



# **THERMAX CHECKLIST FOR TR SET INSPECTION**

PROJECT NAME	R&R of the existing Chinese make waste gas ESP(OC no E308157) E308157 -TATA LONG SINTER ESP	PROJECT NUMBER	E308157 -TATA LONG_SINTER ESP
PRODUCT	Transformer Rectifier Set -TR set	VENDOR NAME	AUTODATA
DATA SHEET NUMBER & REV	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	QTY IN NUMBERS	02 Nos
RATING	THREE PHASE TR SET & TRCC 95KV, 1300MA	SR. NUMBERS	3Φ21706 , 3Φ21707
APPLICABLE QUALITY PLAN	TL/ENV/QAP-FAB/E308157 Rev. No. 01 Approved by Thermax Ltd Dtd. 22/06/2021	THERMAX PURCHASE ORDER NUMBER	PO. 124780 dated 24.05.2021
PART CAT.NUMBER		THERMAX INSPECTION REPORT NUMBER	124780/001

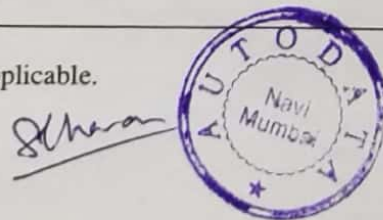
## **Step- 1:- Stage Inspection**

Sr. No.	Description	Specified	Observed	Remark
1	Mounting of Secondary cable from TR Secondary to Rectifier stack	Yes	OK	OK
2	Mounting of Support carrying Sec Cable between TR Secondary to Rectifier stack	Yes	OK	OK
3	Sewing of Cable on Rectifier Stack	Yes	OK	OK

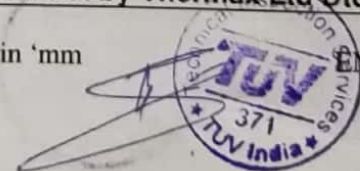
## **Step- 2:- Review of Documents with Latest Revision:**

Sr. No.	Description	Specified	Observed	Remark
1	General Arrangement Drawing for TR Set	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	OK
2	Welding Quality	Yes	Found Satisfactory	OK
3	Wiring Diagram	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd	OK

Strike which ever not applicable.  
Page 1 of 5



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ENV-CHK-B041 REV 05



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## CHECKLIST FOR TR SET INSPECTION

4	Bill of Material	Yes	18/06/2021	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Did 18/06/2021	OK
5	Power Schematic diagram For Transformer	Yes		E308157507 Rev 01 Approved in Code-A by Thermax Ltd Did 18/06/2021	OK
6	WPS-PQR For Welding	Yes		Not Applicable	
7	Calibration report for measuring Instruments	Yes		Found Satisfactory	OK
8	IP Certificate	Yes		IP-55 declared by Vendor.	IP-55 declared by Vendor.
9	Test Certificates of Bought Out Items	Yes		Found satisfactory	OK
10	Internal Test Report	Yes		Found satisfactory	OK

## Step-2 Visual Inspections

Sr. No.	Description	Specified	Observed	Remark
1	Oil leakage at TR set Bushing, Drain Valve, Earth Switch, Fins, Welding Joints, Gasket and Bucolze Relay	Free from leakage.	Free from leakage.	OK
2	TR set Bushing	Free from damages and good surface finishing	Free from damages and good surface finishing	OK
3	Orientation of Bushing	Vertical / Horizontal	Horizontal	OK
4	Creep age Distance			OK
5	Oil level in TR set	Oil level should be above minimum level	Oil level should be above minimum level	OK
6	Make, Model & rating of Components	As per drawing / Approved Vendor List	As per drawing / Approved Vendor List	OK
7	Short Supply If Any	YES/NO	No	OK
8	Ferruling identification	As per drawing	As per drawing	OK

