (EN 61000-4-5)
IMMUNITY TO CONDUCTED DISTURBANCES INDUCED BYRADIO FREQUENCY FIELDS (EN 61000-4-6)
RADIATED EMISSIONS (EN 55011)

SIGNED ON BEHALF OF THE MANUFACTURER
NAME : Necil BÜYÜKPAMUKÇU
POSITION : GENERAL MANAGER
PLACE / DATE : ANKARA 8.05.2023
SIGNATURE :







Declaration of Conformity

According to Directive **2014/68/EU**

for a pressure equipment

The manufacturer herewith declares, that the pressure equipment

Description: **SCQ(South Caermafion Creameries) STEAM COLLECTOR**

Type - Serial - Identification-No: **21151**

Allowable working pressure: **5 Bar**

Max. allowable pressure PS: **6,25 BAR**

Allowable max./min. Temperature TS: **+152 C°/ +162 C°**

Year of manufacturing: **2023**

Test pressure PT: **7,5 Bar**

Test fluid: **Water**

Corresponds to the Pressure Equipment Directive **2014/68/EU.**

Applied conformity assessment procedure: **Category IV Module G**

Applied standards and technical specifications: **Base on EN13445**

Other applied EC-Directives: **2008/42/EC, 2014/35 EU, 2014/30/EU**

Engaged notified bodies:

Examination / inspections / test during manufacturing: **TÜV AUSTRIA SERVICES GMBH**

Certificates which are included

Modul G Certificate Number : **PED-0504-2023-TURK-248-22-IS-2279-0**

Location, Date: **ANKARA**



Aydın TOHUMOĞLU
Quality Control Manager



NDT Personnel Certificates and PED approval according to EN ISO 9712

SERTİFİKA

PERSONEL ONAY BELGESİ
PERSONNEL APPROVAL ATTESTATION

Sertifika No: 2022-3D-21-0225-CE-NDT-038
Certificate Number

BASINÇLI EKİPMANLAR YÖNETMELİĞİ 2014/68/AB EK I, Madde 3.1.3
PRESSURE EQUIPMENT DIRECTIVE 2014/68/EC ANNEX I, Sec. 3.1.3

ANIL UÇAR

Adı Soyadı / Name Surname

Doğum Tarihi / Birth Date: 06/01/1991 Kimlik No / ID Number: 222863

3D inCerta Belgelendirme Mühendislik Güzetm ve Denetim Ltd. Şti., Avrupa Topaklığı Basınçlı Ekipmanlar Yönetmeliği, Madde 23'te tanımlanan Onaylamam Kuruluş olarak Kategorii III ve IV'deki Basınçlı Ekipmanlar Belgelendirme Mueynere gerşekleşirecek yuğunda adı geçen personeli onaylamıştır.

3D inCerta Belgelendirme Mühendislik Güzetm ve Denetim Ltd. Şti., which is recognised Notified Body as desc: within the European Pressure Equipment Directive of Article 23, has approved the above NDT personnel to car: rificed Non Destructive Tests On Permanent Joists to pressure equipment in category III and IV.

Yöntem Methode	Seviye Level	İlgili Sertifika Güerlilik Tarihi Associated Certificate Validity Date	İlgili Sertifika No Associated Certificate Nr	Onay Qlar
PT Penetrant Testing	II	10.03.2027	ANDT-PT-22125	

Verilen personel yetkilendirmesi her bir yöntem için sanı gerşeklik tarihine kadar geçerli olabilmesi ser: personelin ilgili talimatıta mueynere alınında çalıştığını göstermesi yuğ belgelendirme organizasyon: değıllik alınmasını kayıtlıya gerşeklidir.

The present approval is valid until the expiring date of each qualification, provided that the conformity of appli: to be demonstrated upon request or except changes in the organisation that can affect its validity.

