

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
v	Polycarbonate	Make and Thickness	1. Verification of Purchase Documents. 2. Verification of Manufacturer's Test Certificates for specifications 3. Measurement of thickness.	1. 100% of the test reports & purchase documents. 2. 100% of the panels to be used under each Call-up order shall be checked for thickness.	IOCL drawings.	1. Shall conform to approved make viz.: GE Lexan (SABIC), Bayer. 2. Thickness, shall be 5mm. 3. The parameters indicated in the Test Reports shall conform to the specifications.	
		Protective Film	Visual	100% of the panels being used under each Call-up order.	Manufacturer's specifications	Availability of protective film. Note: UV protected face shall be the exposed surface after fabrication & fixing.	
vi	PET-G	Material specification, make & thickness	1. Verification of Purchase Documents. 2. Verification of Manufacturer's Test Certificates for specifications 3. Measurement of thickness.	1. 100% of the test reports, purchase documents. 2. 100% of the panels to be used under each Call-up Order shall be checked for thickness.	1. IOCL Specifications. 2. Manufacturer's test certificates. 3. Vendor's purchase documents.	1. Shall conform to approved makes viz. : Spectra Copolymer, Relstar, Arita Plastics (Spet-G), Bayer. 2. Thickness shall be 3 mm (prior to thermoforming). 3. The parameters indicated in the Test Reports shall conform to the specifications.	
vii	Vinyl	Make & colour	1. Verification of Purchase Documents. 2. Verification of Manufacturer's Test certificates.	100% of the purchase documents of Vinyl to be used under each Call-up order.	1. Manufacturer's test certificates. 2. Vendor's purchase documents.	1. Shall conform to approved makes viz. : 3M: a. 3630 series b. Retro-reflective:Diamond grade 9 or Avery Dennison: a. XL 5500 series b. Retro-reflective: Diamond grade 8 2. Colour shall conform to specifications. Note: The converter shall be the authorised converter of the vinyl manufacturer.	
viii	Fastners	Make & material	Verification of Purchase Documents.	100% of the purchase documents of fastners to be used under each Call-up order.	1. IOCL drawings & specifications. 2. Vendor's purchase documents.	High tensile fastners of the following makes shall be used : TVS/GKW/UNBRAKO/EBY/LPS or equivalent.	
ix	Welding Electrodes	Make & Grade	Verification of purchase documents	100% of the purchase documents pertaining to welding electrodes to be used for each call-up order.	1. IOCL Specifications. 2. Vendor's purchase documents.	Shall conform to approved makes viz.: Advani orlekon, Essab, D&H Secheron, Phillips, GEE or equivalent of Grade E 6013	
x	Adhesives; Tapes, sealant & others	Make	Verification of Purchase Documents.	100% of the purchase documents and test certificates of adhesives to be used under each Call-up order.	1. IOCL Specifications. 2. Vendor's purchase documents.	Shall conform to approved makes viz.: a. Double sided tapes: VHB Tape 4956 of 3M (Shelf life 24 Months) b. Acrylic adhesive: Permabond TA 4246 c. Sealant: Dow Corning 795 / Rhodasil F245 / Bondmaster F246 / F245 Note: VHB tapes, wherever used, shall be continuous.	
