

TUV INDIA PRIVATE LIMITED

INSPECTION VISIT REPORT

IVR - 8117433193 - Sr. No.1. - Rev. 00



General:						
TUV India Control Or SAP Number:		8117433193		Branch:		Mumbai
Notification Name / Number:		Email Dtd:- 10.07.2020.		Date(s) of Inspection:		14.07.2020, 27.08.2020 & 28.09.2020.
Project Name & Location:		NA		Inspection Location:		M/s. Micro Pneumatics Pvt. Ltd./ Vasai
TUV India Client Name:		M/s. Micro Pneumatics Pvt. Ltd./ Vasai		End User Name:		NA
DEC / PMC / EPC Name: (If applicable)		NA		DEC / PMC / EPC Asgmt. Number: (If applicable)		NA
Vendor Name & Location:		M/s. Micro Pneumatics Pvt. Ltd./ Vasai		P.O. Number: (Client PO on Vendor)		NA
Sub Vendor Name & Location: (If applicable)		NA		P.O. Number: (If applicable - Vendor PO on Sub Vendor)		NA
Stages Of Inspection:						
<input type="checkbox"/> Kick Off / Pre Inspection Meeting		<input type="checkbox"/> Material Identification		<input type="checkbox"/> Interim Stages		
<input checked="" type="checkbox"/> Document Review		<input checked="" type="checkbox"/> Final Inspection		<input type="checkbox"/> Re-Inspection		
Item Description:						
P.O. Item No.	Item Code	Item Description	UOM	P.O. Quantity	Offered Quantity	Accepted Quantity
1	----	Performance test on Pneumatic Q turn Actuator as per EN15714-3, Actuator Model:- MD100-F10 Sr. No:- 200701022/07/20 5,00,000 cycles as per BS EN 15714-3:2009	Nos.	01	01	01
2	----	Performance test on Pneumatic Q turn Actuator as per EN15714-3, Actuator Model:- MS63-F05 Sr. No:- 200701013/07/20, 5,00,000 cycles as per BS EN 15714-3:2009	Nos.	01	01	01
Reference Documents:						
Sr. No.	Document Name	Client Document Number	Vendor Document Number	Approval Status		
1)	PR / MR / ARM	Cycle test for actuator as per standard BS EN 15714-3:2009.	Not Applicable	Not Applicable		
2)	QAP / ITP / QCP	Not Applicable	Not Applicable	Not Applicable		
3)	Drawing(s)	MP-GA-6143 Sheet 3 of 19 & MP-GA-6143 Sheet 7 of 19	Not Applicable	Manufacturers Drawing.		
4)	Procedure(s)	Not Applicable	Not Applicable	Not Applicable.		
5)	Datasheet(s)	Not Applicable	Not Applicable	Not Applicable		
6)	Others (Specify)	Not Applicable	Not Applicable	Not Applicable		
Inspection Activities Carried Out :						
Stages Witnessed:						
1)	Visual examination & strip test of actuator witnessed before start of cycle test. - No injurious defect were observed- Found acceptable.					
2)	Shell pressure test (Pneumatic) witnessed. - 8 Bar (g) (at 30 deg. C) for duration 60 seconds found acceptable.					
3)	Torque values measured before start of cycle test & recorded. Counter & actuator sealed & cycles started.					
4)	Random monitoring carried out for check of continuity, smoothness & operation.					