Sınırlamalar / Limitations: Yok / No

Düzenleme Tarihi: 26.05.2022
Issue Date
TRA No: 6863476632

CE 2530

Onaylayan / Approved
Teknik Düzenleme Sorumlusu
Head of NQBO

2530

Cengizhan FEREL

3D inCerta Ltd. Şti. ID-68



TÜRK
YERLİ ÜRÜN

3D inCerta Belgelendirme Mühendislik Güzetm ve Denetim Ltd. Şti.
Adres: Postane Mahallesi 12: Hıçlı Kurum Sokak No: 1/2/2 İstasyon / ŞANLIURFA
T: +90 216 492 2110 F: +90 216 532 71 82 E: info@3d-incerta.com

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Welder Certification and Traceability

NO	KAYNAKÇI ADI SOYADI	STANDART	YÖNTEM	MALZEME TİPİ	MALZEME KALİTESİ	MALZEME KALINLIĞI/ÇAP	BAĞLANTI TİPİ	WPS	SERTİFİKA BİTİŞ TARİHİ			
PO	ŞEVKET KAYACIK	EN ISO 14732-1	151	PLAKA	316		BW	WPS13	27.03.2028			
							BW	WPS14	27.03.2028			
							BW	WPS12	27.03.2028			
					304		BW	WPS10	27.03.2028			
							BW	WPS11	27.03.2028			
W1	TALAT PERVANE	EN ISO 14732-1	151	PLAKA	304		BW	WPS09	27.03.2028			
							BW	WPS10	27.03.2028			
							BW	WPS11	27.03.2028			
					316		BW	WPS13	27.03.2028			
							BW	WPS14	27.03.2028			
W2	ALPER KOÇAK	EN ISO 14732-1	142	BORU ORBİTAL	316		BW	WPS25	10.01.2028			
W3	İSMET AYDOĞAN	EN ISO 14732-1	142	BORU ORBİTAL	316		BW	WPS25	23.03.2025			
NO	KAYNAKÇI ADI SOYADI	STANDART	YÖNTEM	MALZEME TİPİ	MALZEME KALİTESİ	MALZEME KALINLIĞI/ÇAP	BAĞLANTI TİPİ	WPS	ET KALINLIĞI	ARALIK	POS'N	SERTİFİKA BİTİŞ TARİHİ
W8	ÇINAR ERÖKSÜZ	EN 9606-1	141	BORU	304	Ø25*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 3	25 ≤ Ø ≤ 50	H-1045	10.01.2025
						Ø53*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 3	26,5 ≤ Ø	H-1045	10.01.2025
						Ø104*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 4	52 ≤ Ø	H-1045	10.01.2025
						Ø85*2mm	BW	WPS 17 WPS18	2 ≤ s ≤ 4	42,5 ≤ Ø	H-1045	10.01.2025
				PLAKA		1,5mm	BW	WPS 03	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						4mm	BW	WPS 01	3 ≤ s ≤ 8	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						1,5mm	FW	WPS 08	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025
						4mm	FW	WPS 08	3 ≤ s	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025
W5	GÖKMEN DİVARCI	EN 9606-1	141	PLAKA	304	1,5mm	BW	WPS 03	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						4mm	BW	WPS 01	3 ≤ s ≤ 8	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						1,5mm	FW	WPS 08	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025
						4mm	FW	WPS 08	3 ≤ s	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025
W7	HULUSİ YÜKSEL	EN 9606-1	141	BORU	304	Ø25*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 3	25 ≤ Ø ≤ 50	H-1045	10.01.2025
						Ø53*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 3	26,5 ≤ Ø	H-1045	10.01.2025
						Ø104*1,5mm	BW	WPS 17 WPS18	1,5 ≤ s ≤ 4	52 ≤ Ø	H-1045	10.01.2025
						Ø85*2mm	BW	WPS 17 WPS18	2 ≤ s ≤ 4	42,5 ≤ Ø	H-1045	10.01.2025
				PLAKA		1,5mm	BW	WPS 03	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						4mm	BW	WPS 01	3 ≤ s ≤ 8	500 ≤ D Fixed 75 ≤ D Rotating	PA	10.01.2025
						1,5mm	FW	WPS 08	1,5 ≤ s ≤ 3	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025
						4mm	FW	WPS 08	3 ≤ s	500 ≤ D Fixed 75 ≤ D Rotating	PB	10.01.2025



