| **Bearbeitung:**  External Specification: | **NAS4006, Kals 2242** |
| --- | --- |

| ASQ Z1.4 Level 1 AQL 4.0 | ASQ Z1.4 Level 2 AQL 4.0 | Folgenden Anweisungen ist Folge zu leisten:  Follow Instructions below: |
| --- | --- | --- |
| | **Los** | **Stichprobe** | **Max. schlechte Bauteile** | | --- | --- | --- | | 2-50 | **2** | **0** | | 51-500 | **3** | | 501-35000 | **5** | | | **Los** | **Stichprobe** | **Max. schlechte Bauteile** | | --- | --- | --- | | 2-25 | **2** | **0** | | 26-150 | **3** | | 151-1200 | **5** | | 1201-35000 | **8** | **1** | | 35001-500000 | **13** | | 1. Vorsichtige Handhabung der Bauteile. Carefull handling of Part. |
| 1. Bauteile nur mit sauberen Latex/Nitril Handschuhen gemäß VD-A44 handhaben.   Handle parts with clean Latex/Nitril gloves only.  Follow instructions of VD-A44 |
|  |  | 1. Bei Abweichungen am Bauteile hinsichtlich Aussehen und Dimensionen ist die Abteilung PPS zu informieren   In case of deviations on the component regarding to appearance and the dimensions, the PPS department must be informed. |

| **Tab. 1:** Bauteil-Dimensionen  Tab. 1: Component dimensions | | | |  |  |
| --- | --- | --- | --- | --- | --- |
| **Stückgewicht**  Part weight | **g** | **Anzahl Testteile**  Quantity of test parts |  |  |  |

| **Tab. 2: Testteil Durchmesser MP1**  Tab. 2: Test part diameter | | | | | | | | |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | **Testteil-Nr.:**  Test part no: |  |  |  |  | **Beurteilung**  Part evaluation: | | **MA-Stempel**  Employee stamp | **Berechnung Schichtdicke**  Thickness calculation |
| Ø1 | **Nach AI2O3**  After Al2O3 | mm | mm | mm | mm | N/A | |  |  |
| d  Min | **TT UGW** Min | WERT  (mm) | WERT  (mm) | WERT  (mm) | WERT  (mm) | **TT UGW** Min [mm] d Min  + (minimal Schichtdicke x 2)  d Min + (minimum layer thickness x2) |
| d  Max | **TT OGW** Max | WERT  (mm) | WERT  (mm) | WERT  (mm) | WERT  (mm) | **TT OGW** Max [mm] d Max  + (maximal Schichtdicke x 2)  d Min + (maximum layer thickness x2) |
| **i.O**  passed | **n.i.O**  failed |
| Ø2 | **Nach Lack**  After Painting | mm | mm | mm | mm | X | X |  | Schichtdicke **nach** dem Beschichten  Nominal dimension after coating |
| **Schichtdicke**  Layer thicknes | µm | µm | µm | µm | X | X |

| **[WE]** | **Wareneingangskontrolle** Incomming goods inspection | | | | | | Nachweis siehe ND-P83  For evidence see ND-P83 | |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  |  | | | | |
| 010 | Externe Anweisung: **--**  External procedure: | Interne Anweisung: **VD-P26**  Internal procedure: | | | | |
|  |  |  | | | | |
| **[Q]** | **Qualitätssicherung Eingang**  Incoming quality assurance | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | |
| 015 | Externe Anweisung: **--**  External procedure: | Interne Anweisung: **VD-A421**, **VD-A410, ND-B136**  Internal procedure: | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: |  | |  | | Uhrzeit |
|  | Punkte QS ausfüllen  Fill out items QS | **ND-P83** | | | | |
| Kontrolle der Bauteile auf Beschädigung  Inspection for damages | **ASQ Z1.4 Level 2** | | | | |
| Bauteil-Dimensionen in **Tab. 1** dokumentieren  Document part dimensions iin Tab.1 | | | | | |
| Testteil-Nr. in **Tab.2** dokumentieren  Document test part no. in Tab.2 | | | | | |
| **Durchmesser** Prüfgegenstand:  Test specimen for Diameter test: | **4 Testteile (zylindrisch)**  4 test specimens (cyndrical) | | | | |
| **Durchmesser** Material Prüfgegenstand:  Material test specimen for Diameter test: | **Stahl 4130** oder vergleichbar  Steel 4130 or equivalent material | | | | |
| **Durchmesser** Abmaße Prüfgegenstand:  Dimensions test specimen for Diameter test: | entsprechend **Bauteildurchmesser**  according to part diameter | | | | |
| **PM Nummer Prüfmittel:**  PM number of Test equipment: | **Bitte auf FU notieren**  Please note on FU | | | | |
| **Anzahl geprüfter Bauteile:**  Amount of parts checked: |  | |  | |  |
