

Title: Inspection and Test Plan: Hub 2.5 MW- Casting & Machining			Document No. 950PW899		Rev. 1	Page 1	Of 4
					Confidential Class		
Doc. Type PTP	Issued by ERD Deputy	Language English	Derived from W0402-H05-DASH-304-W2E-001-6- DEEN			Rev. 1	
Rev.	Kind of Revision						
0	First Issue						
1	Imbalance control deleted.						
1	M.Jokar	A.Rezaei			Sh.Arefi	5.28.2017	
0	M.Jokar	A.Rezaei			Sh.Arefi	Jan.2016	
Rev.	Prepared	Checked	Checked	Checked	Approved	Date	

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No.	Part/Process Description	Inspection or Test	Reference Document	Performed By	Verified by			Quality Docs (EN 10204-2005)	Remarks
					1	2	3		
Main Shaft Coupling - Casting									
1 Pre casting									
1.1		check and review of project	-	supplier	H	R	-	-	Note 1
1.2		Casting drawing check	-	supplier	H	R	-	-	Note 2
1.3		Check of Model	EN 12890/ H1	supplier	R	R	-	3.1	
2 Casting									
2.1		Chemical analyses GJS-400-18U-LT	EN 1563	supplier	R	R	-	3.1	
2.2		Test block cutting	-	supplier	H	R	-	-	At least 3 test block needed
2.3		Tensile test	EN 1563/ EN 10002-1	supplier	H	R	-	3.1	
2.4		Charpy impact test	EN 1563/ EN 148	supplier	H	R	-	3.1	
2.5		Hardness test	EN ISO 6506-1	supplier	W	R	-	3.1	
2.6		Examination of surface condition	DIN EN 1370/DIN EN 1599/class 3	supplier	W	R	-	3.1	Note 3
2.7		Microstructure	EN ISO 945/ DIN EN 1563	supplier	H	R	-	3.1	Note 4

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					1	2	3		
2.8		Dimensional check	Drawing	supplier	W	R	-	3.1	
2.9		Ultrasonic thickness check	Drawing/ DIN 1685 - GTB -17	supplier	W	R	-	3.1	
2.10		Ultrasonic Test	EN 12680-3- level 2	supplier	W	R	-	3.1	
2.11		MT/PT	EN 1369 Level 3 (SM3/LM3C/AM3C)	supplier	W	R	-	3.1	
2.12		Marking	W0402-H05-DASH-304-W2E-001-6-DEEN	supplier	W	R		-	
3	Pre machining								
3.1		Checking For Completeness Of The Q.A Documents	-	supplier	H	R	-	-	
4	After machining								
4.1		MT/PT	EN 1369 Level 3 (SM3/LM3C/AM3C)	supplier	W	R	-	3.1	
4.2		Dimensional check	Drawing/ W0402-N042-TPRO-304-W2E-001-1-EN/ ISO 2768-mk	supplier	W	R	-	3.1	

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No.	Part/Process Description	Inspection or Test	Reference Document	Performed By	Verified by			Quality Docs (EN 10204-2005)	Remarks
					1	2	3		
4.3		Weight control	W0402-H05-DASH-304-W2E-001-6-DEEN	supplier	W	R		3.1	
5	Coating								
5.1		Thickness Check	DIN EN ISO 2808	supplier	W	R	-	3.1	Note 5
5.2		Coating Strength	ISO 2409	supplier	W	R	-	3.1	Note 6 ,7
6	Final Check								
6.1		Checking For Completeness Of The Q.A Documents	-	Supplier & pars	H	R	-	3.1	
<p> Definition of Terms and Symbols. H: Hold point - The inspection/test will be notified, and held until presence of participant. W: Witness point - The inspection/test will be notified. R: Review of document - The Quality Documents (Records/Certificates) will be received. 1: Mapna Generator Co.(Pars). 2: Client or its Representative. : Other (Based on the contract). *: For Mapna Generator Co. (PARS) Hold and Witness , Supplier Shall Notify Mapna Generator in Written at Proper Time Not Less Than 21 Working Days Before Inspection . Note 1: before starting casting, supplier must provide a Manufacture Process Plane (MPP) that consist of all manufacturing process, casting drawings and inspections test. MPP must previously approved by purchaser. Note 2: Casting drawing (consist of casting size, test block size and location and etc.) must be prepare by casting-company and approve by client. Note 3: Repair welding is not permitted. Repair and mending work are only allowed after consultation and release through the client. Note 4: Structure must consist of at least 90% ferrite portion and 90% of the graphite in spherical form V and VI according to EN ISO 945. Note 5: Thickness of coating have to be in accordance with W0102-Q06-001-SPEC-304-W2E-001-4 Note 6: all machined surface must be protected with Tectyl. Note 7: All treads must be covered with plastic plug . </p>									