ZERTIFIKAT | CERTIFICATE | CERTIFICAT | CERTIFICADO | CERTIFICAT | 証明書 | 證書 | 인증서

TÜV AUSTRIA

WELDER QUALIFICATION CERTIFICATE

EN ISO 9606-1 141 P FW FM5 S t1,5 PB sl

Certificate No. 21-PB-0170-TAP-WL0206-0923

Manufacturer's WPS No Wps-08

Surname / First Name of the Welder PERVANE, Talat

Method of Identification 15364049078

Date / Place of birth 01.07.1978 - Elnadağ

Employer PROMAK

Code / Testing Standard EN ISO 9606-1: 2017

Job Knowledge Not made

Examining Body TÜV AUSTRIA

Personnel Belgeleendirme Eğitim Ltd. Şti.

Examiner Yusuf ERDOĞAN

Welder's Identification mark W1

Approval acc. to 2014/68/EU TÜV AUSTRIA

Personnel Belgeleendirme Eğitim Ltd. Şti.

RTPO third-party organisation recognised by a Member State as provided for in Article 20 of 2014/68/EU

Weld Test Details		Range of Approval
Welding process	141	141, 142, 143, 145
Transfer mode	-	-
Product type (Plate or Pipe)	P	P, T (Fixed ≥500 mm, Rot 75 mm)
Type of weld	FW	FW
Parent material group(s)	CR ISO 15608 Group 8.1	-
Filler metal group	FM5 / S	FM5 / S, M
Filler material (designation)	EN 12072: W 19 9 L	-
Shielding gas	EN ISO 14175: I1	-
Auxiliaries	-	-
Type of current and polarity	DC (-)	-
Material thickness of test piece (mm)	1,5	3 ≥ t ≥ 1,5
Deposited thickness (mm)	-	-
Outside pipe diameter (mm)	-	-
Welding position	PB	PA, PB
Details of weld seam	sl	sl

See supplementary sheet and/or Manufacturer's welding procedure specification for additional information

Type of test	Performed and Accepted	Not required
Visual Testing	X	
Radiographic Test		X
Ultrasonic test		X
Magnetic Test		X
Macro section	X	
Fracture test		X
Bend test		X
Notched Tensile test		X
Hardness test		X
Additional tests		X

* Details on supplementary sheet, if required

** In case of proper confirmation of employer or supervisor (acc. to testing standard)

Extension acc. to point 9.3 a

Date	Signature

Name and Signature: Mustafa ŞİRİN

Place of Issue: TÜV AUSTRIA Personal Belgeleendirme-Ankara

Date of Issue: 21.01.2022

Place of Testing: Promak Workshop-Ankara

Date of Testing: 11.01.2022

Valid until: "": 10.01.2025

TÜV AUSTRIA

Personal Belgeleendirme Eğitim Ltd. Şti.

AB-0031-P

TÜRKAK

Personal Belgeleendirme Eğitim Ltd. Şti.

AB-0031-P

TÜV AUSTRIA Personal Belgeleendirme Eğitim Ltd. Şti.

Alacaatlı Mah. Beşik Sok. No:13 Çankaya, Ankara, TURKEY - www.tuv-austria.org

Yayın Tar: 30.03.2021

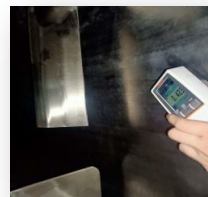
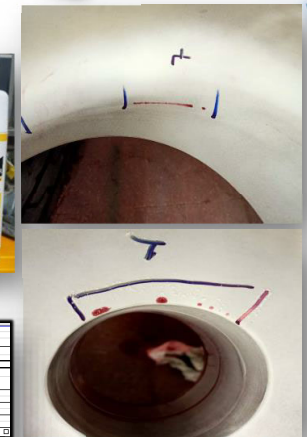
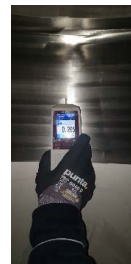
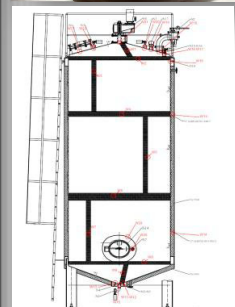
Rev. No:0

