Inspection and Test Plan for Induction Motor

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	-
Before Manufacturing								
2	DWG, Design, Calculation Document	IEC, ISO	IEC, ISO	DWG, Calculation book	H	R	A	-
3	Motor Winding Resistance Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
4	Motor No Load Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
5	Motor Locked Rotor Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
6	Motor Low Frequency Locked Rotor Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
7	Motor Determination of Characteristics Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
8	Motor Temperature Rise Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	

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9	Motor Resistance Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
10	Motor Dielectric Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
11	Motor Vibration Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
12	Motor Noise Test Procedure	IEC, ISO	IEC, ISO	Procedure	H	R	A	
13	Painting Procedure	SSPC	SSPC	Procedure	H	R	A	-
Materials								
14	Raw Material Inspection	ASTM	ASTM	Original Material Certificates	H	H	-	-
15	Review of Certificates	ASTM	ASTM	Certificates	H	H	-	-
16	Material Identification	ASTM	ASTM	Report	H	H	-	
During Fabrication								
17	Assembly Inspection	DWG	DWG	Report	H	SW	-	

18	Checking of Outline Dimensions, Interface Dimensions, Bus Bar Dimensions and Clearances and other Specified Dimensions	DWG	DWG	Report	H	SW	-	
19	Tightness/Torque of Terminals and Degree of Protection	DWG/Spec	DWG/Spec	Report	H	SW	-	
20	Checks that all Instruments, Control Switches, and etc. are Correctly Rated and are Correctly Located, with Specified Labeling.	DWG/Spec	DWG/Spec	Report	H	SW	-	
21	Motor Winding Resistance Test	Procedure	Procedure	Report	H	H	-	
22	Motor No Load Test	Procedure	Procedure	Report	H	H	-	
23	Motor Locked Rotor Test	Procedure	Procedure	Report	H	H	-	
24	Motor Low Frequency Locked Rotor Test	Procedure	Procedure	Report	H	H	-	

25	Motor Determination of Characteristics	Procedure	Procedure	Report	H	H	-	
26	Motor Temperature Rise	Procedure	Procedure	Report	H	H	-	
27	Motor Resistance Test	Procedure	Procedure	Report	H	H	-	
28	Motor Dielectric Test	Procedure	Procedure	Report	H	H	-	
29	Motor Vibration Test	Procedure	Procedure	Report	H	H		
30	Motor Noise Test	Procedure	Procedure	Report	H	H	-	
Final Inspection								
31	Final Visual & Dimensional Check	DWG	DWG	Report	H	H	-	-
32	Surface Preparation and Painting	Procedure	Procedure	Report	H	W	-	-
33	Check of Final Book	Spec.	Spec.	DWG/ P.O	H	R	-	
Documentation								
34	Inspection Reports	Spec./DWG	Spec./DWG	Report	H	R	-	-
35	NCR	Spec./DWG	Spec./DWG	Report	H	R	-	-
36	Review Final Data Report	Spec./DWG	Spec./DWG	Report	H	R	-	-
Pre-Shipment Inspection								
37	Preservation and Packing	Spec./DWG	Spec.	Report	H	H	-	-

38	Marking	Spec.	Spec.	Report	H	H	-	-
39	Loading Inspection	Spec.	Spec.	Report	H	H	-	-
40	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-induction-motor.html

http://www.inspection-for-industry.com/inspection-and-test-plan-for-induction-motor.html