

Title: <b>Inspection and Test Plan: Main Shaft Coupling - Casting</b>			Document No.  950PW951		Rev. 0	Page 1	Of 3
					Confidential Class		
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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		
<b>Main Shaft Coupling - Casting</b>									
<b>1</b>	<b>Pre casting</b>								
1.1		check and review of project documents	-	supplier	R	-	-	-	Note 1
1.2		Casting drawing check	-	supplier	H	-	-	-	Note 2
1.3		Check of Model	EN 12890/ H1	supplier	H	-	-	3.1	
<b>2</b>	<b>Casting</b>								
2.1		Chemical analyses GJS-400-18U-LT	EN 1563	supplier	R	-	-	3.1	
2.2		Test block cutting	-	supplier	H	-	-	-	At least 3 test block needed
2.3		Tensile test	EN 1563/ EN 10002-1	supplier	W	-	-	3.1	
2.4		Charpy impact test	EN 1563/ EN 148	supplier	W	-	-	3.1	
2.5		Hardness test	EN ISO 6506-1	supplier	W	-	-	3.1	
2.6		Examination of surface condition	DIN EN 1370 Drawing	supplier	W	-	-	3.1	Note 3
2.7		Microstructure	EN ISO 945/ DIN EN 1563	supplier	W	-	-	3.1	Note 4

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					1	2	3		
2.8		Dimensional check	Drawing	supplier	W	-	-	3.1	
2.9		Ultrasonic thickness check	Drawing/ DIN 1685 - GTB -17	supplier	W	-	-	3.1	
2.10		Ultrasonic Test	EN 12680-3- level 2	supplier	W	-	-	3.1	Note 5
2.11		MT/PT	EN 1369 Level 3 (SM3/LM3C/AM3C)	supplier	W	-	-	3.1	Note 5 & 6
<b>3</b>	<b>After machining</b>								
3.1		MT/PT	EN 1369 Level 3 (SM3/LM3C/AM3C)	pars	W	-	-	3.1	Note 5 & 6
3.2		Dimensional check	Drawing/ ISO 2678	pars	W	-	-	3.1	
<b>4</b>	<b>Coating</b>								
4.1		Thickness Check	DIN EN ISO 2808	pars	W	-	-	3.1	Note 7

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					1	2	3		
4.2		Coating Strength	ISO 2409	pars	W	-	-	3.1	Note 8
<b>5</b>	<b>Final Check</b>								
5.1		Checking For Completeness Of The Q.A Documents	-	Supplier & pars	R	-	-	3.1	

	<p>Definition of Terms and Symbols.</p> <p>H: Hold point - The inspection/test will be notified, and held until presence of participant.</p> <p>W: Witness point - The inspection/test will be notified.</p> <p>R: Review of document - The Quality Documents (Records/Certificates) will be received.</p> <p>1: Mapna Generator Co.(Pars).</p> <p>2: Client or its Representative.</p> <p>: Other ( Based on the contract ).</p> <p>*: 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 .</p> <p>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.</p> <p>Note 2: Casting drawing (consist of casting size, test block size and location and etc.) must be prepare by casting-company and approve by employer.</p> <p>Note 3: Repair welding is not permitted.</p> <p>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.</p> <p>Note 5: Area of Magnetic and ultrasonic test in accordance with: W0402-N042-000-001-002-02-DMDR-W2E.</p> <p>Note 6: magnetic test must be performed after machining, so final acceptance of casting part performed at this phase.</p> <p>Note 7: Types of coating have to be in accordance with W0402-N042-000-001-003-01-DMDR-W2E.</p> <p>Note 8: Thickness of coating have to be in accordance with W0102-Q06-001-SPEC-304-W2E-001-4</p>
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