

केन्द्रीय पेट्रोसायन अभियांत्रिकी एवं
प्रौद्योगिकी संस्थान (सिपेट)

(पूर्व में केन्द्रीय प्लास्टिक्स इंजीनियरिंग एवं तकनीकी संस्थान)

मुख्यालय, पीडीआई सेल

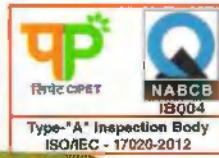
रसायन एवं पेट्रो रसायन विभाग

रसायन एवं उर्वरक मंत्रालय, भारत सरकार

टीवीके औद्योगिक इस्टेट, गिंडी, चेन्नई - 600 032.

दूरभाष : 044-29813708 (Direct) / 044-22254780 (Extn.-5)

ई-मेल : pdiho@cipet.gov.in



CENTRAL INSTITUTE OF PETROCHEMICALS
ENGINEERING & TECHNOLOGY(CIPET)

(Formerly Central Institute of Plastics Engineering & Technology)

Head Office, PDI Cell

Department of Chemicals & Petrochemicals

Ministry of Chemicals & Fertilizers, Govt. of India

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Phone : 044-29813708 (Direct) / 044-22254780 (Extn.-502)

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CIPET/QF/7741

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

W.O. Centre:Kochi
Camp at : M/s.Floflex Industries LLP,Erode

INSPECTION REPORT

1.	Report No : IB00423240500728	Date: 06/06/2023
2.	Name of the Indenter / Consignee with detailed address	The Executive Engineer, Kerala Water Authority, The Office of the Executive Engineer Project Division, Kattappana, Vellayamkudy. P.O
3.	Indenter Order No.& Date and Extension (if any)	No.358/DB1/2023/Pr.D-KTPA-MTPZA Dated : 05/05/2023 Work Order No SE/PHC/MVPA/D5/T-134/2022-23 dated 25.04.2023
4.	Details of the Consignee	The Executive Engineer, Kerala Water Authority, The Office of the Executive Engineer Project Division, Kattappana, Vellayamkudy. P.O
5.	Name of the Supplier / Contractor	Sri. N A Francis, Nellikunnel House Chathamattom, P O Kothamangaiam
6.	Supplier Order No. & Date (if any)	KM/0019/23-24 Dated : 26/04/2023
7.	Name and address of the Manufacturer / Inspection site	M/s.Floflex industries LLP, Plot No-Kk3 and Kk4,Sipcot Industrial Growth Centre, P.V.Palayam P.O, Perundurai Taluk, Erode Dist 638052,Tamilnadu
8.	Manufacturer / Supplier Inspection Call Letter No. & Date	FF/CIPET//CL/MAY-23/0010 (R) dated: 02.06.2023
9.	PDI Cell Assignment No. & Date	CIPET/HO/2023241451 dated 29.05.2023
10.	Date of inspection	Initiated on: 02/06/2023 Completed on: 06/06/2023
11.	Any other information	Manufacturer BIS License No. CM/L- 6500035611 Brand Name: Ashirvad by aliaxis ASHIRVAD SWASTH HDPE PIPES. JJM - WSS to Santhanpara, Rajakumary (part) and Senapathy (Part) Panchayaths in Idukki District-Package 111 A-Supplying and Laying Distribution and Providing FHTC in Rajakumary GP -Intimation for pipe testing