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Page 2 of 5

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ENV-CHK-B041 REV 05







## THERMAX CHECKLIST FOR TR SET INSPECTION

		No Pressure drop for 01 hour. No oil leakage.		a) Test pressure is 1 Kg for Conventional Type and 0.5 kg for Hermetically sealed
9	Pneumatic Pressure test 100 %			
10	Oil sealing at drain valve	As per drawing	As per drawing	OK
11	Position of earth switch with actual assembly of sample door interlock key	As per drawing	As per drawing	OK
12	Colour Code of Wire in Marshaling Box	As per drawing	As per drawing	OK
13	Mechanism of Earth Switch	As per drawing	As per drawing	OK
14	Measurement of Feedback Resistor (with Megger)	As per drawing	As per drawing	OK

### Step-3:- Dimensional Inspection

Sr.No	Description	Specified	Observed	Remark
1	Total Height	1575	1556	OK
2	Total Width	1330	1340	OK
3	Bushing center to ground distance	700 $\pm$ 5	695	OK
4	Roller center to center distance	850 & 600 $\pm$ 10	860 & 610	OK
5	Height of Marshaling Box	420	420	OK
6	Duct Flange Hole- PCD and size x no of holes	Dia 14 X12 Holes PCD 656	Dia 14 X12 Holes PCD 656	OK
7	Height of Inspection door center to Tank			
8	Duct Flange Details	ON Center / OFF Center	ON Center	OK

### Step-4:- Routine Tests

No load test at Rated primary voltage of : 416.1Volt and 50 Hz  
Short Circuit test at rated primary current of : 183Amp

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Page 3 of 5

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ENV-CHK-B041 REV 05





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**CHECKLIST FOR TR SET INSPECTION**

Sr.No. of Equipment	Test Temp (o C)	No Load Tests		Short Circuit Test			Induced Over Voltage Tests at 1.5 times of the rated voltage at 100 Hz
		Current (A)	Losses (W)	Voltage (V)	Losses (W)	Impedance	
3Φ21706		Witness report attached.					
3Φ21707							

**Step- 5:- Functional Test**

Sr.No	Description	Specified		Observed		Remark
1	Pressure release valve operation test	7 PSI		0.50 BAR		OK
2	Resistance Measurement & Dielectric test					
Sr.No. of Equipment	Resistance of Primary, Converted to 75° C	Test Temp.	Oil BDV with 2.5 mm gap (kv)	Insulation Resistance test with 2KV DC Megger (Mohms)		
				Between		
				I/P & Earth	O/P &Earth	I/P &O/P
Applied HV Test between input &earth,3 KV AC for 60 sec						
Witness report attached						
3.0 Marshalling details as per Schematic						

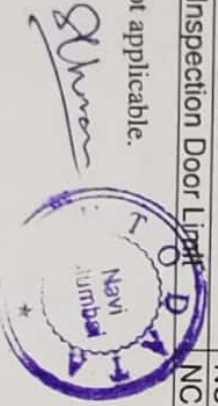
Sr.No. of Equipment	Accessory	Alarm Contact		Trip Contact	
		Specified	Observed	Specified	Observed
	Dial Thermometer	NO		NC	
	Gas & Oil Relay-Top & Bottom Float	For Top Float = NO		For Bottom Float = NC	OK
	Limit Switch	NC			
	Inspection Door Light	NC			