| **Beurteilung der Bauteile:**  Part evaluation: | **i.O**  passed | X | **n.i.O**  failed | X |  |
|  | **Uhrzeit Ende AG:**  End of workstep: |  | |  | | Uhrzeit |
|  |  |  | | | | |

| **[P]** | **Alkalische Ultraschallentfettung** Ultra sonic degreasing | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | | | | | | | | | | | | |
| 020 | Externe Anweisung: **--**  External procedure: | | | | Interne Anweisung: **VD-P47**  Internal procedure: | | | | | | | | |
|  | **Achtung! Ab 12 mm Ø oder einer Länge von 100 mm den Drehantrieb AUS - schalten!**  Attention! Switch the rotary actuator OFF | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  | Zulässige Anlage:  Permitted equipment: | | | | **TE1, UE1** | | | | | | | | |
| **Ultraschall verwendet:**  Ultrasonic used: | | | | **Ja**  Yes | | | X | | **Nein**  No | X | |  |
| **Verwendete Anlage:**  Used equipment: | | | |  | | | | |  | | |  |
| **Transportbehälternummer dokumentieren:**  Document the transport container ID: | | | |  | | | | |  | | |  |
| **Uhrzeit Ende AG:**  End of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  | | | |  | | | | | | | | |
| **[P]** | **Wasserbruchtest** Water break free test | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | |
| 025 | Externe Anweisung:**--**  External procedure: | | | | Interne Anweisung: **VD-A20**  Internal procedure: | | | | | | | | |
|  | **Hinweis: Kalibrierten Timer benutzen!**  Note: Use a calibrated timer! | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  | Die Bauteile mit VE-Wasser benetzen.  Moisten the parts with demineraliesd water. | | | | **≥ 30 sec.** | | | | | | | | |
| Prüfmittel:  test equipment: | | | | **Auge**  Eye | |  | | |  |  | |  |
| **Timer Nr. dokumentieren:**  Document timer no: | | | |  | |  | | |  |  | |  |
| **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | |  | |  | | |  |  | |  |
| **Beurteilung der Bauteile**:  Part evaluation: | | | | **i.O**  passed | | X | | | **n.i.O**  failed | X | |  |
|  | **Auswertung:** Bei **n.i.O** Wiederholung der Entfettung.  Evaluation: If a Water break is visible repeat degreasing. | | | | | | | | | | | | |
|  |  | | | |  | | | | | | | | |
| **[P]** | **Drucklufttrocknen** Drying with compressed air | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | |
| 030 | Externe Anweisung: **--**  External procedure: | | | Interne Anweisung: **VD-A8, VD-P48**  Internal procedure: | | | | | | | | | |
|  | **Geprüfter Druckluftentnahmepunkt (DLEP):**  Tested compressed air extraction point: | | |  | | | | |  | | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | |  | | | | |  | | | | Uhrzeit |
|  |  |  | | | | | | | | | | | |
| **[P]** | **Thermisches Trocknen** Thermal drying | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | |
| 035 | Externe Anweisung: **--**  External procedure: | | | | Interne Anweisung: **VD-P48**  Internal procedure: | | | | | | | | |
|  | **Hinweis: Kalibrierten Timer benutzen!**  Note: Use a calibrated timer! | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  | Zulässiger Ofen:  Permitted oven: | | | | **O 3, O 6, O 8** | | | | | | | | |
|  | Empfohlene Trocknungsdauer:  Recommended drying time: | | | | **≥ 20 min** | | | | | | | | |
|  | Zulässige Temperatur:  Permissible temperature: | | | | **100 ± 5 °C** | | | | | | | | |
|  | **Verwendeter Ofen:**  Used oven: | | | |  | | | | |  | | |  |
|  | **Timer Nr. dokumentieren:**  Document timer no: | | | |  | | | | |  | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  |  | |  | | | | | | | | | | |
| **[P]** | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | |
| 040 | Externe Anweisung: **ASQ Z1.4 Level 1**  External procedure: | | | | Interne Anweisung: **VD-A21**  Internal procedure: | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  | Bauteile auf Beschädigungen und vollständige Trocknung prüfen.  Check component for damage and complete drying. | | | | | | | | | | | | |