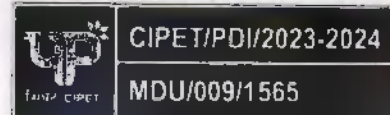
DETAILS OF THE STORES

Sl. No.	Description of the items	Quantity as per supplier order in meter	Quantity Inspected earlier (Cumulative)in meter	Quantity offered for Inspection in meter	Quantity Accepted in meter	Quantity Rejected in meter	Quantity Balance In meter
	HDPE Pipes as per IS 4984: 2016 with IS Certification Mark						
01	90MM PE100 PN8 SDR 17	5400	Nil	5400 (27nos X 200 meter Coil)	5400 (27nos X 200 meter Coil)	Nil	Nil
02	90MM PE100 PN10 SDR 13.6	9000	Nil	9000 (45nos X 200 meter Coil)	9000 (45nos X 200 meter Coil)	Nil	Nil
03	90MM PE100 PN16 SDR 9	27700	Nil	27700 (138nocs X 200 meter Coil) + (1no x 100 meter Coil)	27700 (138nos X 200 meter Coil) + (1no x 100 meter Coil)	Nil	Nil
04	110MM PE100 PN8 SDR 17	600	Nil	600 (6nos X 100 meter Coil)	600 (6nos X 100 meter Coil)	Nil	Nil
05	110MM PE100 PN10 SDR 13.6	900	Nil	900 (9nos X 100 meter Coil)	900 (9nos X 100 meter Coil)	Nil	Nil
06	25MM PE80 PN16 SDR 7.4	78000	Nil	78000 (156nos X 500 meter Coil)	78000 (156nos X 500 meter Coil)	Nil	Nil
07	20MM PE80 PN16 SDR 7.4	26000	Nil	26000 (52nos X 500 meter Coil)	26000 (52nos X 500 meter Coil)	Nil	Nil

Remarks: All accepted items are stamped thus-

For SL No. 06 & 07
HOLOGRAM USED S.L.NO - FROM A3631176 TO A3631383

For SL No : 1, 2, 3, 4 & 5



TOTAL - 208 NOS



1. Certified that the items as detailed above have been inspected and accepted. The accepted items may be dispatched to the consignee. The Inspection Document Nos Ref.No. IB00423240500728/1 to 7 dated 06/06/2023 are enclosed.
2. This inspection report is valid for 30 days and any Dispute/discrepancies/claims may be brought to the notice of the undersigned within 30 days from the date of issue of this report.

AUTHORIZED SIGNATORY
(Mr.SHASHI KUMAR A M & 1565)

Shashi Kumar A M 06/06/23

CC: 1. M / s Floflex Industries LLP - Perundurai, Erode 2. Sri. N A Francis Contractor 3. EE, KWA 4. CIPET - Kochi

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Code No. : 1565

W.O. Centre: Kochi

Camp at : M/s.Floflex Industries LLP,Erode

INSPECTION DOCUMENTS

Inspection Document NO.: IB00423240500728/ 1

Dated: 06/06/2023

Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy. P.O

Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET//CL/MAY-23/0010 (R) dated: 02.06.2023

Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : 90MM PE100 PN8 SDR 17
- b) Declared Value, if any : NIL
- c) Quantity : 5400 Meters (27nos X 200 meter Coil)
- d) Item omitted from the original scope of work if any : Nil
- e) Any Other Information : Batch Numbers : 202305100021

PART B: SUPPLEMENTARY INFORMATION

- a) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.1
		Depth	mm	Max. 0.2	0.19
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 3	2.0
	7.2	Length of straight pipe	Mtrs	--	Not Applicable
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	90.0	90.1
		Maximum	mm	90.6	90.5
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	5.3	5.35
7.4.1.2	Maximum	mm	6.0	5.80	
	Ovality	mm	Max.1.8	1.6	
5	8	Performance Requirement			
	8.1.1 Table-5	Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 5.7 MPa Induced Stress	----	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.4
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.34
		Carbon Black Dispersion	----	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.304
	8.5	Oxidation Induction Time	minutes	≥ 20.0	22.84
	8.6	Base Density at 27°C	kg/m ³	940 to 960	948.9
8.7	Elongation at Break	%	≥ 350	675.20	
8.8	Yield Strength	MPa	>15	18.25	
6	10	Marking on Pipe	----	Ashirvad by afixaxis swasth MFR BY FLOFLEX INDUSTRIES LLP, PE100 DN90 PN8 SDR17, 2023XXXXXXX IS 4984 CM/L 650035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764446587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023 , HD19010431 dated : 24/08/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)			
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.6	Overall Migration	Report No: 03794 , Dated : 30-06-2022	CIPET -- MADURAI	Reviewed & Confirmed
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7.	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

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- These witness result stated above relate Exclusive to the work order of the object(s) or the lot inspection.
- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%.
- Calibration Status of equipments/Instruments are verified.

