

INSPECTION & TEST PLAN (I.T.P) for Stand Gearbox						
Row	Scope	Requirement	M.I	P.I	T.P.I	Remarks
1	Drawing	Design and construction according to approved design and sample	H	H	R.A	
2	Material Requirement	List of all Materials Supplier	H	H	R	
3	Standard Materials Requirement		H	H	R	
4	Material Certificate	Mill certificate, chemical analysis, hardness test	H	R.A	H	
5	Machining Dimensional Inspection	Detailed shape & dimensional drawing	H	R.A	R.A	
6	Gear Hardness	Based on manufacturer's calculations	H	R.A	H	
7	Stress Relief	Heat treatment & stress relief process record	H	R.A	H	
8	UT / MT Test	Non-destructive testing of shafts and critical parts	H	R.A	H	
9	Dimensional Inspection	Before and after assembly dimensional verification	H	W	H	
10	Gear Contact Test	Blue test for gear contact pattern verification	H	W	H	
11	Backlash & Clearance Test	Measurement of gear backlash per design	H	W	H	
12	Oil Leakage Test	Check sealing and joints with oil at operating temperature	H	W	H	
13	Lubrication System Check	Oil circulation and filter check	H	W	H	
14	Performance Test (No Load)	24 hours run test at nominal speed	H	H	H	Location: Manufacturer's Workshop
14.1	Noise and Vibration Test	Noise level and vibration measurement within limits	H	H	H	
14.2	Temperature Rise Test	Temperature of bearing, oil, and housing after test	H	H	H	
15	Painting and Coating	According to approved painting procedure	H	R.A	R.A	
16	Final Inspection	Overall inspection, report review, marking, tagging	H	W	H	

17	Packing Inspection	Packing in wooden box, protection for transport	H	R.A	H	
18	Performance Test (Under Load)	10 days operation under actual load at site	H	H	R.A	Location: Purchaser's Site (Rolling Mill)
18.1	Noise and Vibration Test	Noise level and vibration measurement within limits	H	H	R.A	
18.2	Temperature Rise Test	Temperature of bearing, oil, and housing after test	H	H	R.A	
19	Final Book	***	H	H	H	



M.I = Manufacturer Inspector;

P.I = Purchaser Inspector;

T.P.I = Third-party inspector;

H: Hold Point = Hold on the production till Client and TPI Inspector performs inspection and supervise the required test

W: Witness Point = Manufacture shall notify client and TPI Inspector but there is no hold on the production; Client can waive this inspection based on his discretion and informs TPI Inspector accordingly.

R: Document Review = Review means Review document, which includes of material test certificates, WPS, PQR, NDT Procedures and etc.

A: Approval

SW: Spot Witness = for items with spot witness manufacture shall notify Client and TPI inspector as fulfilling the monitoring.