

## Inspection and Test Plan for Fan and Blower

No.	Inspection and Test Plan	Reference Document	Acceptance Criteria	Verifying Document	Activity By			Remark
					Manuf.	TPI	Client	
1	Pre-Inspection Meeting	Spec.	Spec.	MOM	H	H	H	-
<b>Before Manufacturing</b>								
2	DWG, Design, Calculation Document	API 673	API 673	DWG, Calculation book	H	R	A	-
3	WPS&PQR	ASME	ASME IX	Welding Book	H	R	A	-
4	Welder Qualification Certificates	ASME	ASME IX	Certificates	H	R	-	-
5	NDT procedures	ASME	ASME V,VIII, IX	Procedures	H	R	A	-
6	NDE Personnel Certificates	ASME	ASME V	Certificates	H	R	-	-
7	PWHT Procedure (if needed)	API 673/ASME	API 673/ASME	Procedure	H	R	A	-
8	Fan/Blower Impeller Dynamic and Overspeed Balance Test Procedures	API 673	API 673	Procedure	H	R	A	-
9	Fan and Blower Mechanical Running Test Procedure	API 673	API 673	Procedure	H	R	A	-
10	Fan and Blower Performance Test Procedure	AMCA Standard	AMCA Standard	Procedure	H	R	A	-
11	Pressure Test Procedure	API 673/ASME VIII	ASME VIII/API 673	Procedure	H	R	A	-

12	Painting Procedure	Spec.	Spec.	Procedure	H	R	A	-
Materials								
13	Material Certificates	ASME II/ASTM	ASME II/ASTM	Original Material Certificates	H	R	-	-
14	Material Identification	ASME II/ASTM	ASMEII/ASTM	Report	H	W	-	-
15	Visual, Dimension and Marking Control (Fan Housing, Ducting, Gaskets, Nut and Bolts, Bearings, Bearing Houses, Shaft, Wheels and etc.)	ASME II/ASTM	ASME II/ASTM	Report	H	W	-	-
During Fabrication								
16	Components Visual Inspection for damage	API 673	API 673	Report	H	W	-	
17	Components Dimensional Check to Drawing Requirements	DWG/API 673	DWG/API 673	Report	H	W	-	
18	Visual Examination of Welded parts	ASME/API 673	ASME/API 673	Report	H	W	-	
19	Components Confirmation of Satisfactory NDE	ASME/API 673	ASME/API 673	Report	H	W	-	
21	Ducting inspection (Welded, Riveted, Rolled)	Procedure/API 673	Procedure/API 673	Report	H	H	-	

22	Ducting Pressure Test	WPS/API 673	WPS/API 673	Report	H	W	-	
27	Auxiliary Equipment Inspection and Test i.e. Silencer, Piping, Lube oil System and etc.	API 673	API 673	Report	H	W	-	
28	Impeller visual and Dimensional Inspection	DWG/API 673	DWG/API 673	Report	H	W	-	
30	Impeller Confirmation of Satisfactory NDE	ASME/API 673	ASME/API 673	Report	H	W	-	-
31	Impeller Dynamic Balance Test	Procedure/API 673	Procedure/API 673	Report	H	H	-	-
32	Impeller overspeed Test	Procedure/API 673	Procedure/API 673	Report	H	H		
35	Fan/Blower Mechanical Running Test	Procedure/API 673	Procedure/API 673	Report	H	H	-	-
38	Fan/Blower Performance Test	Procedure/API 673	Procedure/API 673	Report	H	H	-	-
<b>Final Inspection</b>								
39	Final Visual & Dimensional Check	DWG/Spec.	DWG	Report	H	H	-	-
40	Surface Preparation and Painting	Procedure	SSSP/Spec.	Report	H	W	-	-
41	Check of Name Plate	DWG	DWG	Report	H	H	-	-
42	Check of Final Book	Spec.	Spec.	DWG/ P.O	H	R	-	Submitted by

Documentation								
43	Inspection Reports	Spec./DWG	Spec./DWG	Report	H	R	-	-
44	NCR	Spec./DWG	Spec./DWG	Report	H	R	-	-
45	Review Final Data Report	Spec./DWG	Spec./DWG	Report	H	R	-	-
Pre-Shipment Inspection								
46	Preservation and Packing	Spec.	Spec.	Report	H	H	-	-
47	Marking	Spec.	Spec.	Report	H	H	-	-
48	Loading Inspection	Spec.	Spec.	Report	H	H	-	-
49	Shipping Document Control	Procedure	Spec.	Packing List	H	H	-	-
auxiliary equipment such as lube oil system, filter, strainer, piping, steel structure and etc. are not included to this ITP								

Abbreviations:

H: Hold Point = Hold on the production till 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 TPI inspector as fulfilling the monitoring;  
For example one random visit for whole UT tests or one or two visits for whole surface preparation works for painting.

MOM: Minute of Meeting

P.O: Purchase Order

for more information review following articles:

# **www.inspection-for-industry.com**

<http://www.inspection-for-industry.com/third-party-inspection-for-fan-and-blower.html>

<http://www.inspection-for-industry.com/inspection-and-test-plan-for-fan-and-blower.html>