ASSEMBLED MOULD INSPECTION

Minimum Frequency – 1ST MOULD of NEW PRODUCTION RUN THEN SAMPLE 3 MOULDS/SHIFT (each centre)

1. Record the number of occurrences of each type of fault for each mould in the sample.
2. Concrete may not be poured until the mould has been inspected by QC personnel and any faults corrected
3. Sum the total number of faults for each sample.
4. All recorded faults to be rectified before the mould is poured.
5. Determine whether non-conforming, i.e.:
    a. Same fault occurs in 3 consecutive samples.
    b. Same fault occurs 3 or more times in a sample.
    c. More than 6 faults in sample
6. Update *POLES_QA_FOR_034_Quality Control Chart* to monitor non-conformance trends and loss of control.

If non-conforming do the following:

a. Advise the designated quality coordinator of non-conformance and provide them with a copy of this form.
b. Fix any problems and record the actions taken
c. Double sampling rate until 4 consecutive shifts show zero faults (identify double sampling by using same date and time in records)

RECORD THE RESULTS																	
	Date																
	Product Type																
	Mould Size																
	Mould No.																
	Shift																
RECORD THE NUMBER OF OCCURANCES	1. Loose cage – missing locating ferrule																
	2. Distorted cage (oversized)																
	3. Distorted cage (undersized)																
	4. Cage wrong location																
	5. Broken welds																
	6. Missing, bent, or broken studs																
	7. Rusty cage																
	8. Rubber plugs missing																
	9. Insufficient cover																
	10. Excessive oil																
	11. Foreign material in mould																
	12. Insufficient cover to steel																
	13. Seam Bolts missing																
	14. Mould not clean																
	15. Name plate incorrect location																
	16. Seams not clean																
	17. Depth Marker incorrect location																
	18. Twisted Cage In mould																
	19. Fitting Datum incorrect																
	20. Stud / Lug / Tip Ferrules incorrect																
TOTAL FAULTS *(3 moulds)*																	
Action taken to rectify																	
Inspected by *(initials)*																	

Document History:

Version No.:	Date:	Description	Made by	Reviewed by	Approved by
1	02/072024	Initial Issue	Joshua Myhill	Joshua Myhill	Joshua Myhill