




## INSPECTION & TEST PLAN

p. : SST-QA-ITP-67/001  
Rev. 0

PROCESS ACTIVITY	WORK INSTRUCTION/ PROCEDURE	ACCEPTANCE/ CRITERIA	INSPECTION & TEST METHOD	EQUIPMENTS/ INSTRUMENTS	DEPARTMENT& PERSON RESPONSIBLE
Raw Materials Inspection	Test Procedure Doc. No. SST-TPD001-Rev.3		1. Review Mill Certificate Mechanical Test & chemical Test 2. Visual Inspection 3. Dimensional Inspection	1. Vernier caliper 2. Measuring Tape 3. Camber gauge 4. Micrometer	QA Department Production Planning Department
1. Steel Angles 2. C-Channel		TIS-1227 (SS400)			
3. H-Beam		TIS-1227 (SS400)			
4. Plate		TIS-1479 (SS400)			
5. Round Bar		TIS-20 (SR24)			
6. Pipe		TIS-107 (STK400)			
7. Bolt		ISO 898-1 (Gr.8.8), ASTM A394T0			
8. Nut		ISO 898-2 (Gr.8), ASTM A563			
Inspection of Assembly	Fabrication and Quality Manual Doc. No. SST-FQM 001-Rev.0	See 13. Trial Assembly (Page 12/17)	1. Visual Inspection 2. Dimensional Inspection	1. Vernier caliper 2. Measuring Tape	Prototype Assembly Department Production Division, QA Division
Inspection in Process	Test Procedure Doc. No. SST-TPD001-Rev.3	See Table 4 Pitch of holes and tolerances (Page 5/10)	1. Visual Inspection 2. Dimensional Inspection	1. Vernier caliper 2. Measuring Tape	QA Department Production Department Finish Good Department
	Fabrication and Quality Manual Doc. No. SST-FQM 001-Rev.0	See 9.2 Hole dimensions and tolerances (Page 8/17)			
Hot-dip Galvanized Process	Test Procedure Doc. No. SST-TPD001-Rev.3	See Table 2 ASTM A153 Bolt & Nut (Page 4/10)	1. Visual Inspection 2. Coating Thickness Inspection	1. Coating Thickness Gauge	
		See Table 6 ASTM A123 Structural Shapesand Plate (Page 7/10)			
Packing Process	Test Procedure Doc. No. SST-TPD001-Rev.3	See Table 8 Inspection of Finished Products (Page 9/10)	1. Visual Inspection	1. Check List Packing Inspection	

Inspection item	Method
Mill Certificate	Review the chemical composition (Carbon, Phosphorus, Sulfur), tensile strength, elongation and date sign issue on
Visual Inspection	Visual inspection, the passed-inspection samples have to have smooth surface and no cracking.
Dimensional Inspection	Random inspection of material grade. Random inspection shall be carried out on the size of material (angle plate bolt&nut) length, width, height, Random dimension inspection of bolt (bolt hole diameter, number of bolt holes, alignment of bolt holes) other.
Coating Thickness Inspection	Random inspection shall be conducted on the galvanized surface. Random inspection shall be conducted on distortion and bending of the member. Random inspection shall be conducted on the film thickness of the galvanized zinc.
Packing inspection	Visual inspection of packing condition to be in accordance with packing procedure or Client Specified

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PROCESS ACTIVITY	WORK INSTRUCTION/ PROCEDURE	ACCEPTANCE/ CRITERIA	INSPECTION & TEST METHOD	EQUIPMENTS/ INSTRUMENTS	DEPARTMENT& PERSON RESPONSIBLE
Raw Materials Inspection	Test Procedure  Doc. No. SST-TPD-ISO-Rev.1		1. Review Mill Certificate Mechanical Test & Chemical Test  2. Visual Inspection  3. Dimensional Inspection	1. Vernier caliper 2. Measuring Tape 3. Camber gage 4. Micrometer	QA Department  Production Planning Department
1. Steel Angle 2. C-Channel		TIS-1227 (SS400)			
3. H-Beam		TIS-1227 (SS400)			
4. Plate		TIS-1479 (SS400)			
5. Pipe 6. Tube		TIS-107 (STK400 , STKR400)			
7. Light Lip Channel		TIS-1228 (SSCS400)			
8. Round bar		SS400			
9. Bolt&Nut		ISO 898-1(Gr.8.8), ISO 898-2(Gr.8)			
Inspection of Assembly		Fabrication and Quality Manual Doc. No. SST-FQM 001-Rev.0			
Inspection in Process	Test Procedure Doc. No. SST-TPD-ISO-Rev.1	See Table 4 Pitch of holes and tolerances (Page 5/10)	1. Visual Inspection 2. Dimensional Inspection	1. Vernier caliper 2. Measuring Tape	QA Department Production Department Finish Good Department
	Fabrication and Quality Manual Doc. No. SST-FQM 001-Rev.0	See 9.2 Hole dimensions and tolerances (Page 8/17)			
Hot-dip Galvanized Process	Test Procedure Doc. No. SST-TPD-ISO-Rev.1	See Table 2 ISO1461 Iron and Steel products (Page 4/10)	1. Visual Inspection 2. Coating Thickness Inspection	1. Coating Thickness Gauge	
		See Table 6 ISO1461 Bolt&Nut (Page 6/10)			
Packing Process	Test Procedure Doc. No. SST-TPD-ISO-Rev.1	See Table 8 Inspection of Finished Products (Page 9/10)	1. Visual Inspection	1. Check List Packing Inspection	
Inspection item	Method				
Mill Certificate	Review the chemical composition (Carbon, Phosphorus, Sulfur), tensile strength, elongation and date sign issue on				
Visual Inspection	Visual inspection, the passed-inspection samples have to have smooth surface and no cracking.				
Dimensional Inspection	Ramdom inspection of material grade. Ramdom inspection shall be carried out on the size of material (angle plate bolt&nut) length, width, height, Ramdom dimension inspection of bolt (bolt hole diameter, number of bolt holes, alignment of bolt holes) other.				
Coating Thickness Inspection	Ramdom inspection shall be conducted on the galvanized surface. Ramdom inspection shall be conducted on distortion and bending of the member. Ramdom inspection shall be conducted on the film thickness of the galvanized zinc.				

Packing inspection	Visual inspection of packing condition to be in accordance with packing procedure or Client Specified
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