

## Inspection and Test Plan for UPS Storage Battery

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	IEC and ISO	IEC and ISO	DWG, Calculation book	H	R	A	-
3	Storage Battery Capacity Test Procedure	IEC and ISO	IEC and ISO	Procedure	H	R	A	
4	Storage Battery Leakage Test Procedure	IEC and ISO	IEC and ISO	Procedure	H	R	A	
5	Storage Battery Voltage Test Procedure	IEC and ISO	IEC and ISO	Procedure	H	R	A	
6	Storage Battery Short Circuit Absence Test	IEC and ISO	IEC and ISO	Procedure	H	R	A	
<b>Materials</b>								
7	Raw Material Inspection	ASTM	ASTM	Original Material Certificates	H	H	-	-
8	Review of Certificates	ASTM	ASTM	Certificates	H	H	-	-
9	Material Identification	ASTM	ASTM	Report	H	H	-	
<b>During Fabrication</b>								
10	Fabrication Inspection	DWG/Spec	DWG/Spec	Report	H	SW	-	

11	Outline and Interface Dimensional Inspection	DWG/Spec	DWG/Spec	DWG/Spec	H	SW	-	
12	Physical Check for Cells and ancillaries for their type, Quantity, rating, freedom from damages and deformation	DWG/Spec	DWG/Spec	Report	H	W	-	
13	Storage Battery Capacity Test Procedure	Procedure	Procedure	Report	H	H	-	
14	Storage Battery Leakage Test Procedure	Procedure	Procedure	Report	H	H	-	
15	Storage Battery Voltage Test Procedure	Procedure	Procedure	Report	H	H	-	
16	Storage Battery Short Circuit Absence Test	Procedure	Procedure	Report	H	H	-	
<b>Final Inspection</b>								
17	Final Visual & Dimensional Check	DWG	DWG	Report	H	H	-	-
18	Check of Final Book	-	Spec.	DWG/ P.O	H	R	-	
<b>Documentation</b>								
19	Inspection Reports	Spec./DWG	Spec./DWG	Report	H	R	-	-
20	NCR	Spec./DWG	Spec./DWG	Report	H	R	-	-
21	Review Final Data Report	Spec./DWG	Spec./DWG	Report	H	R	-	-
<b>Pre-Shipment Inspection</b>								

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22	Preservation and Packing	Spec.	Spec.	Report	H	H	-	-
23	Marking	Spec.	Spec.	Report	H	H	-	-
24	Loading Inspection	Spec.	Spec.	Report	H	H	-	-
25	Shipping Document Control	Procedure	Spec.	Packing List	H	H	-	-

## 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:

<http://www.inspection-for-industry.com/third-party-inspection-for-Storage-battery.html>

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