

 مجمع فولاد قبايات Ghaenat Steel Complex		ITP FORM (Inspection and Test Plan)			Project Name: Ghaenat Steel Complex		WI Code: GH.WIENG-01 Form Code: FR.ENG-01 Rev: 0 Page: 1/1	
					Item: Hydrocoupling + Adaptor		Date: 1405/04/11	
No.	Inspection Points	Reference Document	Acceptance Criteria	Verifying Document	Activity By			Remark
					Manuf.	TPI	Client	
1	Meeting before Manufacturing : Drawing, Design, Data Sheet, General Arrangement & Specification Check	Spec./ DWG	Spec./ DWG	DWG/ MOM	H		H	
2	NDT Operator Qualification (Level 2)	EN ISO 9712	EN ISO 9712	Operator Certificate	H		R	
3	Chemical Analysis of Aluminium Casting Parts	ASTM E1251:2017	ASTM B108	Quantometric Analysis Report/ Certificate	H		R	
4	Chemical Analysis of Forged Steel Shaft	ASTM E415:2021	ASTM E10083-3	Quantometric Analysis Report/ Certificate	H		R	
5	Material Test Certificate (MTC) Verification of Cast Iron Parts	EN 10204 Type 3.1 / EN 1561 / EN 1563	EN-GJL / EN-GJS grades as per approved drawings	Material Test Certificate	H		R	
6	Penetrant testing (PT)- to The Aluminium casting Parts	EN 1371-1	Severity Level 1 (SP1/ CP1)	PT Examination Report	H		R	
7	Ultrasonic Testing (UT)- to The Forge Steel Part (Shaft)	EN10228-3	EN10228-3 Quality Class 4	Ultrasonic Inspection Report	H		R	
8	Tensile Test of Forged Steel Shaft	ISO6892-1	EN10250-3 (Grade 42CrMo4 / 1.7225)	Tensile Test Report	H		R	
9	Hardness Test of Forged Steel Shaft	ASTM E10	EN 10083-3	Hardness Examination Report	H		R	
10	Check Heat Treatment Report (AL Aluminium Casting Parts T6 Heat Treatment)	ASTM B917/B917M	ASTM B917 (T6 Cycle)	Heat Treatment Report	H		R	
11	Visual and Dimensional Inspection (All Parts Fabricated befor Assembly)	DIN7168-m / DWG	Spec./ DWG	Dimensions Control Report	H		H	
12	Dynamic Balancing (All Parts Fabricated befor Assembly)	ISO1940/1 G6.3 @1500 rpm	ISO1940/1 G6.3 @1500 rpm	Dynamic Balance Report	H		H	
13	Leakage Test	Spec./ Procedure (Pressure: 5 bar, Working Fluid: Air, Duration: 5 min)	No Leakage Observed	Inspection Release Report	H		W	
14	DSC Test (Fusible Alloy)	ASTM E793-Third Party Procedure	Melting Point: 155-165 C	STA Examination Report	H		R	
15	Check Balancing (Fluid Coupling, Assembled and Dynamic Balanced)	ISO1940/1 G6.3 @1500 rpm	ISO1940/1 G6.3 @1500 rpm	Balancing Report	H		H	
16	Final Book & Inspection	Spec./ Procedure (Pressure: 5 bar, Working Fluid: Air, Duration: 5 min)	Spec./DWG	Final Book & All Inspection Reports	H		H	
17	Packing	***	Spec.	Packing List & Procedure	H		R	wooden box
18	Site Acceptance Test (Fluid Coupling Delivered)	Approved Specification / Test Procedure	Approved Specification / Test Procedure	Site Acceptance Test Report	R		H	Input/Output Speed, Slip, Oil Temp, Vibration, Leakage & Noise
Abbreviations: H: Hold Point W: Witness Point R: Document Review MOM: Minute of Meeting		Prepared by: Date:		Checked by: Date:		Approved by: Date:		