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Page 4 of 5

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ENV-CHK-B041 REV 05





## THERMAX CHECKLIST FOR TR SET INSPECTION

**Note-Continuity test shall be conducted to ensure the correctness of wiring.**

### Step-6: Painting Inspection

### Step-7: Identification Inspection

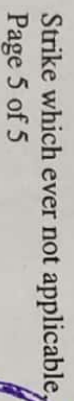
### Step-7: Identification Inspection

**Test Carried Out By**  
**Sign & Date with stamp**

**Test Witnessed By Thermax**  
**Sign & Date with stamp**

**Test Witnessed By Client**  
**Sign & Date with stamp**

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CHECKLIST FOR TRCC PANEL

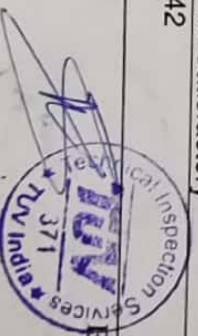
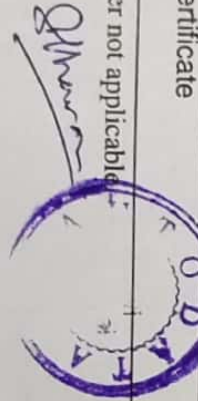
PROJECT NAME	R&R of the existing Chinese make waste gas ESP(OC no E308157) E308157-TATA LONG SINTER ESP		PROJECT NUMBER	E308157-TATA LONG_SINTER ESP
PRODUCT	TR CONTROLLER CENTER- TRCC PANEL		VENDOR NAME	AUTODATA
DATA SHEET NUMBER & REV	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021		QTY IN NUMBERS	02 Nos
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PART CAT.NUMBER			Thermax INSPECTION REPORT NUMBER	124780/001

Step- 1 :- Review of Documents

Sr.No	Description	Specified	Observed	Remark
1	General Arrangement Drawing	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	OK
2	Wiring Diagram	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	OK
3	Bill of Material	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	OK
4	Power Schematic diagram	Yes	E308157507 Rev 01 Approved in Code-A by Thermax Ltd Dtd 18/06/2021	OK
6	Calibration report for measuring Instruments	Yes	Found Satisfactory	OK
7	IP Certificate	Yes	IP-42	Declared by Manufacturer

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Page 1 of 5

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ENV-CHK-B042 REV 03



## THERMAX CHECKLIST FOR TRCC PANEL

8	Test Certificates of Bought Out Items	Yes	Found Satisfactory	OK
9	Approved Data Sheet	Yes	Found Satisfactory	OK
10	Internal Inspection Report	Yes	Found Satisfactory	OK

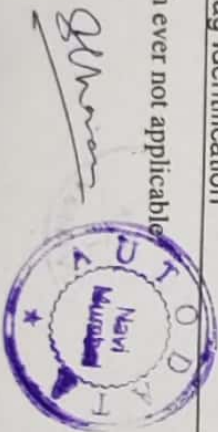
### Step -2 Visual Inspections

Sr. No.	Description	Specified	Observed	Remark
1	Make, Model & rating of Components	As per Approved drawing / BOM	As per Approved drawing / BOM	OK
2	Rating of Switchgear	As per Approved drawing		OK
3	Short Supply If Any	As per Approved drawing		OK
4	Gland Plate Thickness & Gasket	As per Approved drawing	3 mm	OK
5	Continuity Test of Potential Free Contacts	As per Approved drawing		OK
6	Wire size and Make	As per Approved drawing	As per Approved drawing	OK
7	Colour of wires	As per Approved drawing	As per Approved drawing	OK
8	Ferruling identification	As per Approved drawing	As per Approved drawing	OK
9	Pull Out Test for Wires	As per Approved drawing	Found satisfactory	OK
10	Gasket of Panel	As per Approved drawing	As per Approved drawing	OK
11	Main Bus bar Material	Alluminium / Copper	Alluminium	OK
12	Main Bus bar Size	As per Approved drawing	40 X 10 mm	OK
13	Bus bar Slewing & Identification	As per Approved drawing	As per Approved drawing	OK
14	Earth Bus bar Material	Alluminium / Copper	Alluminium	OK
15	Earth Bus bar Size	As per Approved drawing	25 X 5 mm	OK
16	Welding Joints, Meter Cutout	As per Approved drawing		OK
17	Tag Identification	As per Approved drawing		OK

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Page 2 of 5

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ENV-CHK-B042 REV 03







## THERMAX CHECKLIST FOR TRCC PANEL

18	Communication Protocol	As per Approved drawing	OK
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### Step-3:- Dimensional Inspection (MM)