xi	Electrical accessories	Make and model of fittings / accessories	1. Physical Verification of materials 2. Verification of Purchase Documents.	100% of the accessories to be used under each call-up and their purchase invoices	1. IOCL drawings & specifications. 2. Vendor's purchase documents.	Shall conform to IOCL specifications & approved makes viz.: a) Tubelight and electronic choke: Phillips / Bajaj Electrical / Crompton Greaves / Osram b) FRLS copper conductors: Finolex / National / Rallison / L& T / Anchor	
xii	Paint for MS structurals	Make & colour	Verification of Purchase Documents.	100% of the purchase documents of paints to be used	IOCL specifications.	1. Shall conform to IOCL approved makes viz.: Jenson & Nicholson / I.C.I. / Shalimar / Berger / Asian / Nerolac or equivalent. 2. Volume Solids : a. for Mastic coating : 90% +/- 5 % b. for PU Finish paint: 45% Batch Test Certificate from manufacturer confirming the above shall be produced by the converter. 3. Shelf Life : a. for Mastic coating : 12 months b. for PU Finish paint: 3 months	
xiii	Packaging of finished elements for dispatching to site	Packing with bubble sheet or similar material for wrapping / protection	Visual	All packed elements	Vendors packing list	Sturdy and satisfactory packing.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
II	QAP FOR MANUFACTURING & INSTALLATION						
1	MONOLITH / UNIPOLE						
a	AT CONVERTERS FACTORY PREMISES						
i	Structural Steel frames	Fabrication	Visual Check of fabricated frames/structurals	100% of the number of frames / structurals fabricated under each call-up order.	IOCL drawings.	Satisfactory quality of welding.	
		Dimensional check (fabricated frames / structurals)	Physical Measurement	100% of frames / structurals	IOCL Drawings.	Dimensions shall conform to IOCL drawings.	
		Paint Coating - Aluminium Epoxy Mastic primer with acrylic polyurethane finish paint.	Measurement of DFT	Three Readings, at random, for each finished frame / structurals.	IOCL Specifications.	1. All the DFT readings observed shall be within the range of 255 - 265 micron. 2. Application : Brush or airless spray	
ii	Structural frames in Aluminium	Fabrication	Visual Check of fabricated frames/structurals	100% of the number of frames / structurals fabricated under each call-up order.	IOCL drawings.	Satisfactory quality of welding.	
		Dimensional check (fabricated frames / structurals)	Physical Measurement prior to painting	100% of frames / structurals	IOCL Drawings.	Dimensions shall conform to IOCL drawings.	
iii	Base Plate	Size of plates & bolt holes	Dimensional check & finish	100%	IOCL drawings.	1. Base Plate & bolt hole dimensions to conform to drawings. 2. Bolt Holes shall be drilled and machined.	
iv	Polycarbonate Panels for LOGO	Size & Font of letters	Measurement of panel size and the size of vinyl letterings in LOGO	100% of logo panels	IOCL Drawings.	1. Size of the panel shall conform to the drawings and shall not have any joint. 2. Size of letterings in LOGO shall conform to drawings.	
v	Vinyl for Logo (including letterings)	Adhesion	Physical check	100% quantity of panels provided with lettering under each Call-up Order	IOCL drawings.	Shall be fixed satisfactorily without any bubbles with a smooth finish. Note: Converter shall provide warranty certificate for colour & adhesive property of the vinyl from the manufacturer prior to the final billing for the works.	
vi	ACM Panels (Completely fabricated & finished)	Size of panel, size & font of routed lettering in ACM	1. Verification of dimensions of panels and curvature. 2. Measurement of size of finished lettering routed in ACM including verification of the fonts.	25% quantity of panels, at random, used under each Call-up Order	1. IOCL Drawings. 2. Templates for curvature.	1. Size of fabricated panels and curvature shall conform to drawings. 2. Size and font of finished lettering shall conform to drawings. 3. Polycarbonate panel with lettering shall be fixed as per drawing to fit perfectly in the opening for letters in ACM panel.This panel shall be fixed to the ACM panel with silicon sealant neatly without leaving any cavity for dust accumulation.	
		Sealing the cuts in ACM with Hot air welding	Visual inspection of welded cuts	All joints in 25% quantity of panels, at random, used under each Call-up Order	IOCL drawings.	Cuts in ACM shall be sealed with Hot Air Welding as indicated in the drawings.	
vii	Stamping for identification at site; finished ACM panels	Affixing Stickers, after inspection, indicating clearance.	-	-	-	Stickers, at two positions for each frame, with the signature of TPI Inspector using indelible ink.	
viii	Converter's Details	Availability of Name Plate	Visual	100%	-	Name Plate with the following details: 1. Work Order No. 2. Converter's Name. 3. Month & Year of Manufacture. 4. Name of Inspection Agency.	
