

CTL Technical Acceptance Checklist

Inspection Item	Technical Requirement	Acceptance Method
Machine Appearance	No deformation, cracks, rust; paint uniform	Visual inspection
Frame Structure	Welds smooth; no defects; rigidity meets design	Visual
Decoiler Mandrel Expansion	Expansion smooth; pressure meets design	Functional test
Decoiler Pressure Arm	No leakage; movement stable	Visual + running test
Decoiler Bearings	No abnormal noise	Running test
Leveler Work Rolls	Material GCr15; hardness HRC 60±2	Hardness test + visual
Leveler Backup Rolls	Smooth rotation; no abnormal noise	Manual rotation test
Leveler Roller Parallelism	≤ 0.02 mm	Dial indicator
Leveling Accuracy (Flatness)	≤ 0.5 mm/m (or per contract)	Straightedge + feeler gauge
Surface Quality After Leveling	No scratches, dents, or marks	Visual
Shear Blade Condition	No cracks; edge sharpness meets requirement	Visual
Shear Cutting Accuracy	Length tolerance meets contract	Measurement
Shear Motor Performance	No abnormal noise; current within rated value	Running test
Shear Gearbox	No leakage; smooth transmission	Visual + running test
Feeding Speed	Meets design value	Speed measurement
Conveyor Belt	No tearing; stable speed; no deviation	Visual + running test
Conveyor Drive System	Chain/belt transmission smooth; no abnormal noise	Running test
Stacker Operation	Stacking height and alignment meet requirement	Functional test
Hydraulic System Pressure	Meets design pressure	Pressure gauge
Hydraulic Cylinder	No leakage; smooth movement	Visual + running test
Hydraulic Filter	Pressure difference within normal range	Gauge reading
Electrical Cabinet	Wiring neat; labels complete	Visual
PLC & HMI	All functions operate correctly	Functional test
Sensors	Proximity/photoelectric sensors respond correctly	Functional test
Encoder	Length measurement stable; no signal loss	Functional test
Emergency Stop	All E-stop buttons functional	Functional test
Safety Guards	Installed; no missing parts	Visual
Noise Level	≤ 85 dB (or per contract)	Noise meter
Vibration Level	Within ISO 10816 limits	Vibration meter
Lubrication System	Oil/grease supply normal	Visual + running test
Tools & Accessories	Delivered per packing list	Checklist
Technical Documents	Manuals, electrical drawings, maintenance guide	Document check
Spare Parts	Delivered per contract	Checklist
Final Acceptance	Meets all technical requirements	Comprehensive review