



Acceptance Inspection		Document No.: AI_AXE_GM_ECO Revision: V2
Client:	Project:	Date:

Table Configuration	A	B	C	D
Tables				
Rows/Table				
Columns/Table				
Supports/Table				
Support spacing				

Mounting Details	
Table tilt	
Module orientation	
Module edge to ground	
Fixing method	

Layout Positioning		
Criterion	Accepted	Rejected
Array set out as per drawings: <i>Distance between tables and position thereof is correct. Pile positions and span within 10mm tolerance</i> IM 3 Layout positioning		
Correct layout drawing revision used: <i>Site-specific structure, panel type, tilt and table length match approved drawing.</i> IM 3 Layout positioning		
East-West terrain slope: <i>Within 5° tolerance</i> IM 3 Layout positioning		
North-South terrain slope: <i>Lower than 30°</i> IM 3 Layout positioning		

Foundation Fixings		
Criterion	Accepted	Rejected
Open side of pile channel orientation: <i>Open side of the pile channel is facing a direction that accommodates the rafter orientation; rafter rail slots face upwards.</i> IM 4 Foundation fixings		
Front-back row piles are square: <i>Opposing diagonal distances similar within 100mm.</i>		
Pile Inspection - Complete if Driven Channels		
Pile alignment tolerances: <i>Driven piles are within the allowed tolerances.</i> IM 4 Foundation fixings		
Driven channel top protection: <i>Top of ramming profile has protective paint barrier (approx. 3cm coverage).</i> IM 4 Foundation connection		
Driven channel depth: <i>Driven to depth stated in layout drawing (typically 1.4m), within 100mm tolerance and 20mm relative to adjacent piles.</i> IM 4 Foundation connection		
Embedded channel hole condition: <i>Free of loose dirt at bottom; depth (typically 1.0m)/ hole diameter confirmed by physical pull test.</i> IM 4 Foundation connection		
Pre-drilling if obstruction encountered: <i>Target depth pre-drilled and filled in layers with compressed concrete of strength C16/20</i> IM 4 Foundation fixings		
Pull test passed:		
Cast Footing Inspection - Complete for Concrete Foundations		
Concrete foundation: <i>Constructed on 150mm G5 layers compacted to 95% MOD, then placed on in-situ material compacted to 93% MOD; within 50mm tolerance in width/length.</i> IM 5 Foundation connection		
Concrete strength: <i>Specified at 30 MPa with a minimum curing duration of 7 days before tensioning bolts.</i> IM 5 Foundation connection		
Foundation connection: <i>M12 hot-dip galvanised rods used with washers at depth stated in layout drawing.</i> IM 5 Foundation connection		
Threaded rods positioned correctly: <i>Threaded rods are embedded at least halfway (D/2) into the foundation depth in the concrete.</i> IM 5 Foundation connection		
Rebar / securing rod integration: <i>Piles integrated with rebar reinforcement through drilled holes for added stability.</i> IM 5 Foundation connection		
Concrete vibrated: <i>Concrete vibrator used to remove air pockets and ensure concrete fully surrounds the pile.</i> IM 5 Foundation connection		

Ground Screw Inspection – Complete if Ground Screws are being used.

Ground screw soil survey completed: <i>Correct ground screw type/dimensions selected for soil type and conditions.</i> IM 5 Foundation connection		
Ground screws installed correctly: <i>Installed straight and vertical, to correct depth, and securely anchored.</i> IM 5 Foundation connection		
Correct fasteners used on connections and torqued according to specification:		

Structure Assembly

Criterion	Accepted	Rejected
Rafters aligned correctly: <i>Bottom and top ends aligned in both vertical and horizontal planes before final torque.</i> IM 6 Mounting rafters		
Rafter slope: <i>Angle within 1° tolerance.</i>		
Without deformation and damage: <i>Zinc paint touch-ups done on areas where galvanising was damaged.</i>		
Correct fasteners used on connections and torqued according to specification:		

