



## PROCESS CHECK REPORT

Company:			
Process Title	CHROME PASSIVATION OF CADMIUM AND ZINC		
Category(s) of Approval	12o		
Process Check Report Ref. No:			
Date Of Process Audit:			
Auditor (please print name):			
Nadcap Reference (if applicable)			
Invoked Documents:- HBIFSAS/QA/SC1, QAIS Doc Ref Q5B-008H			
<b>QA Element</b>	<b>Yes</b>	<b>No</b>	
	✓	X	
<b>Calibration Status:</b> All Inspection, Measuring and Test Equipment used in this Process is calibrated, and certified against equipment traceable to National Standards			
<b>Materiel Usage:</b> All Materiel used in this Process is in accordance with requirements of the relevant Process Specification/Standard			
<b>BAEP/BS:</b> All work has been processed in accordance with the latest issue of the relevant BAEP(s) and/or National Standards			
<b>Technique Sheets:</b> All applicable Technique Sheets used, including Inspection Plans, are to the latest issue and have been approved by HBQSC			
<b>Training/Qualification:</b> All relevant personnel involved with this Process are appropriately trained, qualified and assessed periodically			
<b>Internal Audit:</b> The Internal Audit for this Process is current, with no outstanding CAs			
<b>If No to any of the above QA Elements - give details below:</b>			
<b>Audit Comments:</b>			
<b>Auditor:</b>	<b>QA Manager:</b>	<b>Approved by (HBQSC):</b>	



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### Invoked Documents Listing

#### 1. Process Specifications

Reference No.	Title	Issue
BAEP 1516	Chromate Passivation Of Cadmium And Zinc Surfaces	2

#### 2. Quality Assurance Instructions To Suppliers

Reference No.	Title	Issue

#### 3. Other Technical Documents Invoked

Reference No.	Title	Issue

#### 4. General

For any deviations to the applicable BAEP please see the Processor Surveillance Questionnaire Pack



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<b>AUDIT FINDINGS</b>
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Details Of Check	Result / Remarks	Action Required
Is BAEP 1516 available and at the correct issue.		
Does an internal procedure exist and what is its reference/issue status.		
Is the operation for passivation satisfactorily incorporated into the planning.		
Are history sheets available and fully endorsed.		
Are all parts free from residues of oil, grease and plating solutions prior to passivation.		
For components other than those which have been freshly plated, and de-embrittled which have not been contaminated: are they degreased and immersed for 5-15 minutes in a boiling solution of 4-8 ozs of trisodium phosphate.		
Are the components thoroughly washed in clean cold running water.		
Are the components dipped for 10 seconds or less in either nitric or sulphuric acid of 1g/l prior to passivation (optional).		



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<b>AUDIT FINDINGS</b>
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Details Of Check	Result / Remarks	Action Required
Are the parts dipped in the passivation solution for 5-10 seconds.		
If longer, then up to 20 seconds can be used as long as the sulphuric acid content is reduced to 3ml/l.		
Are the parts transferred to cold rinsing water tanks until free from yellow colouration.		
Are the parts dipped in hot water not exceeding 50 degrees C for less than 30 seconds and dried in air at the same temperature.		
Are the parts inspected for an iridescent brassy or golden appearance free from bare patches. (Light brown/grey films are considered acceptable but not aimed for).		
Are the components checked for adherence when lightly rubbed with white tissue paper.		
Is the salt droplet test undertaken on samples taken at a frequency determined by the Quality Manager.		
Is the bath examined as per para 1.4.2. Of BAEP 1516.		



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### AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Are the operators given satisfactory training prior to use of the passivation solution.		