

Doc. Ref. No. : CMRL - BFI -03

Rev No. :

**INSPECTION OF BLOCK FACTORY**

FACTORY NAME :	
LOCATION :	
DATE OF VISIT:	

**1. EQUIPMENT INSPECTION**

CHECK OF LISTS	AIM	METHOD	FREQUENCY	REMARKS
<b>1.1 TESTING &amp; MEASURING EQUIPMENT</b>				
All testing & Measuring Equipment	Correct functioning & accuracy	Calibration, traceable to approved Standards or norms	On (re) installation , after major repair or once per year	
<b>1.2 STORAGE &amp; PRODUCTION EQUIPMENT</b>				
1. Storage of materials	Absence of contamination	Visual inspection or other appropriate method	On installation Weekly	
2. Weighing & volumetric batching equipment's	Correct functioning & according to manufactures declared accuracy.	Visual inspection & calibration , traceable to approved standard or norms	On installation Weighing- once a year Volumetric - Twice a year In case of doubt	
3. Mixers	Wear & correct functioning.	Visual inspection	Daily	
4. Moulds	Cleanliness & conditions	Visual inspection	Daily	

**2. MATERIALS INSPECTION**

CHECK OF LISTS	AIM	METHOD	FREQUENCY	REMARKS
<b>2.1 ALL MATERIALS</b>				
1. All materials	To ascertain that the consignment is as ordered & from correct source.	Inspection of delivery ticket or lable on the package showing conformity with order	Each delivery	
2. Cement	Conformity with block manufacturers requirements.	Appropriate test method or acceptable criteria	*First delivery from new source & yearly thereafter. *Conformity certificate shall be provided from cement manufacturer for each batch / delivery.	
3. Aggregate	Conformity with block manufacturers requirements.	Visual inspection & appropriate test method or acceptable criteria	*First delivery from new source *Grading & material finer than 75 micron & water absorption to be tested at least once per quarter. *Other tests as per Annex B to be tested at least once per year.	
4. Other Cementitious materials (Slica Fume or Ground Granulated Blast Furnace Slag - GGBS or Fly Ash)	Conformity with block manufacturers requirements.	Appropriate test method or acceptable criteria	First delivery from new source & yearly thereafter.	

5. Admixture	Conformity with block manufacturers requirements.	Appropriate test method or acceptable criteria	First delivery from new source & yearly thereafter.	
6. Pigments (wherever applicable)	Conformity with block manufacturers requirements.	Appropriate test method or acceptable criteria	First delivery from new source & yearly thereafter.	
7. Water	Conformity with block manufacturers requirements.	Appropriate test method or acceptable criteria	First use of new source	
8. Polystyrene insert - for Sandwich Blocks	Conformity with block manufacturers requirements.	Visual inspection to verify	Each delivery	
<b>3. PRODUCTION PROCESS INSPECTION</b>				
<b>CHECK OF LISTS</b>	<b>AIM</b>	<b>METHOD</b>	<b>FREQUENCY</b>	<b>REMARKS</b>
1. Mixture composition	Conformity with intended composition / mixture values (Visual on weighing equipments & production process documents)	Visual on weighing equipments Checking actions against factory procedures	Daily Daily	
2. Fresh concrete	Correct mixing (Visual check)	Visual Check	Daily	
3. Production	Conformity with documented factory procedures	Checking actions against factory procedures	Daily	
<b>4. FINISHED PRODUCT INSPECTION</b>				
<b>CHECK OF LISTS</b>	<b>AIM</b>	<b>METHOD</b>	<b>FREQUENCY</b>	<b>REMARKS</b>
<b>4.1: PRODUCT TESTING</b>				
<b>4.2: PAVING BLOCKS</b>				
1. Visual checking	Shall conform to FMBL - BF -02	Visual	Daily	
2. Size (Work size & dimensions)	Shall conform to FMBL - BF -02	ASTM C 140	One test per machine per production day	
3. Chloride & sulphate	Shall conform to FMBL - BF -02	BS 1881:Part 124	One test quarterly & for every change of materials source	
4. Compressive strength	Shall conform to FMBL - BF -02	ASTM C 140 or Annex A of FMBL standard	One test per machine per production day	
5. Water absorption	Shall conform to FMBL - BF -02	ASTM C 140	One test monthly	
6. Abrasion resistance	Shall conform to FMBL - BF -02	Test methods as per FMBL - BF -02	One test yearly	
<b>4.3: MASONRY BLOCKS</b>				
1. Visual checking	Shall conform to FMBL - BF -02	Visual	Daily	
2. Size (Work size & dimensions)	Shall conform to FMBL - BF -02	BS EN 772 : Part 16	One test per machine per production day	
3. Net Density	Shall conform to FMBL - BF -02	BS EN 772 : Part 13	One test per machine per production day	
4. Chloride & Sulphate	Shall conform to FMBL - BF -02	BS 1881:Part 124	One test quarterly & for every change of materials source	
5. Compressive strength	Shall conform to FMBL - BF -02	BS EN 772 : Part 1 or Annex A	One test per machine per production day	
6. Drying shrinkage	Shall conform to FMBL - BF -02	ASTM C 426	One test quarterly	

7. Thermal conductivity (whenever applicable)	Shall conform to FMBL - BF -02	Test methods as per FMBL - BF -02	One test yearly	
<b>4.4: FILLER BLOCKS</b>				
1. Visual checking	Shall conform to FMBL - BF -02	Visual	Daily	
2. Size (Work size & dimensions)	Shall conform to FMBL - BF -02	BS EN 772 : Part 16	One test per machine per production day	
3. Net Density	Shall conform to FMBL - BF -02	BS EN 772 : Part 13	One test per machine per production day	
4. Chloride & Sulphate	Shall conform to FMBL - BF -02	BS 1881:Part 124	One test quarterly & for every change of materials source	
5. Compressive strength	Shall conform to FMBL - BF -02	BS EN 772 : Part 1 or Annex A	One test per machine per production day	
6. Drying shrinkage	Shall conform to FMBL - BF -02	ASTM C 426	One test quarterly	
7. Thermal conductivity (whenever applicable)	Shall conform to FMBL - BF -02	Test methods as per FMBL - BF -02	One test yearly	
<b>4.5 : CONCRETE POLYSTYRENE SANDWICH BLOCKS</b>				
1. Visual checking	Shall conform to FMBL - BF -02	Visual	Daily	
2. Size (Work size & dimensions)	Shall conform to FMBL - BF -02	BS EN 772 : Part 16	One test per machine per production day	
3. Chloride & Sulphate	Shall conform to FMBL - BF -02	BS 1881:Part 124	One test quarterly & for every change of materials source	
4. Compressive strength	Shall conform to FMBL - BF -02	BS EN 772 : Part 1 or Annex A	One test per machine per production day	
5. Thermal conductivity (whenever applicable)	Shall conform to FMBL - BF -02	Test methods as per FMBL - BF -02	One test yearly	
NOTE :				
<b>FMBL AUDITOR</b>				
<b>BLOCK FACTORY Q.C. MANAGER</b>	NAME	:		
	SIGNATURE	:		
	NAME	:		
	SIGNATURE	:		
	NAME	:		
	SIGNATURE	:		
	NAME	:		