



PROCESS CHECK REPORT

Company:			
Process Title	HOT ISOSTATIC PRESSING OF CASTINGS		
Category(s) of Approval	19c		
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

2. Quality Assurance Instructions To Suppliers

Reference No.	Title	Issue

3. Other Technical Documents Invoked

Reference No.	Title	Issue

4. General

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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Does an internal procedure exist and what is its reference/issue.		
Is the operation for Hipping satisfactorily incorporated into the planning.		
Are history sheets available and fully endorsed.		
Is tooling required for process		
What gas is used		
Is hipping suitable to be used on cast material (how originally decided)		
What pressure is used		
Does it meet specification (how calculated)		
How is pressure controlled		
Is the furnance adequate for Hawker parts (size etc)		
Are operators trained to use equipment. Do they hold certificates , are training records current, how many operators can use equipment. Are work instructions in use.		
Can all calibrations be traced to national standards.		
Will FAI be carried out. (Stones or Bodycote)		



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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Is the Gas recycled.		
How is the integrity of recycled gas documented.		
What checks/Analysis of gas is recorded.		
What incoming documents are received from Stones		
Does Route card state that castings cleaned/degreased in accordance with BAEP 9038.		
Do Bodycote carry out any pre-hip treatments. If so in accordance with what.		
What happens if a cycle failure occurs.		
Are cycle failures recorded.		
What analysis of process is carried out.		
Are Stones informed.		
How are parts despatched back to Stones (Packaging).		
Are all process specifications invoked documents at correct issue.		
Check who stamps for process on job card.		
Check approvals signatures list / quality manual.		