| **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | |  | | | | |  | | |  |
| **Beurteilung der Bauteile:**  Part evaluation: | | | | **i.O**  passed | X | | | | **n.i.O**  failed | | X |  |
| **Transportbehälternummer dokumentieren:**  Document the transport container ID: | | | |  | | | | |  | | |  |
| **Uhrzeit Ende AG:**  End of workstep: | | | |  | | | | |  | | | Uhrzeit |
|  |  | |  | | | | | | | | | | |

| **[P]** | **Al2O3-Aktivierung** Al2O3-Grit Blasting | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | | | | | | | | | | | | | | | | |
| 045 | Externe Anweisung: **--**  External procedure: | | | | | | | Interne Anweisung: **VD-A8, VD-A423**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit |
|  | **Geprüfter Druckluftentnahmepunkt (DLEP):**  Tested compressed air extraction point: | | | | | | |  | | | | |  | | | |  |
|  | Zulässige Strahlanlage:  Permitted blasting equipment: | | | | | | | **EK 1, EK 2** | | | | | | | | | |
|  | Zulässiges Strahlmittel:  Permitted blasting media: | | | | | | | **F120** | | | | | | | | | |
|  | Zulässiger Druck:  Permitted pressure: | | | | | | | **1,0 – 3,5 bar** | | | | | | | | | |
|  | Abstand Düse-Bauteil:  Distance nozzle part: | | | | | | | **20 ± 10 cm** | | | | | | | | | |
|  | **Verwendete Anlage:**  Used equipments: | | | | | | |  | | | | |  | | | |  |
|  |  | | | | |  | | | | | | | | | | | |
| **[P]** | **Druckluftreinigen** Cleaning with compressed air | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | |
| 050 | Externe Anweisung: **--**  External procedure: | | | | | | | Interne Anweisung: **VD-A8, VD-A42**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit |
|  |  | |  | | | | | | | | | | | | | | |
| **[P]** | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | |
| 055 | Externe Anweisung: **ASQ Z1.4 Level 1**  External procedure: | | | | | | | Interne Anweisung: **VD-A21**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit |
|  | Strahlbild: Bauteile müssen eine gleichmäßig matte Oberfläche aufweisen.  Blasted Surface: Surface must have a continuous mat appearance | | | | | | | | | | | | | | | | |
|  | Verunreinigung: Bauteile dürfen keinerlei Verunreinigung aufweisen.  Soiling**:** Parts may not be soiled after blasting is completed. | | | | | | | | | | | | | | | | |
|  | Beschädigungen: Schäden an Bauteilen sind nicht zulässig.  Damages are not permissible. | | | | | | | | | | | | | | | | |
|  | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | | | |  | | | | |  | | | |  |
|  | **Transportbehälternummer dokumentieren:**  Document the transport container ID: | | | | | | |  | | | | |  | | | |  |
|  | **Beurteilung der Bauteile:**  Part evaluation: | | | | | | | **i.O**  passed | | X | | | **n.i.O**  failed | X | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | |  | |  | | |  |  | | | Uhrzeit |
|  |  | | |  | | | | | | | | | | | | | |
| **[P]** | **Durchmesserprüfung der Testteile** Diameter check of the test specimen | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | |
| 060 | Externe Anweisung: **--**  External procedure: | | | | | | | | Interne Anweisung: **VD-A410**  Internal procedure: | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | | |  | |  | | | | Uhrzeit | | |
|  | **Hinweis:** Min. 3 Messungen mittig am Schaft jeweils um 120° gedreht pro zu prüfenden Teil.  Note: Min. 3 measurements rotated 120° centrally on the shaft per test part to be tested. | | | | | | | | | | | | | | | | |
|  | **PM Nummer Prüfmittel:**  PM number of Test equipment: | | | | | | | |  | |  | | | |  | | |
|  | **Durchmesser (Ø1) in Tab. 2 eintragen und Grenzwerte (UGW/OGW) berechnen.**  Enter diameter (Ø1) in Tab. 2, and calculate limit values (UGW/OGW). | | | | | | | | | | | | | |  | | |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | | |  | |  | | | | Uhrzeit | | |
