



## PROCESS CHECK REPORT

<b>Company:</b>			
<b>Process Title</b>	CORROSION INHIBITING ADHESIVE PRIMER		
<b>Category(s) of Approval</b>	19q		
<b>Process Check Report Ref. No:</b>			
<b>Date Of Process Audit:</b>			
<b>Auditor (please print name):</b>			
<b>Nadcap Reference (if applicable):</b>			
<b>Invoked Documents:- HBIFSAS/QA/SC1, QAIS Doc Ref Q5B-008H</b>			
<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
BS 23865	Corrosion Inhibiting Adhesive Primer	Revision C Issue D 30th March 1984

### 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 BS 23865 available and at the correct issue.		
Does an internal procedure exist and what is its reference/issue status.		
Is the operation for the application of corrosion inhibiting adhesive primer satisfactorily incorporated into the planning.		
Are the history sheets available and fully endorsed.		
Has the primer been deemed compatible with the adhesive system for mechanical properties listed in the governing adhesive system specification.		
Has the primer passed tests 6, 7, 9 and 13 of Table 1 when prepared in accordance with section 4.3 and are top coated with MIL-P-23377 primer.		
For liquid primer and cured film requirements has the primer passed tests 1 through 13 of Table 1.		
Does the room in which the details are primed meet the requirements of BS 23733 of 65-80°F and max 60% RH or upto 65% for max of 4 hours in 24 hour period.		



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## AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
<p>Are the operators certified and is this done on a monthly basis by the following:-</p> <ul style="list-style-type: none"> <li>i) Primer prepared per PS 10050 Table 1 or BS 24554, primed in a room within 2 hours of cleaning.</li> <li>ii) Is the primer warmed up to room temperature prior to opening the container, mixed before and agitated during application.</li> <li>iii) Spray or brush applied to a thickness of 0.00015 to 0.0004 inches within 72 hours of surface preparation.</li> <li>iv) Cured as per para 6.8.2.</li> <li>v) Are the test samples used 10" x 12" x 0.020", 2024 T3 panels.</li> <li>vi) Are the panels divided into quadrants with each quadrant numbered and thickness checked. (0.00015 - 0.004 after air dry and cure).</li> </ul>		
<p>Are the details after baking stamped with a date to indicate expiration of the storage life after 5 years from the date of clean, prime and bake.</p>		
<p>Are the cure conditions of 250°F ± 10° for 30-90 minutes adhered to and are parts segregated so that contact between them does not exist.</p>		
<p>Are details that are primed not stored for more than 5 years.</p>		



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If details to be stored or transported are not done so in an environmentally controlled condition then are they wrapped and sealed.		
Is a stamp or label placed on the wrapping recording the date of expiration.		
Has contamination of the parts taken place. If yes then are they wiped with a lint free cloth dampened with MEK, naptha, alcohol, acetone or solvent per MIL-C-38736.		
Is the primer capable of continious operation through the temperature range of -67 to 350°F.		
Is the prime room temperature and humidity recorded.		
Are production parts primed per this specification, traceable to the following:- i) Time and date of clean. ii) Time and date of primer application. iii) Date, time in oven, time in and out of oven cure.		
Are the qualification samples submitted for approval accompanied by a test report verifying that the primer has passed.		



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Does the vendor have suitable test facilities to perform the required tests or are other approved services utilised (by Beech Aircraft).		
Do the qualification samples consist of a minimum of 4 quarts submitted from each of 3 batches made on production equipment used for filling production orders and operated by production personnel.		
For film property tests are the specimens prepared as per section 4.3 for each batch of primer and tests 9 and 10 performed.		
For liquid primer tests are 2 through to 5 carried out on each batch (no retests allowed).		
Is each shipment of primer accompanied by a test report containing data verifying that the batch has been tested by the supplier and has passed tests 2, 3, 4 and 5 of Table 1.		
Are the following tests conducted using BS 23724 adhesive:- i) Room temperature lap shear. ii) Metal-to-metal peel. iii) Sandwich peel.		



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Are the test specimens for tests 6 through 13 made from base/alclad 2024 T3 of 4" x 6" x 0".020 in size (tests 8 and 9 on base aluminium).		
Do the specimens then follow the following procedure:- i) Cleaned as per PS 10050 or BS 24554. ii) Primed to a dry film thickness of 0.00015 - 0.004". iii) Cured for 1 hour at 250 ± 10°F (within 30 minutes to 24 hours after priming). iv) Film thickness measured on 3 randomly selected panels. If outside the range then each panel from the primed batch must be tested and discarded if it fails to meet the thickness requirements.		
Are the non-volatile/inhibitor analyses checked as per section 4.5 of BS 23865.		
Is the transit time for shipment of primer from vendor to receiving company within 7 days.		
How is the film stored prior to use.		
Are the freezers calibrated.		



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Are there any working freezers in use.		
How is the primer controlled in/out of freezer.		