



PROCESS CHECK REPORT

Company:			
Process Title	VACU-BLASTING (WITH DRY ALUMINIA GRIT)		
Category(s) of Approval	12s		
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			
QA Element	Yes	No	
	✓	X	
Calibration Status: All Inspection, Measuring and Test Equipment used in this Process is calibrated, and certified against equipment traceable to National Standards			
Materiel Usage: All Materiel used in this Process is in accordance with requirements of the relevant Process Specification/Standard			
BAEP/BS: All work has been processed in accordance with the latest issue of the relevant BAEP(s) and/or National Standards			
Technique Sheets: All applicable Technique Sheets used, including Inspection Plans, are to the latest issue and have been approved by HBQSC			
Training/Qualification: All relevant personnel involved with this Process are appropriately trained, qualified and assessed periodically			
Internal Audit: The Internal Audit for this Process is current, with no outstanding CAs			
If No to any of the above QA Elements - give details below:			
Audit Comments:			
Auditor:	QA Manager:	Approved by (HBQSC):	



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Invoked Documents Listing

1. Process Specifications

Reference No.	Title	Issue
BAEP 2002	Vacu Blasting (With Dry Alumina Grit)	7

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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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Is BAEP 2002 available and at the correct issue.		
Does an internal procedure exist and what is its reference/issue status.		
Is the operation for vacu-blasting satisfactorily incorporated into the planning.		
Are history sheets available and fully endorsed.		
Are there separate cabinets for Aluminium/Stainless Steel/Steel/Titanium components, or has a seperator been fitted to the cabinet, or the grit is changed at each change of material, i.e. grit used for Aluminium is not used on Steel/Titanium and vice verca.		
Is the area clean and conducive to good housekeeping.		
Is fused Alumina supplied by an approved supplier and a C of C issued.		
Is the grit replaced when: Iron content reaches 0.5% or does not provide specified surface finish or Almen Arc heights not achieved.		



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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Have all previous manufacturing processes been carried out.		
Have all blemishes, scratches, corrosion damage been rectified.		
Have all dimensional and surface finish checks been carried out.		
Have all components been degreased to an approved method prior to blasting.		
Has the component been masked in an approved manner.		
Are Technique Sheets available and do they specify:- Areas not requiring blasting, size of grit to be used, blast pressure, rate of travel, nozzle distance, almen arc height required.		
Where blasting is a pre-treatment for metal adhesive bonding is the air pressure in accordance with BAEP 9062.		
When blasting for fatigue improvement is the technique determined by means of the almen gauge to BAEP 9046.		
Are visual inspections (x10 magnification) of the surface performed to ensure complete coverage.		



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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
How is the treatment recorded and is time/date of blasting annotated (subsequent treatment with 4 hours).		
Are material batch identities/serial numbers/test specimen numbers maintained during the process.		
If subsequent treatment is not carried out within 4 hours, what measures are used to prevent corrosion of components.		
What is make/model of machine that is used to blast the parts.		