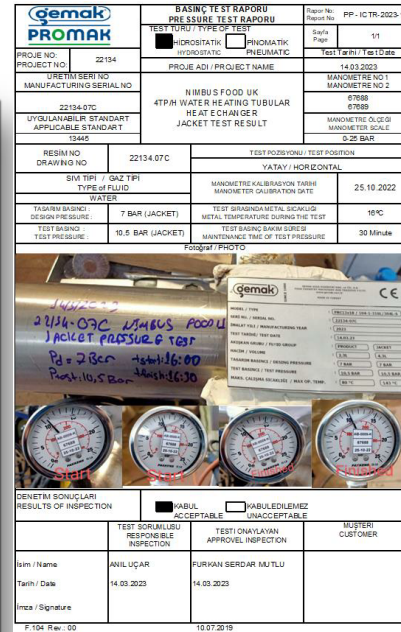
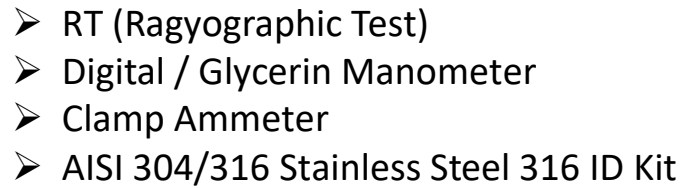
Rev. Tar:

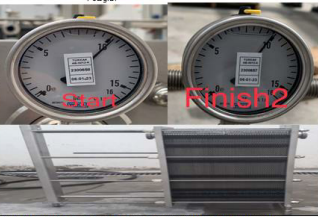
QR Code



- 
- A square sign with rounded corners, featuring a stylized illustration of a spray bottle being used on a surface. Below the illustration, the text "PENETRANT TEST DONE" is printed in bold, capital letters. In the bottom right corner, there is a circular icon containing a checkmark.

[illegible][illegible]

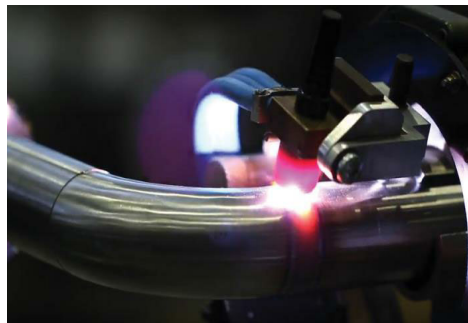
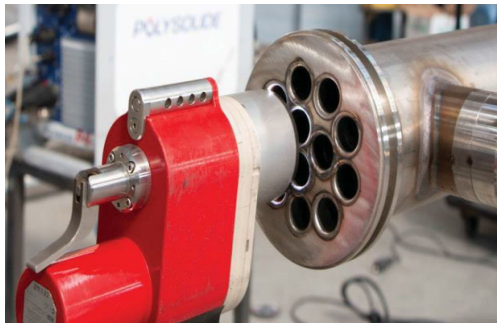


		ŞANŞIYOR BASINÇ TEST RAPORU HEAT EXCHANGER TEST REPORT		Rapor No: PP-HT-2023/07 Rapor No: PP-HT-2023/07	
PROJE NO: 23014 PROJEKT NO: 23014		TEST TURLİK TYPE TYPE HYDROSTATIC		Test Tarih Test Date 25.05.2023	
Şanşiyor Tipi Heat Exchanger type M6M		PROJE ADI / PROJECT NAME RAWI DAIRY 10 TPH MILK COOLER		MANOMETRE NO MANOMETRE NO 2300657-2300655 Monometre / Monometre Kalibrasyon Tarih / Calibration Date 6.01.2023	
Şanşiyor Seri No Heat exchanger Serial No 1344		354 mm		Şanşiyor Borne Sayısı Heat Exchanger Compartment Number 1 Adet / Piece	
Üretim Yılı Manufacture Year 2023		354 mm		Test Sıranındaki Metal Soğutma Metal Temperature During Testing Number 10 °C	
Maksimum İşletme Basıncı Max Operating Pressure 10 BAR		354 mm		Test Basınç İzleme Süresi Test Pressure Monitoring Time 30 Dakika / 30 minute	
Test Basıncı / Test Pressure 10 BAR		354 mm		30 Dakika / 30 minute	
					