ix	Complete Assembled Monolith Unipole as Prototype (For every Converter at the beginning of the contract and installed in their factory premises)	All parameters mentioned above	Visual & Physical	100%	As above	Shall conform to all the requirements indicated in i) to viii) above. Shall be the benchmark for the Converter for subsequent manufacture against the work order. No monolith / unipole shall be manufactured and accepted without the acceptance of Prototype.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
b	AT SITE						
		Pre-Erection					
i	Fabricated materials from factory	Verification / Identification of Material received at site	Visual	100%	Packing List.	Name Plate and the stickers shall match the details in the Packing List. Note: 1. Converters shall intimate IOCL & TPI agency, in advance, if they chose to despatch Monoliths / Unipole in fully assembled condition. 2. If Monoliths / Unipole are dispatched in fully assembled condition, they shall be subjected to Post erection checks only, at site. 3. Fully assembled Monoliths shall be accepted at site, only if, they are inspected 100% for all parameters and released from the factory.	
		Post-Erection					
i		Internal accessories, such as, tubelights, ballasts, wiring, winch mechanism and ACM reinforcement for panels.	Visual	1. All electrical accessories. 2. Two bottom most panels for reinforcements and other internal details.	IOCL Drawings and specifications.	1. All materials used shall conform to the drawings & specifications and shall be as released at factory. 2. Pulley mechanism shall function satisfactorily. 3. ACM reinforcements for panels shall be as per drawings.	
ii		Mechanism of Hinged Panels	Physical	1. Operation of Hinged Panels of Monolith and Sliding Panel of Unipole.	IOCL Drawing & Prototype Inspection	1. Hinged Panel and Sliding panels shall function satisfactorily on both sides. 2. The opening in the hinged panel shall be adequate for easy access to the tube light trays for taking up maintenance works. 3. Stay rod shall be available on both sides.	
iii		Verticality of erected Monolith	Checking the plumb	100%	IOCL Drawings and specifications.	Shall be vertical.	
iv		Visibility of shadows of any nature on the backlit areas	Visual	100%	IOCL Drawings and specifications.	No shadows to be visible from outside.	
v		Finished face of the ACM after peeling off the sticker	Visual	100%	-	No damages in the ACM cladding.	
vi		Junction box	Visual	100%	IOCL Drawings.	Location of Junction box shall conform to the drawings.	
2	SPREADERS / DIRECTIONAL SIGNAGE / FACILITY SIGNAGE (Separate inspection report shall be enclosed for each RVI Element)						
a	AT CONVERTERS FACTORY PREMISES						
i	Aluminium Frame	Fabrication	Visual Check of fabricated frames	25% of the frames for each element under each call-up order	IOCL drawings.	Satisfactory workmanship with proper grinding of the welded joints to give a smooth finish to the frames.	
		Dimension	Physical Measurement	10%, at random, of each element under each Call-up order.	IOCL Drawings.	Shall conform to IOCL drawings.	
		Powder coating(white) - Quality & DFT	Painting: 1. Measurement of DFT.	1. 100% verification of purchase documents / Certificate of compliance for paints / powder coating for structurals under each call-up order. 2. 3 Readings, at random, for each finished frame.	1. IOCL Specifications. 2. Certificate of compliance. 3. Vendor's purchase documents for paints / powder coating.	1. All the DFT readings observed shall be within the range of 50 - 100 micron. 2. Powder coating process: a. Availability of invoices from the applicator. b. Availability of certificate of compliance to IOCL specifications from the applicator.	
