

**Document Name:**

- Contractor Quality Control Plan for Rotating Equipment Installation
- Inspection and Test Plan for Rotating Equipment Installation

| No.        | Item description   | Responsibility |     |       |
|------------|--|----------------|-----|-------|
|            |  | CC             | TPI | Owner |
| <b>3.4</b> | <b>Pumps, Steam turbine, compressors, fans, blowers, generator and drivers (rotating machines)</b>   |                |     |       |
| 3.4.1      | Pre-installation check<br>1) Foundation and anchor bolts<br>- Dimension<br>- Visual check<br>2) Visuals check<br>3) 3) Identification marking    | H              |     |       |
| 3.4.2      | Installation<br>1) Orientation<br>2) Elevation   | H              |     |       |
| 3.4.3      | Assembling layout and arrangement  | H              |     |       |
| 3.4.4      | Leveling and grouting<br>1) Leveling<br>2) Grouting (Refer to the section 1.2.5 grout and mortar finishing for foundation)                       | H              |     |       |
| 3.4.5      | Alignment<br>1) Initial alignment<br>2) Alignment after piping connection  | H              |     |       |
| 3.4.6      | Tightness of connection and fastening  | H              |     |       |
| 3.4.7      | Final check<br>1) Visual check (included cleaning for internal)<br>2) Grease and oil for lubrication<br>3) Free turning<br>4) Rotating direction | H              |     |       |
| 3.4.8      | Compressor and pump<br>1) Insertage diaphragms and inlet guide vanes<br>2) Labyrinths packing<br>3) Shafts and shaft sealing                     | H              |     |       |

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|            |  |   |  |  |
|------------|--|---|--|--|
|            | <ul style="list-style-type: none"> <li>4) Bearing and bearing housings</li> <li>5) Impellers</li> <li>6) Vibration and position detectors</li> <li>7) - Bolt torque test</li> </ul>  |   |  |  |
| 3.4.9      | <p><b>Turbine</b></p> <ul style="list-style-type: none"> <li>1) Rotors and shafts</li> <li>2) Bearing and bearing housing</li> <li>3) Clearance check and adjustment</li> <li>4) Final assembly of internal</li> <li>5) Shaft sealing</li> <li>6) - Bolt torque test</li> </ul>  | H |  |  |
| 3.4.10     | <p><b>Generator</b></p> <ul style="list-style-type: none"> <li>1) Roll in after discharging of the stator</li> <li>2) Inserting the rotor and assembling the lower half bearing bracket</li> <li>3) Mounting and welding of terminal box</li> <li>4) Mounting of the bushing current transformer</li> <li>5) Inserting and assembly of gas cooler</li> <li>6) Measurement of air gap and mounting of fan nozzle ring</li> <li>7) Mounting of fan entrance vanes</li> <li>8) Filling of seal</li> <li>9) Mounting of rotor fan, inner oil discharge and adjustment of gap</li> <li>10) Assembly upper half bearing bracket</li> </ul> | H |  |  |
|            | <ul style="list-style-type: none"> <li>11) Assembly and disassembly of oil seal</li> <li>12) Temporary assembly and centering of brush, holder</li> <li>13) Installation of lagging cover pedestal</li> </ul>  | H |  |  |
| <b>3.5</b> | <b>Centrifuge, mixers, agitator (rotating machine II)</b>  |   |  |  |
| 3.5.1      | <p><b>Pre-installation check</b></p> <ul style="list-style-type: none"> <li>1) Dimension                             <ul style="list-style-type: none"> <li>- Setting flange</li> <li>- Setting bolts</li> </ul> </li> <li>2) Visual checks</li> </ul>   | H |  |  |

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|       |   |   |  |  |
|-------|---|---|--|--|
|       | 3) Identification marking   |   |  |  |
| 3.5.2 | Installation  | H |  |  |
| 3.5.3 | Assembling layout arrangement   | H |  |  |
| 3.5.4 | Alignment and run out   | H |  |  |
| 3.5.5 | Thighness of connection and fastening   | H |  |  |
| 3.5.6 | Final check<br>1) Visual check<br>2) Grease and oil lubrication<br>3) Free turning<br>4) Rotating direction   | H |  |  |
| 3.5.7 | Mixer<br>1) Flange are clean and show no damage<br>2) StaTPI mixer housing is inspected for damage & cracks<br>3) Internal elements are inspected for damage<br>4) Retaining bars are downstream of the elements<br>5) - Inlet and outlet connected | H |  |  |

**CC:** Construction Contractor

**TPI:** Third Party Inspection

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

If you want to use this draft for inspection and test plan you need to fill the TPI and Owner Column based your project requirement. You may use following abbreviation for filling the columns:

**W: Witness Point;** Manufacture shall notify client and TPI Inspector but there is no hold on the Construction;

**R: Document Review;** Review means Review document, which includes of material test certificates, test reports, records and etc.

**A: Approval**

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**SW: Spot Witness;** for items with spot witness contractor shall notify TPI inspector as fulfilling the monitoring;