Açıklama Explanation Denetim Sonuçları Audit Results		Şanşiyor giriş ve çıkış yönleri kontrol edildikten sonra basınç testi gerçekleştirilmiştir. The pressure test was carried out after checking the inlet and outlet directions of the exchanger arrangement.			
Basınç Testi Yapılan Pressure Testing		Operatör / Operator Kabul / Acceptance		Teslim Onaylayan / Test Approved İlet / Reject	
İşim / Name Tarih / Date İmza / Signature		Akif KAYIRHAN 25.05.2023		Değışhan ÖZVARIRAR 25.05.2023	

❖ Electrical, Mechanical and Performance Tests

Welding Technology

- Argon Tig welding
- Plasma Weld
- Orbital Pipe Welding
- Lazer Weld
- Electric Arc Welding
- Mig-Mag Welding



[illegible]



PQR LIST

Tarih:

19.12.2018

Rev. No:

0

ITEM NO	PQR NO	PQR Standartı	Yöntem	MATERIAL	Dolgu Tipi	Kalınlık	Boru Çapı	Pozisyon	Hazırlayan	Tarih
15	PR-PQR-015	EN 15614-1	141	AlSi 316L	ER 316 LSi	1,5 mm(1,06 to 3,1 mm) for 4 mm (3,0 to 8 mm)	Ø33 (D ≥ 26,5)	PB	Osman YIDIRM	2.11.2015
16	PR-PQR-016	EN 15614-1	141	AlSi 316L	ER 316 LSi	2 mm(1,4 to 4,0 mm) for 4 mm (3,0 to 8 mm)	Ø42,4 (D ≥ 25)	PB	Osman YIDIRM	2.11.2015
17	PR-PQR-017	EN 15614-1	141	AlSi 316L	ER 316 LSi	1,5 mm(1,05 to 3 mm)	Ø33 (D ≥ 25)	HL-045	Osman YIDIRM	2.11.2015
18	PR-PQR-018	EN 15614-1	141	AlSi 316L	ER 316 LSi	2 mm(1,4 to 4,0 mm)	Ø42,4 (D ≥ 25)	HL-045	Osman YIDIRM	2.11.2015
19	PR-PQR-019	EN 15614-1	141	AlSi 316L	ER 316 LSi	10 mm(3 to 20 mm)	NA	PA	Osman YIDIRM	26.11.2015
20	PR-PQR-020	EN 15614-1	141	AlSi 316L	ER 316 LSi	10 mm(5 to 20 mm)	NA	PB	Osman YIDIRM	26.11.2015
21	PR-PQR-021	EN 15614-1 2017- Level 2	141	AlSi 316L / SA 240	ER 316 L	2 mm(1mm to 4 mm)	D > 500mm D > 150mm	PA	M.KorayEFE	12.02.2018
22	PR-PQR-022	EN 15614-1 2017- Level 2	141	AlSi 316L / SA 240	ER 316 L	2 mm(1,4 mm to 4 mm)	D > 500mm D > 150mm	PB	M.KorayEFE	12.02.2018
23	PR-PQR-023	EN 15613	141	AlSi 316L / SA 240	ER 316 L	Pipe 2 mm(1,4 mm to 4 mm) / Plate 2mm(1,4to-4mm)	38mm (≥ 19mm)	PB	M.KorayEFE	13.02.2018
24	PR-PQR-024	EN 15614-1 2017 LEVEL 2	142	AlSi 304L /	ER 308 L	1,5mm (3mm ± 1 ≥ 0,75mm)	Ø33 (D ≥ 26,5)	FJ	Osman YIDIRM	20.10.2020
25	PR-PQR-025	EN 15614-1 2017 LEVEL 2	142	AlSi 316L /	ER 316 L	1,5mm (3mm ± 1 ≥ 0,75mm)	Ø33 (D ≥ 26,5)	FJ	Osman YIDIRM	20.10.2020
PREPARED BY					APPROVED BY			REVIEWED BY		
NAME : Furkan Serdar MUTLU					NAME :			NAME :		
SIGNATURE :					SIGNATURE :			SIGNATURE :		
DATE : 19.12.2018					DATE :			DATE :		