ii	Foundation bolts (Direction Sign)	Material & Size	1.Verification of purchase documents. 2. Dimensional check.	100%	IOCL drawings.	1. Sizes / Dimensions to conform to drawings 2. Material of the bolts shall be of High Yield Strength	
iii	Finished Elements	Dimensions of panel, size & font of routed lettering in ACM & Polycarbonate, including pasting of vinyl	1. Verification of dimensions of panels and curvature. 2. Verification of finished product lettering routed in ACM & PC w.r.t standard art work.	100% quantity of panels used under each Call-up Order	1. IOCL Drawings. 2. Templates for curvature (developed by converters). 3. Standard art work of IOCL.	1. Size of fabricated panels and curvature shall conform to drawings. 2. Size and font of finished lettering shall conform to drawings. 3. Polycarbonate panel with lettering shall be fixed as per drawing to fit perfectly in the opening for letters in ACM panel.This panel shall be fixed to the ACM panel with silicon sealent neatly without leaving any cavity for dust accumulation. Note: Converter shall ensure to provide Warranty certificate for colour & adhesive property of the vinyl from the manufacturer prior to the final billing for the works.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
iv		Sealing the cuts in ACM with Hot air welding	Visual inspection of welded cuts	100% quantity of panels used under each Call-up Order	IOCL drawings.	Cuts in ACM shall be sealed with Hot Air Welding as indicated in the drawings.	
v		Workmanship for rear Side finish of facility Sign	Visual	25%, at random, elements under each call-up order	IOCL Drawings.	-	
vi		Shadows and light leakage	Visual	100% elements under each call-up order	IOCL Drawings.	No shadows or light leakges permissible	
vii		End cap finish for frames	Visual	25%, at random, elements under each call-up order	IOCL Drawings.	Satisfactory workmanship	
viii		Availability of peel-off sticker	Visual	100% elements under each call-up order	IOCL Drawings.	Shall be available without any damage	
	Complete Assembled Elements as Prototype (For every Converter at the beginning of the contract and installed in their factory premises)	All parameters mentioned above	Visual & Physical	100%	-	1. Shall conform to all the requirements indicated in i) to viii) above. Shall be the benchmark for the Converter for subsequent manufacture against the work order. No element shall be manufactured and accepted without the acceptance of Prototype. 2. Converters shall preserve one set of TPI cleared structural frames including the assembled lighting arrangements, etc for each RVI element as reference for future inspections.	
viii	Converter's Details	Availability of Name Plate	Visual	100% elements under each call-up order	-	Name Plate with following details shall be rivetted on the top ACM cladding / Aluminium frame: 1. Work Order No. 2. Converter's Name. 3. Month & Year of Manufacture. 4. Name of Inspection Agency.	
b	AT SITE						
		Pre-Erection					
i	Fabricated materials from factory	Verification / Identification of Material received at site	Visual	100%	1. Name plate details in Packing List. 2. Stickers on the ACM Panels.	Name Plate and the stickers shall match with the details in the Packing List and the RO sites indicated in the Call-up order	
		Post Erection :					
ii		Levels of elements	Measurement	100%	IOCL Drawings and specifications.	Elements to be in level. Permissible tolerance in level+/- 5mm.	
iii		Finished face of the ACM after peeling off the sticker	Visual	100%	-	No damages	
iv		Rigidity	Physical	100%	Nil	Shall be rigidly fixed.	
3	CANOPY / BUILDING FACIA (NON-LIT)						
a	AT CONVERTERS FACTORY PREMISES						
i	ACM Panels	Fabricated Panels - Main	1. Physical verification of dimensions of panels & curvature. 2. Verification of cladding layout drgs.	20% quantity of panels, at Random, to be used at each RO under each Call-up Order	1. IOCL Drawings. 2. Panel layout drawings of fascia developed by Converter.	1. Size of fabricated panels and curvature shall conform to drawings. TPI shall affix sticker with signature using indelible ink on the reverse side of panels for indentification of the inspected panels. 2. TPI shall approve the panel layout drawings developed by the converter for installation/erection at site.	
		Fabricated Panels -Corner 1m	Physical verification of dimensions of panels & curvature	100% quantity of panels used under each Call-up Order	IOCL Drawings.	Size of fabricated panels and curvature shall conform to drawings.	
ii	Structural Steel frames	Fabrication	Visual Check of fabricated frames	3 fabricated frames with all their elements, at random, against each call-up order.	IOCL drawings.	Satisfactory quality of welding.	
