**INSPECTION & TEST PLAN**

**- SCHEDULE OF INSPECTIONS AND TESTS -**

**CONSTRUCTION PROCESS**: FIRE/MECANICAL/HYDRAULIC SERVICES – Steel pipe (black or Galvanised) Rolled Grooved Pipe Inspection **100 mm heavy duty Pipe Work (4.5mm)**

**PROJECT: SERVICE:**

**LOCATION: REFERENCE: DATE OF INSPECTION:**

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Ref | Inspection/Test/Approval | | | | | Test Measurement | | Acceptance Criteria  (Pass / Fail) | Specification /Standard | Comments |
| Description | Key | **Optimum Measurement** | Maximum Measurement | Minimum Measurement | “A” | “B” |
| 1 | Pipe Diameter (OD) | D1 | **114.3mm** | 115.44mm | 113.51mm |  |  |  | **Manual Calliper,**  **Tape, ruler** | First and every 20 roll |
| 2 | Flare Diameter | D2 | N/A | **116.80mm** | N/A |  |  |  | **Manual Calliper,**  **Tape, ruler** | **Mandatory on every roll groove** |
| 3 | Gasket Seat Dimension | A | **15.88mm** | 16.64mm | 15.21mm |  |  |  | **Manual Calliper,**  **Tape, ruler** | First and every 20 roll |
| 4 | Groove Width | B | **8.74mm** | 9.50mm | 7.98mm |  |  |  | **Manual Calliper,**  **Tape, ruler** | First and every 20 roll |
| 5 | Groove Depth | D | **2.11mm** | N/A | N/A |  |  |  | **Manual Calliper,**  **Tape, ruler** | First and every 20 roll |
| 6 | Groove Diameter  (circumference tape) | D3 | **110.08mm (diameter)** | 110.08mm | 109.57mm |  |  |  | **GO, NO-GO Tape Measure** | **Mandatory on every roll groove, must align with correct point on tape** |
| 7 | Groove Corner Inner | R1 | 3.8 | N/A | **3.37mm** |  |  |  | **Two Point Micrometer or Modifed Calliper** | First and every 20 roll.  Must remain at ≥75% of original wall thickness |
| 8 | Groove Corner Outer | R2 | 3.8 | N/A | **3.37mm** |  |  |  | **Two Point Micrometer or Modifed Calliper** | First and every 20 roll  Must remain at ≥75% of original wall thickness |
| 9 | Wall Thickness Inner | T2 | **4.5** | N/A | **4.4mm** |  |  |  | **Two Point Micrometer or Modifed Calliper** | First and every 20 roll |
| 10 | Wall Thickness Outer | T1 | **4.5** | N/A | **4.4mm** |  |  |  | **Two Point Micrometer or Modifed Calliper** | First and every 20 roll |
| 11 | Galvanised Protection  Internally to Grooves |  |  |  |  |  |  |  | **Visual** | **Mandatory on every roll groove**  Any flaking or cracked zinc is to be wire brushed off and cold galvanising paint applied as per manufactures requirements |

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| Document No.: ITP RG H100 | Prepared By: LLd | Approved By site | Position: | Date: |
| Issue No:B |  | Approved By LL: | Position: | Date: |
| Amendment No.:6 | Date: | Approved By Contractor: | Position: | Date: |