CALIBRATION

❖ Welding Machine Calibration and Verification Form

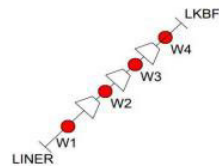
❖ Manometer and Clamp Ammeter Calibration Tracking Form

Manometer NO	MEASUREMEN T RANGE	CALIBRATION DATE	FINISH DATE	HOW MUCH DAY LEFT	
67682	0-06 BAR	25.10.2022	25.10.2023	125 DAY LEFT	
2265999	0-06 BAR	20.12.2022	20.12.2023	180Day Left	
2265998	0-06 BAR	20.12.2022	20.12.2023	180Day Left	
67692	0-10 BAR	25.10.2022	25.10.2023	124Day Left	
67693	0-10 BAR	25.10.2022	25.10.2023	124Day Left	
67691	0-10 BAR	25.10.2022	25.10.2023	124Day Left	
67694	0-10 BAR	25.10.2022	25.10.2023	124Day Left	
2265997	0-10 BAR	20.12.2022	20.12.2023	180Day Left	
2266001	0-10 BAR	20.12.2022	20.12.2023	180Day Left	
2266004	0-15 BAR	20.12.2022	20.12.2023	180Day Left	
2266003	0-15 BAR	20.12.2022	20.12.2023	180Day Left	
67685	0-16 BAR	25.10.2022	25.10.2023	124Day Left	
67686	0-16 BAR	25.10.2022	25.10.2023	124Day Left	
67684	0-16 BAR	25.10.2022	25.10.2023	124Day Left	BROKEN
67683	0-16 BAR	25.10.2022	25.10.2023	124Day Left	
67681	0-16 BAR	25.10.2022	25.10.2023	124Day Left	LOST
67689	0-25 BAR	25.10.2022	25.10.2023	124Day Left	
67687	0-25 BAR	25.10.2022	25.10.2023	124Day Left	
67688	0-25 BAR	25.10.2022	25.10.2023	124Day Left	
67690	0-25 BAR	25.10.2022	25.10.2023	124Day Left	
2266002	0-25 BAR	20.12.2022	20.12.2023	180Day Left	
2266000	0-25 BAR	20.12.2022	20.12.2023	180Day Left	
1A027BZIQJ4	0-25 BAR	1.09.2022	1.09.2023	70Day Left	DİGİTAL 1
1A027BZHQ31	0-25 BAR	1.09.2022	1.09.2023	70Day Left	DİGİTAL 2
1A027BZIM2Y	0-25 BAR	1.09.2022	1.09.2023	70Day Left	DİGİTAL 3
2207268	400A	22.12.2022	22.12.2023	182Day Left	CLAMP AMMETER

