| **Bearbeitung:**  External Specification: | **prEN6118, Type 1, MIL-DTL-5541F Type I,** |
| --- | --- |

| Folgenden Anweisungen ist Folge zu leisten:  Follow Instructions below:   1. Vorsichtige Handhabung der Bauteile.   Carefull handling of parts.   1. Bauteile nur mit sauberen Latex/Nitril Handschuhen   gemäß ACAA113 handhaben.  Handle parts with clean Latex/Nitril gloves only. Follow instructions of ACAA113   1. Bei Abweichungen am Bauteil hinsichtlich Aussehen und Dimensionen ist die Abteilung PPS zu informieren.   In case of deviations on the component regarding to appearance and the dimensions, the IMS department must be informed. |
| --- |

| **Tab. 1:** Bauteil-Dimensionen  Tab. 1: Partpart dimensions | |  |  | **Fläche/Stück**  Surface/piece | **mm2** |
| --- | --- | --- | --- | --- | --- |
| **Bauteillänge**  Part length | **mm** | **Stückgewicht**  Piece weight | **g** | **Gesamtfläche**  Total surface | **m2** |
| Soll **Ø** gem. Zeichnung  Part acc. to drawing | | Stichprobe **vor** der Beschichtung  Sample before coating | | Sollmaß **nach** dem Beschichten  Nominal dimension after coating | |
|  | | WE-Min [mm] | WE-Max [mm] | **UGW** Min [mm] | **OGW** Max [mm] |
| **Ø MP1** (Schaft mittig)  (shank center) | |  |  |  |  |
| **Ø MP2** (10 mm über Gewinde)  (10 mm over thread) | |  |  |  |  |
| **Ø MP3** (5 mm unter dem Kopf)  (5 mm under the head) | |  |  |  |  |

|  | **[WE]** | | **Wareneingangskontrolle** Incoming goods inspection | | | | | | | | | | Nachweis siehe ACFB671  For evidence see ACFB671 | | |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | |  | |  | | | | | | | |
|  | 010 | | Externe Anweisung: **--**  External procedure: | | Interne Anweisung: **ACPB37**  Internal procedure: | | | | | | | |
|  |  | |  | |  | | | | | | | |
|  | **[Q]** | | **Qualitätssicherung Eingang**  Incoming quality assurance | | | | | | | | | | Datum  Date | | MA-Stempel  Employee stamp |
|  |  | |  | | | | | | | | | |
|  | 015 | | Externe Anweisung: **prEN6118**  External procedure: | | Interne Anweisung: **ACAA130**  Internal procedure: | | | | | | | |
|  |  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | |  | | | |  | | | Uhrzeit |
|  |  | | Punkte QS ausfüllen  Fill out items QS | | **ACFB671** | | | | | | | |
|  | Kontrolle der Bauteile auf Beschädigung  Inspection for damages | | | | | | | | | |
|  | Durchmesserprüfung der Bauteile (Sinic)  Diameter inspection of parts (Sinic) | | **ACAA130** | | | | | | | |
|  | **AC Nummer Prüfmittel:**  AC number of Test equipment: | | **Bitte auf FU notieren**  Please note on FU | | | | | | | |
|  | **Beurteilung der Bauteile:**  Part evaluation: | | **i.O**  passed | | X | | **n.i.O**  failed | | X |  |
|  |  | | **Messwerte in Tab. 1 übernehmen**  Transfer measured values to Table 1 | |  | | | | | | | |
|  |  | | **Uhrzeit Ende AG:**  End of workstep: | |  | | | |  | | | Uhrzeit |
|  |  | |  | |  | | | | | | | |
| **[P]** | | **Alkalische Ultraschallentfettung** Ultra sonic alkaline degreasing | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | |
| 020 | | Externe Anweisung: **prEN6118**  External procedure: | | Interne Anweisung: **ACPB35**  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: | | |  | | |  | | | |  | |
| **Fahrtennummer:**  Production number: | | |  | | |  | | | |  | |
| **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: **ACAA136**  Internal procedure: | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | |  | | | | | | | Uhrzeit |
|  | | Die Bauteile mit VE-Wasser benetzen.  Moisten the parts with demineralised water. | | | | | **≥ 30 sec** | | | | | | | | | | | |
| Prüfmittel:  Test equipment: | | | | | **Auge**  Eye | | | | | | | | | | | |
| **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 repeatc degreasing | | | | | | | | | | | | | | | | |
|  | |  | | | |  | | | | | | | | | | | | |
| **[P]** | | **Drucklufttrocknen** Drying with compressed air | | | | | | | | | | | | | | | | |
|  | |  | | | | | | | | | | | | | | | | |
| 030 | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **ACAA9**  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: **ACPB39**  Internal procedure: | | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | | | |  | | | | | | Uhrzeit |
|  | | Zulässiger Ofen:  Permitted oven: | | | | | **O 3, O 6, O 8** | | | | | | | | | | | |
|  | | Empfohlene Trocknungsdauer:  Recommended drying time: | | | | | **≥ 20 min** | | | | | | | | | | | |
|  | | Maximal zulässige Temperatur:  Maximum Permissible temperature: | | | | | **100 ± 5 °C** | | | | | | | | | | | |
|  | | **Verwendeter Ofen:**  Used oven: | | | | |  | | | | |  | | | | | |  |
|  | | **Fahrtennummer:**  Production number: | | | | |  | | | | |  | | | | | |  |
|  | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | |  | | | | | | Uhrzeit |
|  | |  | | |  | | | | | | | | | | | | | |
| **[P]** | | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | | |
| 040 | | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | Interne Anweisung: **ACAA29**  Internal procedure: | | | | | | | | | | |
|  | | Prüfgegenstand:  Test specimen: | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | |  | | | |  | | | | | | Uhrzeit |
|  | | Bauteil auf Beschädigungen und vollständige Trocknung prüfen.  Check part for damage and complete drying. | | | | | | | | | | | | | | | |  |
| **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: **prEN6118**  External procedure: | | | | | | | Interne Anweisung: **ACAA9, ACPB28**  Internal procedure: | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit | |
|  | **Geprüfter Druckluftentnahmepunkt (DLEP):**  Tested compressed air extraction point: | | | | | | |  | | | | |  | | | |  | |
|  | Zulässige Strahlanlage:  Permitted blasting equipment: | | | | | | | **EK 4, EK 5 , EK 6** | | | | | | | | | | |
|  | Zulässiges Strahlmittel:  Permitted blasting media: | | | | | | | **F120** | | | | | | | | | | |
|  | Zulässiger Druck:  Permitted pressure: | | | | | | | **4,5 – 5,5 bar** | | | | | | | | | | |
|  | Abstand Düse-Bauteil:  Distance nozzle part: | | | | | | | **20 ± 10 cm** | | | | | | | | | | |
|  | **Verwendete Anlage:**  Used equipments: | | | | | | |  | | | | |  | | | |  | |
|  | **Fahrtennummer:**  Equipment job number: | | | | | | |  | | | | |  | | | |  | |
|  |  | |  | | | | | | | | | | | | | | | |
| **[P]** | **Druckluftreinigen** Cleaning with compressed air | | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | |
| 050 | Externe Anweisung: **--**  External procedure: | | | | | | | Interne Anweisung: **ACAA9, ACAA254**  Internal procedure: | | | | | | | | | | |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | | |  | | | | |  | | | | Uhrzeit | |
|  |  | | |  | | | | | | | | | | | | | | |