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5)	Endurance test witnessed :- 5,00,000 Cycles with stroking time less than 5 seconds (actual- 2 seconds) with load at least 60 % of the run torque at 5.5 bar pressure; Witnessed Torque values at start & end of the test & found not less than 90% of initial value as per below table.						
	Torque test Actuator Model : MD100-F10, Serial no : 200701022/07/20						
	Pressure	Torque Before Cycle test at Ambient temp (28 Deg. C)	Torque After 5,00,000 Cycle test at Ambient temp (29 Deg. C)	Test Result			
	3 Bar(g)	9.43 kg -m	8.95 kg -m	Passed			
	4 Bar(g)	12.57 kg-m	11.90 kg -m	Passed			
	5 Bar(g)	15.71 kg -m	14.76 kg -m	Passed			
	5.5 Bar(g)	17.28 kg-m	16.00 kg -m	Passed			
	Torque test Actuator Model : MS63-F05, Serial no : 200701013/07/20						
	Pressure	Torque Before Cycle test at Ambient temp (28 Deg. C)	Torque After 5,00,000 Cycle test at Ambient temp (29 Deg. C)	Test Result			
	5.5Bar	(Air start /Air end) 2.48/1.73 KG-m	(Air start /Air end) 2.38/1.66 KG-m	PASSED			
Spring set 3	(Spring start /Spring End) 2.55/1.8 KG-m	(Spring start /Spring End) 2.42/1.75 KG-m	PASSED				
6)	Final Pneumatic Leakage test witnessed at 5.5Bar (g) pressure - No leakage observed.						
7)	Final operating stroke Checked, observed between 98 % to 102%. - Found acceptable.						
8)	Leakage (Pneumatic) test witnessed at 5.5 Bar at temperature - 20 Deg. C & 60 Deg. C for duration 60 seconds - No leakage observed.						
9)	Strip test witnessed after cycle test.-No damage observed to the internals. - Found acceptable						
10)	Marking On name Plate verified : Manufactures Name , Model , serial no ,Maximum Operating Pressure , Fail safe Return actuator , Actuator designation verified.- Found in order as per drawing & data sheet.						
Documents Reviewed:							
1)	Reports reviewed for Corrosion test, Material Of Construction - Found in order.						
2)	Calibration certificates verified. - Found in order.						
Details of Equipment(s) / Instrument(s) used for measuring / testing during Inspection (Refer Notes):							
Sr. No.	Detail of Equipment(s) / Instrument(s)	Range	ID	Validity till Date	Calibration Certificate Number	NABL / OTHER CERT. BODIES	NON-NABL
						Please tick whichever is applicable	
						See Note 1	See Note 2
1)	Vernier Calliper	0-300mm	2858	07.02.2021	43869-2858 Dtd:- 08.02.2002.	✓	
2)	Pressure Gauge	0-10 Kg/cm2	346-04-900	16.09.2020	LH/M-ET/F20-001 dtd:- 17.06.2020	✓	
3)	Digital Counter	0-999999	DC-01/1700813424	04.12.2020	43804 DC-01/1700813424 Dtd:-05.12.2019.		✓
4)	Digital Thermometer	-50 to 400°C	19090903	05.06.2021	43988-19090903 Dtd: 06.06.2020.		✓
5)	Torque Tester	0- 10.6Kg-m	S5-70	05.06.2021	42908-20 Dtd: 06.06.2020		✓
6)	Torque Tester	0- 212Kg-m	S5-71	05.06.2021	42909-20 Dtd: 06.06.2020		✓
Notes: 1) Other Certifying bodies are: NPL-India, CIPM (International Committee for Weights & Measures), ILAC & APLAC MRA Signatories. 2) Visiting inspector to ensure continued suitability for intended use, periodic maintenance, proper identification and valid calibration records and traceability to known National / International standards of the measuring Instrument(s) / testing equipment(s). 3) In lieu of table above inspectors may collect master list from manufacturer/ vendor/ sub vendor with all above details and clearly indicating the details of instrument(s) / equipment(s) used.							

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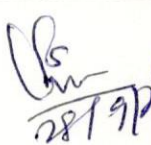
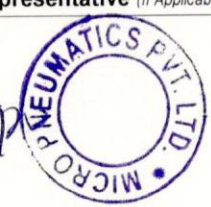
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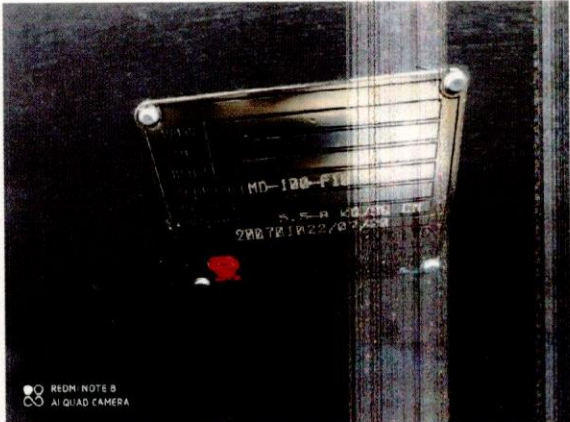
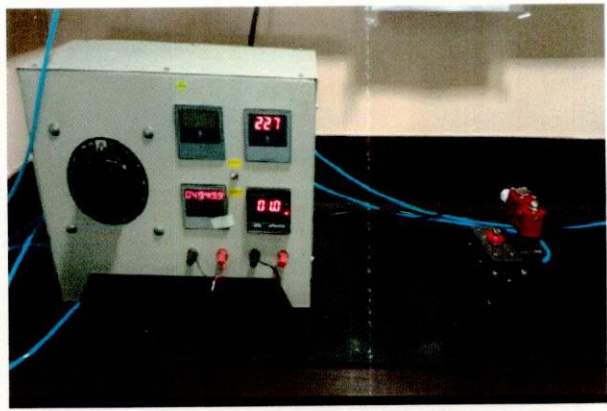
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Form No. : F / INSP / VR / 11 - R10; Revision Date: 26.09.2019