|  |  | | | |  | | | | | | | | | | | | |
| **[P]** | **Lackansatz** Paint preparation | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | |
| 065 | Externe Anweisung: **NAS4006**  External procedure: | | | | | | | Interne Anweisung: **VD-A439, VD-A330**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit |
|  | **Ansatznummer:**  Paint preparation number: | | | | | | |  | | | | |  | | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit |
|  |  | | | | | |  | | | | | | | | | | |
| **[P]** | **Lackieren** Spray painting | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | |
| 070 | Externe Anweisung: **NAS4006**  External procedure: | | | | | | | Interne Anweisung: **VD-A439**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | |  | | | | Uhrzeit | |
|  | Lackieranlage:  Painting plant: | | | | | | | **L3, L4** | | | |  | | | |  | |
|  | Verwendete Anlage:  Plant used: | | | | | | |  | | | |  | | | |  | |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | |  | | | |  | | | | Uhrzeit | |
|  |  |  | | | | | | | | | | | | | | | |

| **[P]** | | **Durchmesserprüfung der Testteile** Diameter check of the test specimen | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | |  | | | | | | | | | | | | | | | | | |
| 075 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **VD-A410**  Internal procedure: | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | | |  | | | | | Uhrzeit | |
|  | | **Hinweis:** Min. 3 Messungen mittig am Schaft jeweils um 120° gedreht pro zu prüfenden Teil.  Note: Min. 3 measurements rotated 120° centrally on the shaft per test part to be tested. | | | | | | | | | | | | | | | | | |
|  | | **PM Nummer Prüfmittel:**  PM number of Test equipment: | | | | |  | | | | | |  | | | | |  | |
|  | | **Durchmesser (Ø2) in Tab. 2 eintragen und die Schichtdicke bestimmen.**  Enter the diameter (Ø2) in Table 2 and define the layer thickness. | | | | | | | | | | | | | | | |  | |
|  | | **Geforderte Schichtdicke erreicht:**  Required layer thickness achieved: | | | | | **Ja**  Yes | | X | | | | | **Nein**  No | | | X |  | |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | |  | | | | |  | | |  | Uhrzeit | |
|  | |  | | |  | | | | | | | | | | | | | | |
| **[P]** | **Zwischenkontrolle Schichtdicke**  Intermediate check thickness | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | | | |
| 080 | Externe Anweisung: **NASM 1312-12**  External procedure: | | | | | Interne Anweisung: **VD-A410, ND-P63**  Internal procedure: | | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | | | Uhrzeit |
|  | Prüfmethode:  Test method: | | | | | **Mikrometerschraube**  Micrometer screw | | | | | | | | | | | | | |
|  | Prüfgegenstand:  Test item: | | | | | **4 Testteile (zylindrisch)**  4 Test parts (cylindrical) | | | | | | | | | | | | | |
|  | **PM Nummer Prüfmittel:**  PM number of Test equipment: | | | | |  | | | | |  | | | | | | | |  |
|  | **Prüfbericht erstellen nach Kundenvorlage „ND-P63\_Prüfbericht fastener“ Speichern, Drucken und Abstempeln.**  Create test report according to customer template “Test report fastener Save, print and stamp. | | | | | | | | | | | | | | | | | | |
|  | Die nach Prüfbericht geforderte Anzahl Bauteile messen und im Entschichtungskorb ablegen.  Measure the number of parts required according to the test report and place in the decoating basket. | | | | | | | | | | | | | | | | | | |
|  | Beschichtung der Bauteile mit MEK vollständig entfernen. **Reihenfolge der Bauteile nicht ändern!**  Completely remove the coating of the parts with MEK. Do not change the order of the parts! | | | | | | | | | | | | | | | | | | |
|  | Bauteile in der gleichen Reihenfolge wie zuvor messen und die Schichtdicke ermitteln.  Measure the parts in the same order as before and determine the layer thickness. | | | | | | | | | | | | | | | | | | |