Sr. No.	Description	Specified	Observed	Remark
1	Height	2000+100	2000+100	OK
2	Width	800	800	OK
3	Depth	500	500	OK
4	Base frame details	100	100	OK
5	Foundation plan Dimension	NA	NA	OK
6	Door thickness	2mm	2mm	OK
7	Lifting hook	4 Nos	4 Nos	OK

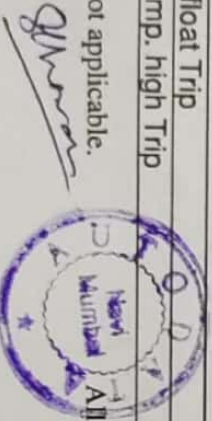
### Step-4:- Routine Test

Sr. No.	Description	Specified	Observed	Remark
1	HV Test at 1.5 KV for 1 min	Should Withstood	Should Withstood	OK
2	IR Test	Above 200 M-Ohm	OK	OK

### Step-5:- Simulation Test

Sr. No.	Description	Specified	Observed	Remark
1	Under Voltage alarm Trip	Yes		OK
2	Over Voltage Trip	Yes		OK
3	AC Current High trip	Yes		OK
4	Tr. Temp High-1 Alarm	Yes		OK
5	Top float Alarm	Yes		Not Applicable
6	Bottom float Trip	Yes		Not Applicable
7	SCR Temp. high Trip	Yes		OK

Strike which ever not applicable.  
Page 3 of 5



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ENV-CHK-B042 REV 03





# THERMAX CHECKLIST FOR TRCC PANEL

8	Overload Trip	Yes		OK
9	Safety Loop fail trip	Yes		OK
10	Programmable optional Alarm-1	Yes		OK
11	Programmable optional Trip-1	Yes		OK
12	Pressure high trip (only for hermetically sealed)	Yes		OK
13	Oil Level low trip (only for hermetically sealed)	Yes		OK
14	Single SCR Firing	Yes		Not Applicable
15	Process Fault Trip / Remote Trip	Yes		OK
16	Remote HT ON	Yes		OK
17	Panel OFF	Yes		OK
18	Remote Alarm	Yes		OK
19	Oil Temp. High/Low Alarm	Yes		OK

## Step-6: Functional Test

Sr. No.	Description	Specified	Observed	Remark
1	Parameter Settings of Controller	As Per Approved Drawing	As Per Approved Drawing	OK
2	Alarm Annunciation	As Per Approved Drawing	As Per Approved Drawing	OK
3	Regulation Test	As Per Approved Drawing		Load Regulation offered
4	Charge Ratio	As Per Approved Drawing		Internal check by vendor.
5	Remote Operation	As Per Approved Drawing	As Per Approved Drawing	OK
6	4-20 mA Signals	As Per Approved Drawing	As Per Approved Drawing	OK
7	Load Test	As Per Approved Drawing	As Per Approved Drawing	OK

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Page 4 of 5

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ENV-CHK-B042 REV 03





# Thermax CHECKLIST FOR TRCC PANEL

			Drawing	
8	Spark Test (60 spark/min)	As Per Approved Drawing	As Per Approved Drawing	OK

## Step- 7: Painting Inspection

Sr.No. of Equipment	Description	Specified	Observed	Remark
1	Visual	Free from paint lumps	OK	OK
	Paint Shade	As per drawing	RAK 7032	OK
	Mounting plate	As per drawing	OK	OK
	Paint Thickness	Min 50 micron	Min 60 micron	OK

## Step- 8: Identification Inspection

Sr.No. of Equipment	Description	Specified	Observed	Remark
1	Visual	Rating, model, part number, Sr. No.to be painted or Name plate to be provided.	OK	OK
2	Visual	Supplier Should provide Sr. No Of Controller Used in the panel along with software version	OK	OK
Test Carried Out By		Test Witnessed By Thermax	Test Witnessed By Client	
Sign & Date with stamp		Sign & Date with stamp	Sign & Date with stamp	

