



QASF Co. Ltd.

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Document Title **HEAD FORMING**

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Included Forms

Department **Engineering**

Type **Procedure**

Revision **D**

Date **27 Jun 2019**

Responsible person(s) **Engineering Manager**

APPROVAL

NAME: _____ POSITION: _____

SIGN: _____ DATE: _____



HEAD FORMING

1 INTRODUCTION

- 1.1 This procedure describes method of forming dished heads in the workshop of Trung Tin Co. (TTC).
- 1.2 Forming shall be in accordance with ASME Section VIII Division 1, UG-79.
- 1.3 QASF Co Ltd shall be responsible for final inspection, checking and acceptance.
- 1.4 QASF Co Ltd will provide TTC Technical Department the technical drawings which will address all technical requirements.
- 1.5 The TTC workshop shall be responsible for forming the dished heads in accordance with the technical drawings.
- 1.6 The TTC QC Inspector shall be responsible for monitoring the forming process, inspecting the finished heads and providing the inspection reports.
- 1.7 The Engineering Manager is responsible for the implementation of this procedure.

2 REVISIONS

Rev.	Date	Nature of Changes	Approved By
B	22.2.16	Issued for use	NHD
C	16.3.16	Clients' comments added	NHD
D	27.6.19	Clarity added for customer	NHD

3 PROCEDURE

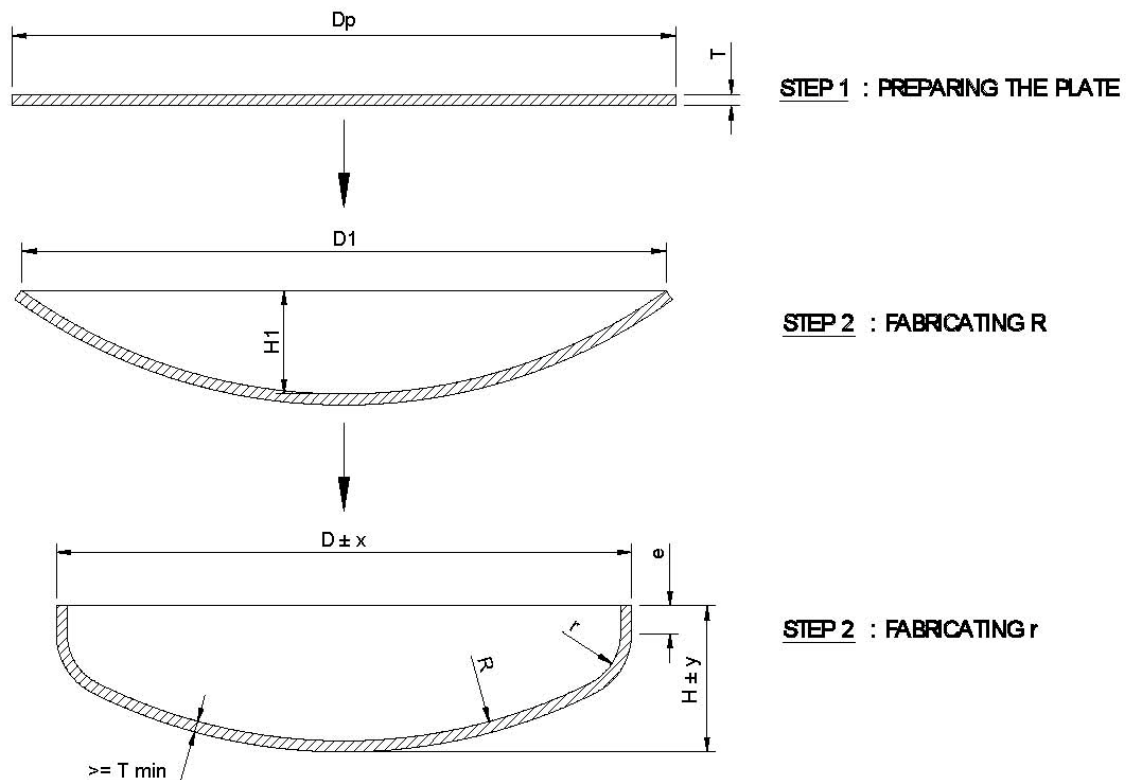
- 3.1 Material checks:
 - a) Certificate of Origin
 - b) Certificate of Quality
 - c) Check coded stamp is present and matches MRIR
 - d) Checking the thickness before fabricating
 - e) Checking the surface before fabricating
 - f) Taking samples for properties checks (if required)
- 3.2 Ensure all plate forming markings are as per the approved drawing.

3.3 Head forming involves 3 steps:

3.3.1 Step 1: Preparing the plate material

3.3.2 Step 2: Forming of the crown radius 'R'

3.3.3 Step 3: Forming of the knuckle radius 'r'



4 INSPECTION - TTC

- 4.1 Checking the final dimensions in accordance with the technical drawings.
- 4.2 Checking the thickness after fabricating T_{min}
- 4.3 Checking the roundness of head
- 4.4 Checking for any defects
- 4.5 Complete a TTC final inspection report

5 NDT

- 5.1 NDT shall be performed as requested from QASF Co Ltd.

6 RECEIVING – QASF

- 6.1 QASF Co Ltd will perform a receipt inspection, complete a Dimension Control Report and indicate final acceptance.

7 FORMS

[Dimensional Check Formed Heads](#)