|  | **Achtung!** Die entschichteten Bauteile in einer beschrifteten Tüte der Position beilegen.  Attention! The decoated parts in a labelled bag must be enclosed with the position. | | | | | | | | | | | | | | | | | | |
|  | **Anzahl geprüfter Bauteile:**  Amount of faulty parts: | | | | |  | | | | |  | | | | | | | |  |
|  | **Beurteilung der Bauteile:**  Part evaluation: | | | | | **i.O**  passed | | | | X | **n.i.O**  failed | | | | | X | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | | | | Uhrzeit |
|  |  | | | | |  | | | | | | | | | | | | | |
| **[P]** | | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | | | |
| 085 | | Externe Anweisung: **ASQ Z1.4 Level 1**  External procedure: | | | | | Interne Anweisung: **VD-A21**  Internal procedure: | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | | Uhrzeit |
|  | | Gleichmäßige und glatte Beschichtung ohne Fehlstellen wie Löcher oder Blasen.  Uniform and smooth coating without holes or blisters. | | | | | | | | | | | | | | | | | |
|  | | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | |  | | | | |  | | | | | |  | |
|  | | **Beurteilung der Bauteile:**  Part evaluation: | | | | | **i.O**  passed | X | | | | **n.i.O**  failed | | | X | | |  | |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | | Uhrzeit | |
|  | |  | |  | | | | | | | | | | | | | | | |
| **[P]** | | **Thermisches Trocknen** Thermal drying | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | | | |
| 090 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **VD-P48**  Internal procedure: | | | | | | | | | | | | |
|  | | **Hinweis: Kalibrierten Timer benutzen!**  Note: Use a calibrated timer! | | | | | | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | Uhrzeit | |
|  | | Zulässiger Ofen:  Permitted oven: | | | | | **O 1, O 2, O 9** | | | | | | | | | | | | |
|  | | Zulässiges Programm:  Permitted program: | | | | | **3** | | | | | | | | | | | | |
|  | | **Timer Nr. dokumentieren:**  Document timer no: | | | | |  | | | | |  | | | | | |  | |
|  | | **Verwendeter Ofen:**  Oven used: | | | | |  | | | | |  | | | | | |  | |
|  | | **Blechnummer:**  Plate number: | | | | |  | | | | |  | | | | | |  | |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | | Uhrzeit | |
|  | |  |  | | | | | | | | | | | | | | | | |

| **[P]** | | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
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| 095 | | Externe Anweisung: **ASQ Z1.4 Level 1**  External procedure: | | | | | Interne Anweisung: **VD-A21**  Internal procedure: | | | | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | | | Uhrzeit | | |
|  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | | | | | | | |
|  | | Keine Fehler wie: Kratzer, Narben, Blasen, Streifen, Vertiefungen, Fremdkörper, Partikelanhäufungen, Inhomogenitäten oder sonstige Oberflächenfehler  No failures like: Scratches, scars, blisters, stripes, indentations, foreign bodies, particle clusters, inhomogeneities or other surface defects | | | | | | | | | | | | | | | | | | | | |
|  | | **Transportbehälternummer dokumentieren:**  Document the transport container ID: | | | | |  | | | | |  | | | | | | | |  | | |
|  | | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | |  | | | | |  | | | | | | | |  | | |
|  | | **Beurteilung der Bauteile:**  Part evaluation: | | | | | **i.O**  passed | X | | | | **n.i.O**  failed | | | X | | | | |  | | |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | | | | Uhrzeit | | |
|  | |  |  | | | | | | | | | | | | | | | | | | | |
| **[Q]** | | **Endkontrolle Sichtprüfung / EMPB erstellen** Final visual Inspection / Write FAIR | | | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | | | | | | |
| 100 | | Externe Anweisung: **ASQ Z1.4 Level 2, DIN9102**  External procedure: | | | | | Interne Anweisung: **VD-A109, VD-A443**  Internal procedure: | | | | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | | | Uhrzeit | | |
|  | | Prüfgegenstand:  Test specimen: | | | | | **Bauteil**  Part | | | | | | | | | | | | | | | |