		Dimensional check (fabricated frames)	Physical Measurement prior to powder coating	3 fabricated frames with all their elements, at random, against each call-up order.	IOCL Drawings.	Dimensions shall conform to IOCL drawings.	
		Powder coating (white) - Quality & DFT	1. Verification of Purchase documents of paints / Powder coating 2. Measurement of DFT.	1. 100% verification of purchase documents / certificate for paints for structurals under each call-up order. 2. 3 Readings, at random, for 25% of finished frames in any call-up order.	1. IOCL Specifications. 2. Certificate of compliance.	1. All the DFT readings observed shall be within the range of 50 - 100 micron. 2. Powder coating process: a. Availability of invoices from the applicator. b. Availability of certificate of compliance to IOCL specifications from the applicator.	
iii	Stamping for identification of structural steel at site	Affixing Stickers, after inspection, indicating clearance.	-	-	-	TPI shall affix stickers, at two positions for each frame, with the signature of TPI Inspector using indelible ink.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
iv	Converter's Details	Availability of Name Plate	Visual	100%	-	Name Plate with the following details on the top surface (not to be seen in elevation) of blue ACM at any one of the end caps: 1. Work Order No. 2. Converter's Name. 3. Month & Year of Manufacture. 4. Name of Inspection Agency.	
b	AT SITE						
		Pre-Erection					
i	Fabricated materials from factory	Verification / Identification of Material received at site	Visual	100%	Stickers on the Structural Frames and ACM Panels.	Stickers shall match with the details in the Packing List and the RO sites indicated in the Call-up order	
		Post Erection :					
ii		Line and level of fascia	Measurement	100%	IOCL Drawings.	1. Fascia to follow the levels of top of Canopy fascia frame / Building fascia. Permissible tolerance: +/- 5mm. 2. Finished fascia surface at blue band shall be in line, when measured from end to end of canopy. Permissible tolerance of +/- 5mm in 20 M length of Canopy / Building fascia.	
iii		Joint gap between 4m wide panels	Physical	verification of 25% of joints in the finished fascia	IOCL Drawings.	Uniform joints of 4mm width with provision of adequate backing strip in ACM	
iv		GI sheet flashing overlap & fixing on canopy roof sheeting.	Visual	100%	IOCL Drawings.	1. Overlap of flashing with the roofing sheet shall be minimum 300mm. 2. Slope of the flashing sheet shall be 1:5 as indicated in the drawing.	
v		Provision of 1m panels at corners	Visual	100%	IOCL Drawings.	Location of fixing shall conform to the drawings	
vi		End cap	Visual	100%	IOCL Drawings.	Satisfactory workmanship in fixing of end cap	
vii		Finished face of the ACM after removal of peel off sticker	Visual	100%	IOCL Specifications.	No damages	
4	BACKLIT CANOPY FASCIA (Indian Oil lettering)						
a	AT CONVERTERS FACTORY PREMISES						
i	ACM Panels	Fabricated Panels	1. Physical verification of dimensions of panels & curvature. 2. Verification of cladding layout drgs.	25% quantity of panels, at Random, used under each Call-up Order	1. IOCL Drawings. 2. Panel layout drawings of fascia developed by Converter.	1. Size of fabricated panels and curvature shall conform to drawings. TPI shall affix sticker with signature using indelible ink on the reverse side of panels for identification of the inspected panels. 2. TPI shall approve the panel layout drawings developed by the converter for installation/erection at site.	
ii	Letterings in PET-G	Size and font	Measurement of size & verification of font.	25% of the completely fixed letter.	1. IOCL Drawings & specifications. 2. Certificate of Compliance to IOCL specifications.	1. Letter size, font & finish shall conform to drawings 2. Thermoforming process: a. Availability of invoices from the vendor. b. Availability of certificate of compliance to IOCL specifications from the vendor.	
		Double sided adhesive tape : Size & application	Physcal verification	100%	IOCL drawings.	Continuous 12mm wide VHB tapes (double sided) of 3M make shall be used for fixing the letters.	
