

Integrated Management System

D-243 – Casting Inspection Checklist



1. Scope

This document covers the requirements for inspections of castings at a supplier's premises by the supplier's QC/QA team or SPP Personnel.

2. Purpose

To provide a record that all castings have been inspected at a supplier's premises prior to despatch to SPP Pumps. These are the minimum requirements as agreed in the SPP Pumps Ltd Supplier Specification for Castings Document (D-402).

3. Owner

SSE Manager

4. Related Documents

D-402 Supplier Specification for Castings

5. Revision History

Issue	Reason	Approved By	Date
01	New IMS document	MR	15/08/2019
02	Change of document owner	CP	21/11/2025
03	Add no visible surface defects	CP	10/03/2026

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Supplier Name:			Part Number:	Planned Delivery Date:
Supplier Contact Name:			Completion Signature:	Date:
Part	Criteria	Pass Fail	Action Required by Supplier	Comments (Supplier NCR No)
Pattern	Suitable to achieve casting as per the drawing		Inform SPP Purchasing Dept	
Mould	All dimensions correct to achieve the required casting		Review pattern and inform SPP Purchasing Dept	
Casting	Free from sand and scale		Remove	
Casting	Free from twist and buckling defects including shrouds		Rework	
Casting	Defect free – e.g. cracks, hot tears and no visible surface defects		Rework	
Casting	Joint and flash lines removed		Rework	
Casting	Cored out passages free of sand, blockages & other defects		Rework	
Casting	Casting meets relevant drawing tolerances		Rework / Re-cast. Inform SPP Purchasing of any delays	
Impeller Castings	Outlet port dimensions correct		Rework / Re-cast. Inform SPP Purchasing Dept	
Impeller Castings	Inlet & outlet vane profile correct to drawing		Rework	
Casting	Runners & Risers removed to max of 20mm above the relevant cast face.		Remove	
Casting	NDT requirements have been met – MPI, DPI		Inform SPP Purchasing to determine SPP Client requirements	
Casting	Primed as required		Rework	
Casting	Free from grease, burrs, surface corrosion, pitting & other surface breaking defects.		Rework	
Casting	Clearly identified with part and heat / melt numbers			

			Mark Up Castings. Stamp number on surface not to be machined.	
Documentation	Material and testing certificates provided before or with delivery		Seek concession from SPP Quality before delivering castings	

Note: All Pass / Fail boxes must be completed