|  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | | | | | | | |
|  | | Keine Fehler wie: Kratzer, Narben, Blasen, Streifen, Vertiefungen, Fremdkörper, Partikelanhäufungen, Inhomogenitäten oder sonstige Oberflächenfehler  No failures like: Scratches, scars, blisters, stripes, indentations, foreign bodies, particle clusters, inhomogeneities or other surface defects | | | | | | | | | | | | | | | | | | | | |
|  | | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | |  | | | | |  | | | | | | | |  | | |
|  | | **Beurteilung der Bauteile:**  Part evaluation: | | | | | **i.O**  passed | | X | | | **n.i.O**  failed | | | | | X | | |  | | |
|  | | **EMPB notwendig?**  FAIR necessary? | | | | | **Ja**  Yes | | X | | | **Nein**  No | | | | | X | | |  | | |
|  | | **EMPB Dokumentation erstellt?**  FAIR documentation created? | | | | | **Ja**  Yes | | X | | | **Nein**  No | | | | | X | | |  | | |
|  | |  | | | | |  | |  | | |  | | | | |  | | |  | | |
| **[Q]** | | **Endkontrolle Schichtdicke** Final control thicknes | | | | | | | | | | | | | | | | | | | | |
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| 105 | | Externe Anweisung: **NASM 1312-12**  External procedure: | | | | Interne Anweisung: **VD-A410, ND-P63**  Internal procedure: | | | | | | | | | | | | | | | | |
|  | | Überprüfung der Schichtdickenergebnisse aus dem **ND-P63\_Prüfbericht fastener und Abstempeln.**  Checking the coating thickness results from the Test report fastener and stamp. | | | | | | | | | | | | | | | | | | | | |
|  | | **Beurteilung der Schichtdicke:**  Thicknes evaluation: | | | | **i.O**  passed | | X | | | **n.i.O**  failed | | | | | X | | |  | | |  |
|  | |  | | |  | | | | | | | | | | | | | | | | | |
|  | **[Q]** | **Schichthaftung** Final coating adhesion Inspection | | | | | | | | | | | | | | | | | | | | |  |
|  |  |  | | | | | | | | | | | | | | | | | | | | |
|  | 110 | Externe Anweisung: **NAS4006**  External procedure: | | | | | Interne Anweisung: **VD-A365**  Internal procedure: | | | | | | | | | | | | | | | |
|  |  | **Hinweis: Kalibrierten Timer benutzen!**  Note: Use a calibrated timer! | | | | | | | | | | | | | | | | | | | | |
|  |  | Prüfmethode:  Test method: | | | | | **Ritztest**  Scratch test | | | | | | | | | | | | | | | |
|  |  | Prüfgegenstand:  Test specimen: | | | | | **4 Bauteile**  4 Parts | | | | | | | | | | | | | | | |
|  |  | Betrachtung:  Examination: | | | | | **4x Vergrößerung**  4x magnification | | | | | | | | | | | | | | | |
|  |  | **Timer Nr. dokumentieren:**  Document timer no: | | | | |  | | | | | | |  | | | | | | |  | |
|  |  | Durchführung: Beschichtung mit einer scharfen Klinge bis zum Grundmaterial einritzen.  Es ist nur ein Schnitt pro Testteil vorzunehmen.  Procedure: Scratch coating with sharp edge. Cut must penetrate the coating down to substrate. Only one cut per test specimen. | | | | | | | | | | | | | | | | | | | | |
|  |  | Eine Trennung der Schicht vom Grundmaterial, Abschälung oder Blasenbildung ist nicht zulässig.  Separation of the layer from the base material, peeling or blistering is not permitted. | | | | | | | | | | | | | | | | | | | | |
|  |  | **Beurteilung der Testteile:**  Test specimen evaluation: | | | | | **i.O**  passed | | | X | | | **n.i.O**  failed | | | | | X | |  | | |
|  |  | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | | |  | | | | | | | Uhrzeit | | |
|  |  |  | |  | | | | | | | | | | | | | | | | | | |

| **[Q]** | | **Endkontrolle** Final inspection Shop paper control | | | | | | | | | | | | | | | | | | | Datum  Date | | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | |  | | | | | | | | | | | | | | | | | | |
| 115 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **--**  Internal procedure: | | | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | Uhrzeit | | | |