(Signature)
06/06/23

AUTHORIZED SIGNATORY
(Mr. SHASHI KUMAR A M & 1565)

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CIPET/QF/7741

W.O. Centre:Kochi

Camp at : M/s.Floflex Industries LLP,Erode

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/ 2

Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy. P.O

Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET/UCL/MAY-23/0010 (R) dated: 02.06.2023

Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : 90MM PE100 PN10 SDR 13.6
b) Declared Value, if any : NIL
c) Quantity : 9000 Meters (45nos X 200 meter Coil)
d) Item omitted from the original scope of work if any : Nil
e) Any Other Information : Batch Numbers : 202305120021

PART B: SUPPLEMENTARY INFORMATION

b) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.1
		Depth	mm	Max. 0.2	0.19
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 3.0	2.5
		7.2	Length of straight pipe	Mtrs	--
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	90.0	90.1
		Maximum	mm	90.6	90.5
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	6.7	6.75
		Maximum	mm	7.5	7.39
7.4.1.2	Ovality	mm	Max.1.8	1.7	
5	8	Performance Requirement			
	8.1.1 Table-5	Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 5.7 MPa Induced Stress	----	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.3
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.53
		Carbon Black Dispersion	----	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.254
	8.5	Oxidation Induction Time	minutes	≥ 20.0	24.72
	8.6	Base Density at 27°C	kg/m ³	940 to 960	945.75
8.7	Elongation at Break	%	≥ 350	825.32	
8.8	Yield Strength	MPa	>15	18.54	
6	10	Marking on Pipe	----	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE100 PN10 DN90 SDR13.6, 2023XXXXXXXXX IS 4984 CML 6500035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764446587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023, HD19010431 dated : 24/08/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)			
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
5.	8.5	Overall Migration			
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7	8.8	Tensile Strength for Butt-fusion			
8	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

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- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%
- Calibration Status of equipments/Instruments are verified.

AUTHORIZED SIGNATORY
(M. SHASHI KUMAR A M & 1565)

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Code No. : 1565

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INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/ 3

Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy, P.O

Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET/CL/MAY-23/0010 (R) dated: 02.06.2023

Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : 90MM PE 100 PN 16 SDR 9
- b) Declared Value, if any : NIL
- c) Quantity : 27700 Meters (138nos X 200 meter Coil) + (1no x 100 meter Coil)
- d) Item omitted from the original scope of work if any : Nil
- e) Any Other Information : Batch Numbers : 202305170011 , 202305240011

PART B: SUPPLEMENTARY INFORMATION

- c) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.1
		Depth	mm	Max. 0.2	0.19
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 3.0	2.5
		Length of straight pipe	Mtrs	--	Not Applicable
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	90.0	90.1
		Maximum	mm	90.6	90.4
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	10.0	10.2
		Maximum	mm	11.1	10.30
7.4.1.2	Ovality	mm	Max.1.8	1.7	
5	8	Performance Requirement			
		Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 5.7 Mpa induced Stress	----	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.3
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.35
		Carbon Black Dispersion	----	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (180°C/5kgf)	g/10min	0.15 to 1.1	0.295
	8.5	Oxidation Induction Time	minutes	≥ 20.0	24.72
	8.6	Base Density at 27°C	kg/m ³	940 to 960	949.78
8.7	Elongation at Break	%	≥ 350	627.48	
8.8	Yield Strength	MPa	>15	17.40	
6	10	Marking on Pipe	----	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE100 PN16 DN90 SDR9, 2023XXXXXXX IS 4984 CML 6500035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764446587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023 , HD19010431 dated : 24/08/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.6	Overall Migration			
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7	8.8	Tensile Strength for Butt-fusion			
8	8.10	Slow Crack Growth Rate Test			