		Polyseter film backing	Physcal verification of fixity of the film	100%	IOCL drawings.	Availability of Polyseter film of approved make as backing for each letter with satisfactory workmanship in fixing the film.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
iii	Structural Steel frames	Fabrication	Visual Check of fabricated frames prior to powder coating	25% of the number of frames, at random, fabricated against each call-up order.	IOCL drawings.	Good quality of welding	
		Dimensional check (fabricated frames)	Physical Measurement prior to powder coating	50% of fabricated frames under any call-up order	IOCL Drawings.	Dimensions shall conform to IOCL drawings.	
		Powder coating(white) - Quality & DFT	1. Verification of Purchase documents for Powder coating 2. Measurement of DFT.	1. 100% verification of purchase documents / certificate for paints for structurals under each call-up order. 2. 3 Readings, at random, for each finished frame.	1. IOCL Specifications. 2. Certificate of Compliance to IOCL specifications.	1. All the DFT readings observed shall be within the range of 50 - 100 micron. 2. Powder coating process: a. Availability of invoices from the applicator. b. Availability of certificate of compliance to IOCL specifications from the applicator.	
						Note: 1. All jigs and fixtures used in production of various structural elements shall be fabricated properly out of new materials. 2. Jigs shall be replaced after it is used for fabrication of materials for 5 ROs.	
iv	Electrical	Quality of wiring	Visual	100%	Standard Practices	Shall conform to the drawings and specifications with satisfactory terminations, dressing of wires, etc.	
		Sliding arrangement for light frames	Dimensions of the Sliding Frames	25% of the number of frames, at random, fabricated against each call-up order.	IOCL Drawings.	Sliding arrangement with aluminium channel and roller pivot shall conform to the drawings and shall be working satisfactorily.	
v	GI Service Door	Fixing of the door	Measurement of size	100%	IOCL Drawings.	Fixing of the door to conform to drawing.	
vi	GI Backing with lamination	Lamination for backing	1. Verification of Purchase Documents for laminating material. 2. Quality of Lamination.	100%	IOCL Drawings.	1. Invoices shall be available for 0.4 mm thk. high purity aluminum electro-brightened and anodized reflector (Anofol 740.3/Alanod 320G) 2. Satisfactory workmanship for lamination.	
vii	Complete Assembled unit as Prototype (For every Converter at the beginning and installed in their factory premises)	All parameters mentioned above	Visual & Physical	100%	-	1. Shall conform to all the requirements indicated in i) to vi) above. Shall be the benchmark for the Converter for subsequent manufacture against the work order. No element shall be manufactured and accepted without the acceptance of Prototype. 2. Converters shall preserve one set of TPI cleared structural frames including the assembled lighting arrangements, etc for each RVI element as reference	
viii	Stamping for identification of structural steel at site	Affixing Stickers, after inspection, indicating clearance.	-	-	-	Stickers, at two positions for each frame, with the signature of TPI Inspector using indelible ink.	
	QAP-AT SITE						
		Pre-Erection					
i)	Fabricated materials from factory	Verification / Identification of Material received at site	Visual	100%	1. Stickers on the Structural Frames and ACM Panels.	Name Plate and the stickers shall match the details in the Packing List and the RO sites indicated in the Call-up order	
		Post Erection :					
ii)		Joint gap between 4mt. Wide panels	Visual	100%	IOCL Drawings	Uniform joints of 4mm width with provision of adequate backing strip in ACM	
iii)		GI sheet flashing overlap & fixing on canopy roof sheeting.	Visual	100%	IOCL Drawings	1. Overlap of flashing with the roofing sheet shall be minimum 300mm. 2. Slope of the flashing sheet shall be 1:5 as indicated in the drawing.	
iv)		Verticality of PET-G letters & their fixing	Visual	100%	IOCL Drawings	1.The outer face of the letters shall be in line and the plumb. 2. Letters shall be firmly fixed with continuous VHB tapes.	
v)		Visibility of tube light from outside	Visual	100%	IOCL Drawings	No tube light be visible from outside.	