|  | | Der AP ist auf vollständig abgearbeitete Arbeitsgänge zu überprüfen.  Check shop paper for complete and correct flow down. | | | | | | | | | | | | | | | | | | |
|  | | Wurden die Kundendokumente ausgefüllt,  kopiert und beigelegt?  Have the customer documents been filled-out, copied and enclosed? | | | | | | | | **Ja**  Yes | | | | X | | **Nein**  No | | | X | |
|  | | Gibt es Anmerkungen, welche an den Bereich PPS weitergeleitet werden müssen?  Are there any remarks that need to be forwarded to the Production Planing department? | | | | | | | | **Ja**  Yes | | | | X | | **Nein**  No | | | X | |
|  | | Hinweis: Auffälligkeiten und nicht korrekt ausgefüllte Arbeitsschritte  bei der Endkontrolle der AP sind immer den Bereichsverantwortlichen mitzuteilen.  Note: Any anomalies and not correct flowed down worksteps must be reported to superior. | | | | | | | | | | | | | | | | | | |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | |  | | | | | | Uhrzeit | | | |
|  | |  | |  | | | | | | | | | | | | | | | | |
|  | **[WA]** | | **Verpacken** packing | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp | |
|  |  | |  | | | | | | | | | | | | | | | | | | |
|  | 120 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **VD-A428**  Internal procedure: | | | | | | | | | | | | | |
|  |  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | Uhrzeit | | | |
|  |  | | FU Und AP zusammenheften.  FU And AP Staple Together | | | | | | | | | | | | | | | | | | |
|  |  | | Originalverpackung verwenden.  Sofern diese nicht verwendet wird bitte Grund in Bemerkungsfeld eintragen.  Use original Packaging. If this is not used, please enter the reason in the comments field. | | | | | | | | | | | | | | | | | | |
|  |  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | Uhrzeit | | | |
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|  | **[WA]** | | **Versandbereitschaft herstellen** Prepare for disbatching | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp | |
|  |  | |  | | | | | | | | | | | | | | | | | | |
|  | 125 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **VD-P26**  Internal procedure: | | | | | | | | | | | | | |
|  |  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | Uhrzeit | | | |
|  |  | | Vollständigkeit der Papiere prüfen  Paperwork check | | | | |  | | | | | | | | | | | | | |
|  |  | | Ordnungsgemäße Verpackung der Bauteile kontrollieren  Check for correct packaging | | | | | | | | | | | | | | | | | | |
|  |  | | **Transportorganisation durch:**  Transport organization by: | | | | | **AC**  AC | X | | | | **Kunde**  Customer | | X | | |  | |  | |
|  |  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | Uhrzeit | | | |
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| **Bemerkungsfeld**  Comments section | | |
| --- | --- | --- |
| AG Nr.  Workstep number | Bemerkung  Comment | MA-Stempel  Employee stamp |
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**Revisionsliste der mitgeltenden Dokumente**

List of revisions of applicable documents

| **Dokumenten-Nr.:**  Document Number | **Revision**  Revision | **Internes / externes Dokument**  Internal / external Document |
| --- | --- | --- |
| DIN EN 9102 | 2016-12 | External |
| ANSI/ASQ Z1.4 | 2018-10 | External |
| NAS4006 | Rev. 7 | External |
| NASM 1312-12 | Rev. 5 | External |
| VD-A8 | Rev. 3 | Internal |
| VD-A20 | Rev. 4 | Internal |
| VD-A21 | Rev. 3 | Internal |
| VD-A42 | Rev. 1 | Internal |
| VD-A44 | Rev. 2 | Internal |
| VD-A109 | Rev. 6 | Internal |
| VD-A330 | Rev. 3 | Internal |
| VD-A365 | Rev. 5 | Internal |
| VD-A410 | Rev. 0 | Internal |
| VD-A421 | Rev. 7 | Internal |
| VD-A423 | Rev. 6 | Internal |
| VD-A428 | Rev. 3 | Internal |
| VD-A439 | Rev. 15 | Internal |
| VD-A443 | Rev. 3 | Internal |
| ND-P63 | Rev. 5 | Internal |
| ND-P83 | Rev. 4 | Internal |
| ND-B136 | Rev. 0 | Internal |
| VD-P26 | Rev. 1 | Internal |
| VD-P47 | Rev. 5 | Internal |
| VD-P48 | Rev. 2 | Internal |