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(Mr.SHASHI KUMAR A M & 1565)

केन्द्रीय पेट्रोसायन अभियांत्रिकी एवं प्रौद्योगिकी संस्थान (सिपेट)

(पूर्व में केन्द्रीय प्लास्टिक्स इंजीनियरिंग एवं तकनीकी संस्थान)

मुख्यालय, पीडीआई सेल

रसायन एवं पेट्रो रसायन विभाग

रसायन एवं उर्वरक मंत्रालय, भारत सरकार

टीवीके औद्योगिक इस्टेट, गिंडी, चेन्नई - 600 032.

दूरभाष : 044-29813708 (Direct) / 044-22254780 (Extn.-502)

ई-मेल : pdiho@cipet.gov.in



CENTRAL INSTITUTE OF PETROCHEMICALS ENGINEERING & TECHNOLOGY(CIPET)

(Formerly Central Institute of Plastics Engineering & Technology)

Head Office, PDI Cell

Department of Chemicals & Petrochemicals

Ministry of Chemicals & Fertilizers, Govt. of India

TVK Industrial Estate, Guindy, Chennai - 600 032.

Phone : 044-29813708 (Direct) / 044-22254780 (Extn.-502)

Email : pdiho@cipet.gov.in

CIPET/QF/7741

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

W.O. Centre: Kochi
Camp. At : M/s.Floflex Industries LLP,Erode

INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/ 4

Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy. P.O

Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET/UCL/MAY-23/0010 (R) dated: 02.06.2023

Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : PE 100 PN8 110MM SDR 17
b) Declared Value, if any : Nil
c) Quantity : 600 Meters (6 Nos X 100 meter Coil)
d) Item omitted from the original scope of work if any : Nil
e) Any Other Information : Batch Numbers : 202301260011

PART B: SUPPLEMENTARY INFORMATION

- d) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.5
		Depth	mm	Max. 0.2	0.19
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be clearly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 3.0	2.5
		Length of straight pipe	Mtrs	6.0	6.01
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	110.0	110.1
		Maximum	mm	110.7	110.5
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	6.5	6.68
		Maximum	mm	7.3	7.21
7.4.1.2	Ovality	mm	Max 2.2	1.8	
5	8	Performance Requirement			
		Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 5.7 Mpa Induced Stress	----	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.1.1 Table-5				
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.4
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.29
		Carbon Black Dispersion	----	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.252
	8.5	Oxidation Induction Time	minutes	≥ 20.0	22.32
8.6	Base Density at 27°C	kg/m ³	940 to 960	947.92	
8.7	Elongation at Break	%	≥ 350	805.30	
8.8	Yield Strength	MPa	>15	18.34	
6	10	Marking on Pipe	----	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE100 PN8 DN110 SDR17. 2023XXXXXXX IS 4984 CML 6500035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764448587 Dated : 09/03/2023 . 764481438 Dated : 10/03/2023 . HD19010431 dated : 24/08/2022	IOOL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.6	Overall Migration			
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7.	8.8	Tensile Strength for Butt-fusion			
8.	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

- This Inspection document shall not be reproduced except in full without the written approval of the PDI Cell at CIPET Head Office.
- These witness result stated above relate Exclusive to the work order of the object(s) or the lot inspection.
- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%.
- Calibration Status of equipments/Instruments are verified.

