

<b>General Inspection plan</b>  Title <b>Wet Motors</b>	Document <b>KBE IP – 103.4</b>
	Issue <b>3</b>
	Date <b>2024-05-07</b>
	Supersedes <b>2</b>

Inspection according to codes below					
<u>Inspection Specification</u> (1st letter) A: Routine 100% Insp. S: Sample Inspection T: Type Inspection		<u>Inspection performed and documented by</u> (2nd letter) E: Manufacturer D: Supplier B: Purchaser		<u>Inspection supervised by</u> (3rd letter) B: Purchaser C: Inspector engaged by purchaser D: Supplier	
				<u>Documentation</u> (4th letter) R: Technical Report P: Inspection Record I: Certificate	
Examination Procedures		Codes	Inspection Procedure	Inspection Record	Deviation Report/Remark
<b>Type Inspection</b>					
T1	Withstand voltage test KBE EP-170 pt. 3.16	TEBR			
T2	Temperature rise KBE EP-170 pt. 3.9	TEBR			
T3	Load losses KBE EP-170 pt. 3.8	TEBR			
T4	No-load test KBE EP-170 pt. 3.7	TEBR			
T5	Short circuit test KBE EP-170 pt. 3.12	TEBR			
T6	Torque curve KBE EP-170 pt. 3.19	TEBR			
T7	Aging (winding wire) KBE EP-135	TE-R			
T8	Test/Inspection of electrical Penetrations Note 1	TEBR			
T9	Noise level KBE EP-170 pt. 3.14	TEBR			
T10	Seismic Qualification Note 2 KBE EP-147	TEBR			
T11	Type Inspection review and certification KBE EP-180	TE-R			
T12					
T13					
T14					
<b>Notes</b>  (See page 2)					

Examination Procedures		Codes	Inspection Procedure	Inspection Record	Deviation Report/Remark
<b>Routine Inspection</b>					
R1	Inspection of welds Note 3	AE-P			
R2	Airgap measurement KBE EP-170	AE-P			
R3	Winding resistance measurement KBE EP-170	AE-P			
R4	No-load test KBE EP-170	AE-P			
R5	Overspeed and vibration test KBE EP-170	AE-P			
R6	Overvoltage test KBE EP-170	AEBP			
R7	Short-circuit (locked rotor) test KBE EP-170	AEBP			
R8	Voltage withstanding test KBE EP-170	AEBP			
R9	Insulation resistance measurement KBE EP-170	AEBP			
R10	Bearing inspection/testing Note 4	AE-P			
R11	Visual inspection KBE EP-170	AEBP			
R12	Surface finish inspection KBE EP-148	AEBP			
R13	Material quality certificates KBE EP-109	AE-P			
R14	Delivery Release Inspection Note 5	AEBP			
R15	Quality and identity certification KBE EP-180	AE-I			
R16					
R17					
<b>Notes</b> <ol style="list-style-type: none"> <li>The test shall be carried out according to Manufacturer's standard procedure, subject to prior review and approval by the Purchaser. As a minimum the test shall include thermal ageing, radiation ageing, cyclic pressure testing and cyclic temperature testing, followed by voltage test, insulation resistance test and leakage test.</li> <li>Verification of seismic requirements given in the Technical Specification.</li> <li>Welder's licenses shall be checked before manufacturing starts. Visual inspection of welds before start of stator winding.</li> <li>SPM (Shock pulse measurement) inspection, where called for in Technical Specification.</li> <li>Inspection witnessed by Purchaser before Delivery (Shipping) Release in accordance with KBE 100-X.</li> </ol>					