Mounting Rails

Criterion	Accepted	Rejected
Isolation pads fitted between Rafter and Rails: <i>When Aluminium rails are used.</i> IM 7 Mounting rails		
Rail spacing correct: <i>Per PV module installation guide and project-specific layout drawing.</i> IM 7 Mounting rails		
Thermal expansion gaps where applicable: <i>When tables exceed $\pm 35m$ in length.</i>		
Correct fasteners used on connections and torqued according to specification:		

Bracing Installation		
Criterion	Accepted	Rejected
Bracing method matches layout drawing: <i>Angle Bracing or Bracing Cables, connected to back posts/piles at specified locations.</i> IM 9 Bracing installation		
Bracing Cable best practice: <i>Wire rope clamps installed with the saddle on the live end of the wire rope.</i> IM 9 Bracing installation		
Thermal expansion gaps where applicable: <i>When tables exceed $\pm 35m$ in length.</i>		
Correct fasteners used on connections and torqued according to specification:		

PV Module Installation		
Criterion	Accepted	Rejected
Table horizontal levelled: <i>Levelled with the slope of the ground.</i>		
Modules without damage:		
Modules laid in portrait orientation: <i>Each module supported by two Rail lengths.</i> IM 10 PV module installation		
Middle/End clamps overlap module: <i>>6mm</i>		
Correct End Clamp used for module frame height: <i>30mm / 35mm / 40mm, with matching fastener length per Clamps and Fasteners table.</i> IM 10 PV module installation		
Click Fix clamps correctly seated: <i>Pegs fully seated in Rail slot; not repeatedly inserted/removed.</i> IM 10 PV module installation		
Nut Stoppers & Square Nuts positioned correctly: <i>Positioned in Rail cavity to match clamping configuration.</i> IM 10 PV module installation		
Nut Holder connection correct: <i>Positioned over Rail lip in line with panel edge (steel rail).</i> IM 10 PV module installation		
Earthing / Earth Plates installed correctly: <i>Spikes are pierced through anodised layer; Square Nut aligned with Earth Plate's central hole.</i> IM 10 PV module installation		
Correct fasteners used on connections and torqued according to specification:		

End Caps		
Criterion	Accepted	Rejected
End Caps installed on all rail ends: <i>Nut Stopper/Square Nut positioned near rail end before cap fitted.</i> IM 11 End Caps		
End Cap fastened: <i>M8x20 Hex Cap Screw tightened; M6.3 Self-Drilling Tek Screw installed at bottom if required for added security.</i> IM 11 End Caps		
Correct fasteners used on connections and torqued according to specification:		

Inspection and Maintenance		
Criterion	Accepted	Rejected
<i>Zinc paint touch-ups must be done where galvanising layers have been damaged.</i>		
-The products are to be inspected annually in the form of a visual inspection of the whole installation. Axe Struct must be notified of any first appearances of rust and abnormal deformations. -Annual spot checks are to be done on fasteners to ensure that the minimum required torque moment specified in this Manual is met. -Cleaning of the product must be done with water with a pH between 6 and 10, and without chemicals.		

Site Closeout		
Criterion	Accepted	Rejected
Site-wide cleanup:		
All rubbish has been removed:		
Tools and remaining parts packed in stores:		

Torque Settings Table		
<i>The specified settings below are assumed to have a dry application. Should a lubrication agent or anti-seizing be used, 80% of the below-listed values would apply. Fastening should be halted when aluminium sections start to visually deform.</i>		
Size	Stainless Steel (N·m)	Galvanised Grade 8.8
M8	18 N.m	N/A
M10	38 N.m	N/A
M12	60 N.m	93 N.m
M16	150 N.m	230 N.m
M20	300 N.m	464 N.m
M24	N/A	798 N.m

Additional Comments	
Table ID	Comments

Inspected by
(Name and surname)

Signature

Date