(Signature)
0610083

AUTHORIZED SIGNATORY
(M. SHASHI KUMAR A M - 1565)

केन्द्रीय पेट्रोसायन अभियांत्रिकी एवं प्रौद्योगिकी संस्थान (सिपेट)

(पूर्व में केन्द्रीय प्लास्टिक्स इंजीनियरिंग एवं तकनीकी संस्थान)

मुख्यालय, पीडीआई सेल

रसायन एवं पेट्रो रसायन विभाग

रसायन एवं उर्वरक मंत्रालय, भारत सरकार

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दूरभाष : 044-29813708 (Direct) / 044-22254780 (Extn.-502)

ई-मेल : pdiho@cipet.gov.in



जादी अमृत महोत्सव

CENTRAL INSTITUTE OF PETROCHEMICALS ENGINEERING & TECHNOLOGY(CIPET)

(Formerly Central Institute of Plastics Engineering & Technology)

Head Office, PDI Cell

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Ministry of Chemicals & Fertilizers, Govt. of India

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CIPET/QF/7741

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

W.O. Centre: Kochi

Camp. At : M/s.Floflex Industries LLP,Erode

INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/ 5

Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy. P.O

Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET/ICL/MAY-23/0010 (R) dated: 02.06.2023

Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : PE 100 PN10 110MM SDR 13.6
b) Declared Value, if any : Nil
c) Quantity : 900 Meters (9 Nos X 100 meter Coil)
d) Item omitted from the original scope of work If any : Nil
e) Any Other Information : Batch Numbers : 202305110011

PART B: SUPPLEMENTARY INFORMATION

- e) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.5
		Depth	mm	Max. 0.2	0.18
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 3.0	2.5
		7.2	Length of straight pipe	Mtrs	—
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	110.0	110.1
		Maximum	mm	110.7	110.5
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	8.1	8.10
		Maximum	mm	9.1	8.55
7.4.1.2	Ovality	mm	Max.2.2	1.9	
5	8	Performance Requirement			
	8.1.1 Table-5	Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 5.7 Mpa Induced Stress	----	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.3
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.32
		Carbon Black Dispersion	---	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.302
	8.5	Oxidation Induction Time	minutes	≥ 20.0	22.32
	8.6	Base Density at 27°C	kg/m ³	940 to 980	949.78
8.7	Elongation at Break	%	≥ 350	734.54	
	8.8	Yield Strength	MPa	>15	16.49
6	10	Marking on Pipe	----	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE100 PN10 DN110 SDR13.6, 2023XXXXXXX IS 4984 CML 6500035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764448587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023, HD19010431 dated : 24/08/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)			
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.8	Overall Migration	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7	8.8	Tensile Strength for Butt-fusion			
8	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

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- These witness result stated above relate Exclusive to the work order of the object(s) or the lot inspection.
- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%.
- Calibration Status of equipments/Instruments are verified.

[Signature]
06/06/23

AUTHORIZED SIGNATORY
(M^{rs} SHASHI KUMAR A M - 1565)

केन्द्रीय पेट्रोसायन अभियांत्रिकी एवं प्रौद्योगिकी संस्थान (सिपेट)

(पूर्व में केन्द्रीय प्लास्टिक्स इंजीनियरिंग एवं तकनीकी संस्थान)
मुख्यालय, पीडीआई सेल
रसायन एवं पेट्रो रसायन विभाग
रसायन एवं उर्वरक मंत्रालय, भारत सरकार
टीवीके औद्योगिक इस्टेट, गिंडी, चेन्नई - 600 032.
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CENTRAL INSTITUTE OF PETROCHEMICALS
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(Formerly Central Institute of Plastics Engineering & Technology)

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CIPET/QF/7741

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

W.O. Centre:Kochi

Camp at : M/s.Floflex Industries LLP,Erode

INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/ 6
Issued to : The Office of the Executive Engineer,Kerala Water Authority, Project Division, Kattappana, Vellayarkudy. P.O
Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET//CL/MAY-23/0010 (R) dated: 02.06.2023
Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : 25MM PE 80 PN 16 SDR 7.4
b) Declared Value, if any : NIL
c) Quantity : 78000 Meters (156 Nos X 500 Meter Coil)
d) Item omitted from the original scope of work if any : Nil
e) Any Other Information : Batch Numbers : 202305210051 , 202305230051