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Conclusion (Acceptable / Not Acceptable / Acceptance subject to):	
Accepted.	
Pending Activities from this Visit:	
NIL	
Identification of Inspected Item(s):	
NIL	
Areas of Concern:	
NIL	
Non Conformities raised / Discrepancies observed during Inspection (If Any, Mention TUV India NCR Number):	
NIL	
Attachments:	
<input checked="" type="checkbox"/> Inspection records – Total Page Nos. 4	<input checked="" type="checkbox"/> Master List of calibrated Instruments / equipment
<input checked="" type="checkbox"/> Inspection Photos – Refer Page Nos. 3 & 4	<input checked="" type="checkbox"/> Others (Specify) : None
Authorised Signatures:	
TUV India Inspector(s):	Vendor / Sub Vendor Representative (If Applicable):
 28/09/2020 	 28/09/2020 
Name: Swapnil D' Britto	Date: 28-09-2020
Name: Saroj Kumar Jena	
Distribution List: <input checked="" type="checkbox"/> TUV India Client / End User <input checked="" type="checkbox"/> TUV India Executing / Originating Branch <input checked="" type="checkbox"/> Vendor / Sub Vendor	
Revision Number (If Applicable) : 00 – Type Reason for revision here	
This Document Supersedes IVR No. : Mention Previous IVR Number.	

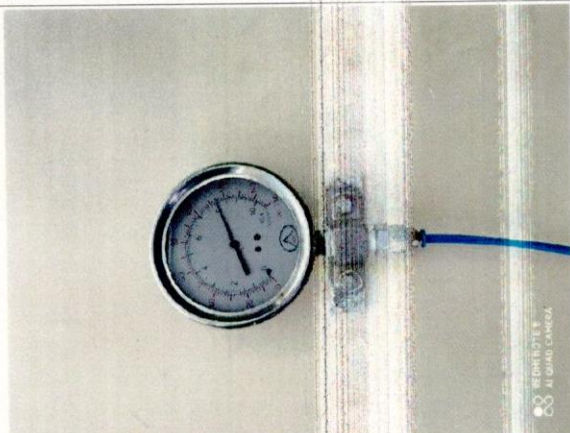
Inspection Pictures:	
Marking Verification of Actuator	Life Cycle test set up
	

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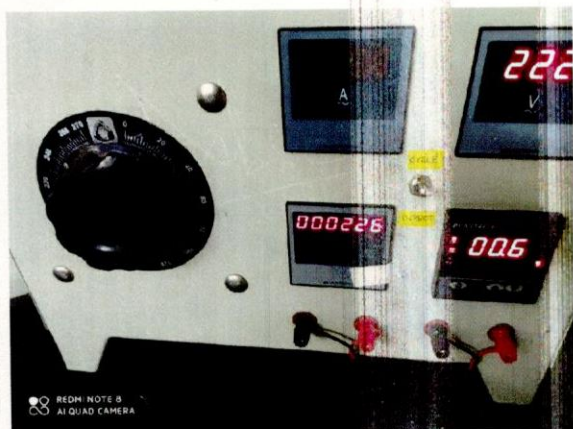
Pneumatic Shell test Pressure before cycle test



Pneumatic Shell test before cycle test



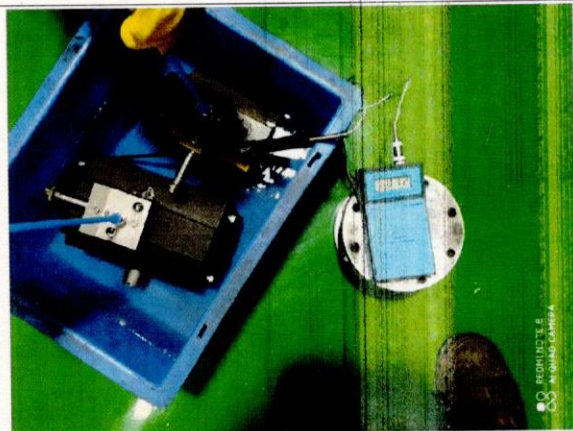
Sealing Of Counter



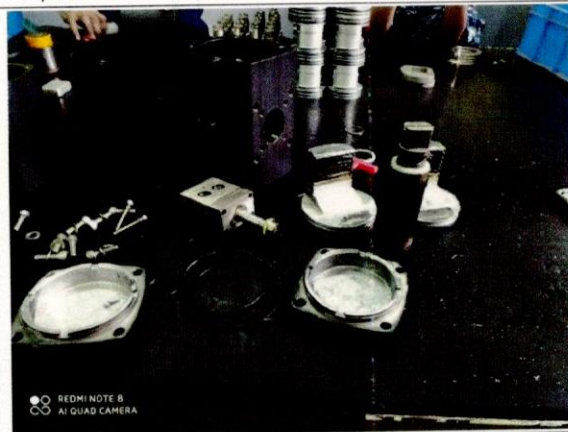
Check of Cycles



Pneumatic test after completion of 5,00,000 cycles



Strip test after completion of 5,00,000 cycles



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