

XIX FLAME SPRAYING (ISO 4.9)

| | | Yes | No | N/A |
|---|--|--------------------------|--------------------------|--------------------------|
| A | 1. Identify the drawing, specification or document invokes the requirements for flame spraying | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 2a. Does a written detailed procedure exist and is it utilized for the flame spraying process? | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | 2b. Are procedures readily available? | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 3. Is the procedure approved by the Customer? List Procedure and Reference Approval Number, if applicable: | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 4. Are procedures/work instructions adequate for control of: | Sat | Unsat | |
| | a. (Proper Equipment) Guns, Filters Regulators, Flowmeters, Wire Feed Control, etc. | <input type="checkbox"/> | <input type="checkbox"/> | |
| | b. (Proper Materials) Gases, Wire, etc. | <input type="checkbox"/> | <input type="checkbox"/> | |
| | c. Temperature monitoring - preheat, spraying temp, cooling, etc | <input type="checkbox"/> | <input type="checkbox"/> | |
| | d. Methods for masking areas | <input type="checkbox"/> | <input type="checkbox"/> | |
| | e. Pressure and flow settings | <input type="checkbox"/> | <input type="checkbox"/> | |
| | f. Gun to workpiece distances and angles | <input type="checkbox"/> | <input type="checkbox"/> | |
| | g. Rate of application | <input type="checkbox"/> | <input type="checkbox"/> | |
| | h. Final thickness | <input type="checkbox"/> | <input type="checkbox"/> | |
| A | 5a. Are pieces to be flame sprayed cleaned prior to process? | <input type="checkbox"/> | <input type="checkbox"/> | |
| A | 5b. List methods and materials used, if applicable | | | |
| A | 5c. Is cleanliness maintained prior to flame spraying? | <input type="checkbox"/> | <input type="checkbox"/> | |

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|----------|--|--|---|
| A | 6. Identify inspection methods used to verify conformance with procedures and standards | Sat <input type="checkbox"/> | Unsa <input type="checkbox"/> |
| | <ul style="list-style-type: none"> • Visual <input type="checkbox"/> • Tensile Bond <input type="checkbox"/> • Hardness <input type="checkbox"/> • Thickness <input type="checkbox"/> • Other (list) <input type="checkbox"/> | | |
| A | 7. What inspection documents exist and are they maintained to confirm inspection process was performed? | Yes <input type="checkbox"/> | No <input type="checkbox"/> |
| | <p>a. Are inspection documents properly completed and maintained?</p> <p style="text-align: center;"><input type="checkbox"/> <input type="checkbox"/></p> <p>b. Review and record number of samples: _____</p> | | |
| A | 8. Is traceability maintained for material which has been flame sprayed? | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 9. Is inspection data reviewed and accepted by qualified personnel?: | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 10. Are corrective actions performed and documented after rejectable attributes have been found? | Yes <input type="checkbox"/> | No <input type="checkbox"/> |
| | | N/A <input type="checkbox"/> | |
| A | 11 Are all tools, gages, meters, utilized for monitoring and/or inspection a part of the manufacturer's calibration program? | <input type="checkbox"/> | <input type="checkbox"/> |
| | | <input type="checkbox"/> | |
| A | 12. Are certifications for raw materials used in flame spraying process reviewed for acceptance and maintained on file for review? | <input type="checkbox"/> | <input type="checkbox"/> |
| | | <input type="checkbox"/> | |

| | | Yes | No | N/A |
|----------|---|--------------------------|--------------------------|--------------------------|
| A | 13. Are personnel performing flame spraying process knowledgeable in the use of the: | | | |
| | • Procedure: | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | • Tools | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| | • Gages, meters, etc | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 14. Are special precautions identified prior to performing flame spray process (i.e. safety issues, hazard material)? | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 15a. Are any special handling equipment used or special packaging required after flame spraying process? List: | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| A | 15b. Is handling equipment and packaging requirements accomplished IAW the specification, drawing or procurement spec? | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

Additional Comments/Concerns