PART B: SUPPLEMENTARY INFORMATION

f) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results
1	6.2	Colour of pipe	----	Black	Black
2	6.2.1	Dimension of Blue Stripes			
		Width	mm	Min. 3.0	3.3
		Depth	mm	Max. 0.2	0.19
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory
		Out of Squareness	mm	Max. 2.0	1.8
	7.2	Length of straight pipe	Mtrs	--	Not Applicable
4	7.4	Dimensions of Pipe			
		Outside Diameter			
	7.4.1.1 Table-3	Minimum	mm	25.0	25.1
		Maximum	mm	25.3	25.2
	7.4.1.1 Table-4	Wall Thickness			
		Minimum	mm	3.4	3.41
	Maximum	mm	3.9	3.62	
7.4.1.2	Ovality	mm	Max. 1.2	1.0	
5	8	Performance Requirement			
	8.1.1 Table-5	Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 4.9 MPa Induced Stress	---	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
	8.2	Longitudinal Reversion Test	%	Max ± 3 %	1.6
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.32
		Carbon Black Dispersion	----	Satisfactory	Satisfactory
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.40
	8.5	Oxidation Induction Time	minutes	≥ 20.0	24.20
	8.6	Base Density at 27°C	kg/m ³	940 to 960	945.15
8.7	Elongation at Break	%	≥ 350	723.24	
8.8	Yield Strength	MPa	>15	17.52	
6	10	Marking on Pipe	----	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE 80 PN16 25MM SDR 7.4, 2023XXXXXXX IS 4984 CML/ 6500035611	Marking are as per Standard

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report Issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764446587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023 , HD19010431 dated : 24/08/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)			
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.6	Overall Migration	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7	8.8	Tensile Strength for Butt-fusion			
8	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

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- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%
- Calibration Status of equipments/instruments are verified.

AUTHORIZED SIGNATORY

(Mr.SHASHI KUMAR A M & 1565)

केन्द्रीय पेट्रोसायन अभियांत्रिकी एवं
प्रौद्योगिकी संस्थान (सिपेट)
(पूर्व में केन्द्रीय प्लास्टिक्स इंजीनियरिंग एवं तकनीकी संस्थान)
मुख्यालय, पीडीआई सेल
रसायन एवं पेट्रो रसायन विभाग
रसायन एवं उर्वरक मंत्रालय, भारत सरकार
टीवीके औद्योगिक इस्टेट, गिंडी, चेन्नई - 600 032.
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**CENTRAL INSTITUTE OF PETROCHEMICALS
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CIPET/QF/7741

Name of Inspecting Official: SHASHI KUMAR A M
Code No. : 1565

W.O. Centre: Kochi
Camp at : M/s.Floflex Industries LLP,Erode

INSPECTION DOCUMENTS

Dated: 06/06/2023

Inspection Document NO.: IB00423240500728/7
Issued to : The Office of the Executive Engineer, Kerala Water Authority, Project Division, Kattappana, Vellayamkudy, P.O
Manufacturer / Supplier Inspection Call Letter No. & Date: FF/CIPET/CL/MAY-23/0010 (R) dated: 02.06.2023
Test report as per IS 4984:2016 (Latest Amendment)

PART - A: PARTICULARS OF STORES

- a) Description of the items : HDPE Pipe
Grade/Variety/Type/Size/Class etc. : 20MM PE 80 PN 16 SDR 7.4
b) Declared Value, if any : NIL
c) Quantity : 26000 Meters (52nos X 500 meter Coil)
d) Item omitted from the original scope of work if any : Nil
e) Any Other Information : Batch Numbers : 202301090051, 202301210051, 202301240051, 202301280051

PART B: SUPPLEMENTARY INFORMATION

g) Reference to sampling procedure : As per IS:4984 -2016 with latest amendment (Random Sampling)