gemak PROMAK		KAYNAK MAKİNESİ KALİBRASYON VE DOĞRULAMA FORMU					TARİH 11.08.2020
							DOKÜMAN NO F.111
							REVİZYON R00
							SAYFA NO 1
KALİBRASYON VE DOĞRULAMA TARİHİ		08.08.2022					
SERİ NO	REFERANS	50	100	150	200	250	Sonuç
	AKIM/ VOLTAJ	A	A	A	A	A	
OSMAN NANLIKAYA PRM219	OKUNAN AMPER	50,30	100,70	151,30	201,90	252,10	OK
	OKUNAN VOLTAJ	11,20	14,70	15,20	22,70	22,20	
ALİ MARAL PRM 214	OKUNAN AMPER	50,90	101,70	152,40	202,90	253,80	OK
	OKUNAN VOLTAJ	10,20	12,70	13,70	15,70	16,20	
CİNAR ERÖKSÜZ PRM 206	OKUNAN AMPER	50,30	100,00	150,50	200,70	250,70	OK
	OKUNAN VOLTAJ	14,20	17,20	17,50	20,50	23,70	
ALPER KOÇAK PRM 208	OKUNAN AMPER	50,40	101,10	151,20	201,40	252,00	OK
	OKUNAN VOLTAJ	9,50	13,70	14,70	15,20	18,20	
İSA BÜTÜN PRM 236	OKUNAN AMPER	51,00	101,90	152,70	203,20	254,10	OK
	OKUNAN VOLTAJ	10,70	13,00	13,50	14,20	16,70	
MEHMET KONUK PRM 220	OKUNAN AMPER	51,70	103,60	152,40	202,20	254,30	OK
	OKUNAN VOLTAJ	11,40	12,70	13,20	17,40	19,40	
TANER ÖZTÜRK PRM 202	OKUNAN AMPER	50,70	100,90	150,80	200,70	251,10	OK
	OKUNAN VOLTAJ	12,80	13,50	14,40	14,70	17,60	
ZEKERİYA ÖZTÜRK PRM 207	OKUNAN AMPER	50,90	101,30	151,70	198,60	251,90	OK
	OKUNAN VOLTAJ	9,00	11,70	14,00	16,00	19,70	
GÖKMEN DİVARCI PRM 210	OKUNAN AMPER	50,70	100,80	151,30	200,50	251,90	OK
	OKUNAN VOLTAJ	12,70	13,00	16,00	17,00	19,00	
OĞUZ DOĞAN PRM 211	OKUNAN AMPER	50,80	101,50	153,10	204,00	255,50	OK
	OKUNAN VOLTAJ	10,70	12,80	16,50	18,20	25,70	
MUSTAFA KAHYA PRM 213	OKUNAN AMPER	48,00	100,30	151,80	202,40	251,60	OK
	OKUNAN VOLTAJ	11,20	12,70	16,40	18,60	21,30	
BERAT KARABULUT PRM 203	OKUNAN AMPER	50,50	101,20	151,00	201,20	251,80	OK
	OKUNAN VOLTAJ	12,50	13,70	14,80	15,00	17,90	

Equipment Installation Piping and 3D Controls

			WELD LOG																		
		Project Name: XXXX																			
No	DWR No	Picture No	Joint No	Joint type	Material 1				Material 2				Weld Process	WPS No	Weld Date	Welder	NDE				
					Dia.	Sch./ Thk.	Quality	Heat Number	Dia.	Sch./ Thk.	Quality	Heat Number					VT				
																	Ratio	Date	Result		
1	BCM-128	607	W1	BW	60.3	2	316L	35736	60.3	2	316L	35736	141	WPS18	21.10.2022	K28	100%	23.10.2022	OK		
2	BCM-128	608	W2	BW	60.3	2	316L	35736	60.3	2	316L	7014442	141	WPS18	21.10.2022	K28	100%	23.10.2022	OK		
3	BCM-128	609	W3	BW	60.3	2	316L	7014442	60.3	2	316L	35736	141	WPS18	21.10.2022	K28	100%	23.10.2022	OK		
4	BCM-128	610	W4	BW	60.3	2	316L	35736	60.3	2	316L	KY21N83	141	WPS18	21.10.2022	K28	100%	23.10.2022	OK		
5	BCM-130	611	W1	BW	88.9	2	316L	CN218Y	88.9	2	316L	1007771	142	WPS24	21.10.2022	K32	100%	23.10.2022	OK		
6	BCM-130	612	W2	BW	88.9	2	316L	1007771	88.9	2	316L	35736	142	WPS24	21.10.2022	K32	100%	23.10.2022	OK		
7	BCM-130	613	W3	BW	88.9	2	316L	35736	88.9	2	316L	1007771	141	WPS18	21.10.2022	K28	100%	23.10.2022	OK		



BCM - 128		
WELDING NO	DIAMETER	WELDING NAME
W1		
W2		
W3		
W4		
W5		
W6		
W7		
W8		



Control of CIP and Product lines with 100% Borescope camera

Welder Certification (EN ISO 9606-1, EN ISO 14732)

Traceability; Welder, Welding and Material.