S. No.	ITEM / MATERIAL / PRODUCT	INSPECTION PARAMETERS	MODE / TYPE OF INSPECTION	EXTENT OF INSPECTION	REFERENCE DOCUMENT / MATERIAL	ACCEPTABLE LIMIT / CRITERION / SPECIFIED VALUES	OBSERVATIONS & COMMENTS BY INSPECTOR
vi)		Visibility of shadows of any nature on the backlit areas	Visual	100%	IOCL Drawings	No shadows to be visible from outside.	
vii)		Operation of Hinged Service Door	Physical	100%	IOCL Drawings	Satisfactory opening & closing of the door	
ix)		Finished face of the ACM after removal of peel off sticker	Visual	100%	IOCL Specifications.	No damages	
5	CANOPY COLUMN / BUILDING CLADDING						
a	AT CONVERTERS FACTORY PREMISES						
i	ACM PANELS	Fabricated Panels	1. Physical verification of dimensions of panels including grooving & curvature. 2. Verification of cladding layout drgs. developed by the Converter.	25%, at random, of panels to be used under each Call-up Order.	1. IOCL Drawings 2. Building Plan & Elevation	1. Size of fabricated panels and groovings shall conform to drawings. 2. Actual panel layout drawing shall conform to IOCL drawings.	
		Fabrication / Routing of Panels	Measurement	100% of panels to be used under each Call-up Order.	Approved Panel layout drawings for building cladding	Panel layout pattern shall conform to IOCL typical drawing.	
ii	Structural Steel Bracket (for Column cladding)	Fabrication	Visual Check of fabricated brackets prior to powder coating	20% of the number of brackets, at random, fabricated against each call-up order.	IOCL drawings.	Good quality of welding	
		Dimensional check (fabricated frames)	Physical Measurement of size of bracket	20% of fabricated brackets	IOCL Drawings.	Dimensions shall conform to IOCL drawings.	
		Powder coating(white) - Quality & DFT	1. Verification of Purchase documents / Certificates for paints / Powder coating 2. Measurement of DFT.	1. 20% verification of purchase documents of paints for structurals under each call-up order. 2. 3 Readings, at random, for each finished frame.	1. IOCL Specifications. 2. Certificate of compliance.	1. All the DFT readings observed shall be within the range of 50 - 100 micron. 2. Powder coating process: a. Availability of invoices from the applicator. b. Availability of certificate of compliance to IOCL specifications from the applicator.	
		Make of fastners	Verification of purchase documents	100% of purchase documents for the qty. under each Call-up order.	1. IOCL Specifications. 2. Approved makes of fastners by the TPI	1. Shall conform to approved makes. 2. Shall conform to IOCL specifications.	
iii	Converter's Details	Availability of Name Plate	Visual	100%	-	Name Plate with the following details: 1. Work Order No. 2. Converter's Name. 3. Month & Year of Manufacture. 4. Name of Inspection Agency.	
	AT SITE						
		Pre-Erection					
i	Fabricated materials from factory	Verification / Identification of Material received at site	Visual	100%	Sticker references in the packing list.	Stickers shall match the details in the Packing List and the RO sites indicated in the Call-up order	
		Post Erection :					
ii	Aluminium frame work for building cladding	Location of channels / brackets	Physical Verification	100%	1. IOCL Drawings. 2. Panel layout for the Building cladding.	Panel layout shall conform to IOCL drawing.	
iii	Fixing of MS brackets for column cladding		Physical Verification	100%	IOCL Drawings.	Fixing shall conform to the drawings.	
iv		Line of cladding	Visual	100%	Drawings and specifications.	Cladding to be in line.	
v		Joint gap between ACM panels	Visual	100%	Drawings and specifications.	3mm for Column / 5mm for Building	
vi		Top trim for Column Cladding	Physical Measurement	50%, at random, of the no. of trims provided at each RO under each Call-up order.	Drawings and specifications.	Conforming to IOCL drawings	
		Finished face of the ACM after removal of peel off sticker	Visual	100%	IOCL Specifications.	No damages	