PART C: RESULTS OF WITNESSED TESTS & REVIEW OF DOCUMENTS

Sl. No.	Clause No.	Tests Witnessed	Unit	Specified Requirements	Observed Results	
1	6.2	Colour of pipe	---	Black	Black	
2	6.2.1	Dimension of Blue Stripes				
		Width	mm	Min. 3.0	3.5	
		Depth	mm	Max. 0.2	0.18	
3	7.1	Visual Appearance	----	The Internal & External surfaces shall be smooth, clean and free from grooving and other defects. Ends shall be cleanly cut and shall be square with the axis of the pipe	Satisfactory	
		Out of Squareness	mm	Max. 2.0	1.7	
		7.2	Length of straight pipe	Mtrs	--	Not Applicable
4	7.4	Dimensions of Pipe				
		Outside Diameter				
		Minimum	mm	20.0	20.1	
	7.4.1.1	Table-3	Maximum	mm	20.3	20.12
			Wall Thickness			
	7.4.1.1	Table-4	Minimum	mm	2.8	2.83
			Maximum	mm	3.2	3.02
7.4.1.2	Ovality	mm	Max.1.2	0.15		
5	8	Performance Requirement				
	8.1.1	Table-5	Hydraulic Characteristic (IPCR) Acceptance Test 48 hrs at 80°C @ 4.9 Mpa Induced Stress	---	The sample shall show no signs of localized swelling, leakage or weeping and shall not burst during the Test Duration	No Sign of Failure Observed during test duration.
			8.2	Longitudinal Reversion Test	%	Max ± 3 %
	8.3	Carbon Black Content	%	2.5 ± 0.5	2.23	
		Carbon Black Dispersion	---	Satisfactory	Satisfactory	
	8.4	Melt Flow Rate (190°C/5kgf)	g/10min	0.15 to 1.1	0.44	
	8.5	Oxidation Induction Time	minutes	≥ 20.0	25.71	
	8.6	Base Density at 27°C	kg/m ³	940 to 960	946.41	
8.7	Elongation at Break	%	≥ 350	936		
8.8	Yield Strength	MPa	>15	18.21		
6	10	Marking on Pipe	---	Ashirvad by aliaxis ASHIRVAD SWASTH MFR BY FLOFLEX INDUSTRIES LLP, PE 80 PN16 20MM SDR 7.4, 2023XXXXXXX IS 4984 CML/ 6500035611	Marking are as per Standard	

Review of Documents (if any)

Sl. No.	Clause No.	Tests Parameters/ Documents	Certificate/ Report No. & Date	Report issued by	Review/ Remarks
1.	5.2, 6.1.1 Table 2	Raw material property Grade: 002DP48 HDPE D PIPES & IOCL	BATCH NO: 764446587 Dated : 09/03/2023 , 764481438 Dated : 10/03/2023 , HD19010431 dated : 24/09/2022	IOCL	Reviewed & Confirmed
		Raw material Property	BATCH NO : 5109 DATED : 16/04/2022	konspec	Reviewed & Confirmed
2.	8.1.1 Annex E	Internal Pressure Creep Rupture Test of Pipe (at 27°C for 100 h)	Report No: 03794 , Dated : 30-06-2022	CIPET - MADURAI	Reviewed & Confirmed
3.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 165 h)			
4.	do	Internal Pressure Creep Rupture Test of Pipe (at 80°C for 1000 h)			
5.	8.6	Overall Migration			
6.	8.1.2	Internal Pressure Creep Rupture Test of Joint Pipe (at 80° C for 48 h)			
7.	8.8	Tensile Strength for Butt-fusion			
8.	8.10	Slow Crack Growth Rate Test			

PART - D: REMARKS

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- Lab. Environmental Condition during the witness or Tests: Temperature 27± 2 °C & R.H. 65±5%
- Calibration Status of equipments/Instruments are verified.

(Signature)
AUTHORIZED SIGNATORY

(Mr.SHASHI KUMAR A M & 1565)