PICTURE NO:607



PICTURE NO:608



PICTURE NO:609



PICTURE NO:610



PICTURE NO:611



PICTURE NO:612

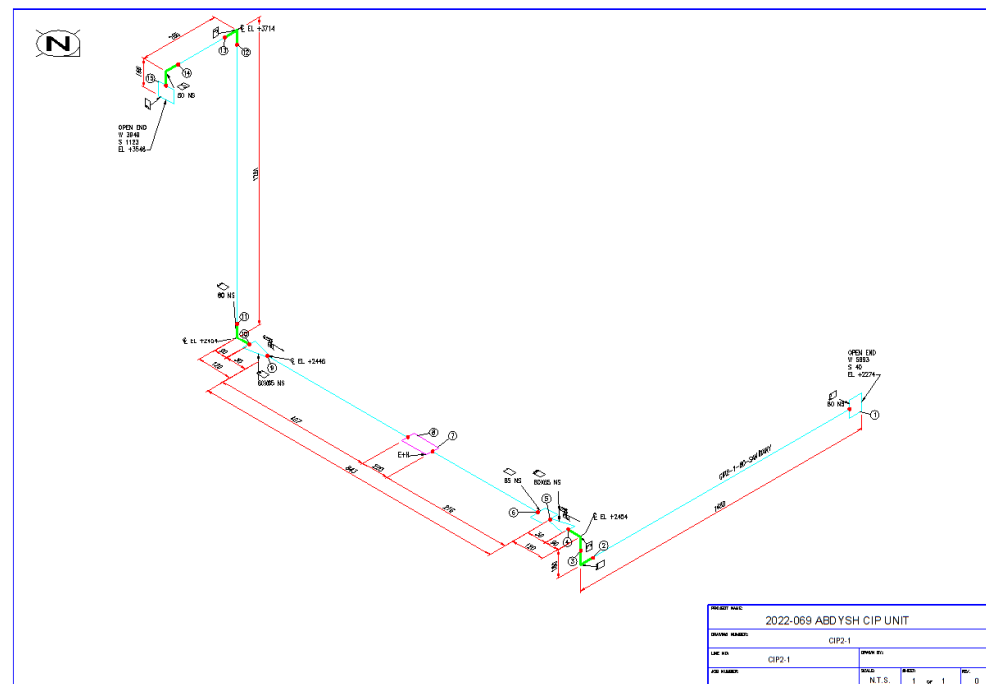
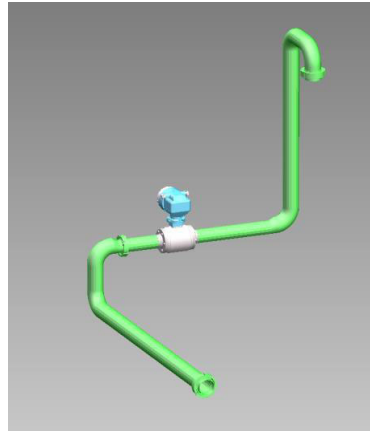
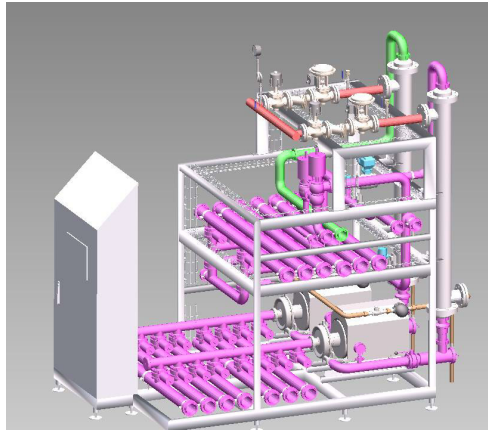


PICTURE NO:613



PICTURE NO:614

Equipment Installation Piping and 3D Controls



- ✓ Manufacturing control with 3D.
- ✓ Source traceability capability with isometry.

Thank You



GEMAK GIDA ENDÜSTRİ MAKİNALARI ve TİC. A.Ş.
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