| **[P]** | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | | | | | | | | | | | |
| 055 | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | Interne Anweisung: **ACAA29**  Internal procedure: | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | |  | |  | | | Uhrzeit |
|  | Prüfgegenstand:  Test specimen: | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | |
|  | 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 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]** | **IVD-Al-Beschichtung** IVD-Al coating | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | |
| 060 | Externe Anweisung: **prEN6118**  External procedure: | | | | | | Interne Anweisung: **ACPB15**  Internal procedure: | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | |  | |  | | | Uhrzeit |
|  | **Zulässige Anlagen:**  Permitted systems: | | | | | | **IVD 1, IVD 3, IVD 4** | | | | | |
|  | **Verwendete IVD-Anlage:**  Used IVD equipment: | | | | | |  | |  | | |  |
|  | **Fahrtennummer:**  Paint preparation number: | | | | | |  | |  | | |  |
|  | **Uhrzeit Ende AG:**  End of workstep: | | | | | |  | |  | | | Uhrzeit |
|  |  | | |  | | | | | | | | |
| **[P]** | **Entnahme** Part withdrawl | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | |
| 065 | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **ACPB15**  Internal procedure: | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | |  | | |  | | | Uhrzeit |
|  | **Transportbehälternummer dokumentieren:**  Document the transport container ID: | | | | |  | | |  | | |  |
|  |  | |  | | | | | | | | | |
| **[P]** | | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | |
|  | |  | | | | | | | | | | |
| 070 | | Externe Anweisung: **--**  External procedure: | | | | Interne Anweisung: **ACAA29**  Internal procedure: | | | | | | |
|  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen. Minimale Kontaktstellen von Bauteilaufnahmen sind zulässig sofern die Beschichtung geschlossen ist.  Parts shall have a uniform coating without any flaws. Contact points caused by jigs are permissible as long as the coating layer is closed. | | | | | | | | | | |
|  | | Überprüfung der Sollschichtdicke  Checking the nominal layer thickness | | | |  | | |  | | |  |
|  | | **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]** | **Glaskugelstrahlen der Prüfteile** Glass bead peening of test parts | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | | | | | | | | | | | | | | | | |
| 075 | Externe Anweisung: **--**  External procedure: | | Interne Anweisung: **ACAA9, ACPB38**  Internal procedure: | | | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | |  | | | | |  | | | | | Uhrzeit | | | | |
|  | Prüfgegenstand:  Test specimen: | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | | | | | | |
|  | **Geprüfter Druckluftentnahmepunkt (DLEP):**  Tested compressed air extraction point: | |  | | | |  | | | | | |  | | | | |
|  | Zulässige Strahlanlage:  Permitted blasting equipment: | | **GP 3** | | | | | | | | | | | | | | |
|  | Zulässiger Druck:  Permitted pressure: | | **0,8 – 1,2 bar** | | | | | | | | | | | | | | |
|  | **Fahrtennummer:**  Equipment job number: | |  | | | | |  | | | | |  | | | | |
|  |  |  | | | | | | | | | | | | | | | |
| **[P]** | **Zwischenkontrolle Durchmesser** Intermediate control diameter | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | |
| 080 | Externe Anweisung: **NASM 1312-12**  External procedure: | | Interne Anweisung: **ACAA130, ACFB709**  Internal procedure: | | | | | | | | | | | | | | |
|  | Prüfmethode:  Test method: | | **Mikrometerschraube**  Micrometer screw | | | | | | | | | | | | | | |
|  | Prüfgegenstand:  Test specimen: | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | | | | | | |
|  | **AC Nummer Prüfmittel:**  AC number of Test equipment: | |  | | | | |  | | | | |  | | | | |
|  | **Prüfbericht erstellen unter Vorlage ”ACFB709\_Prüfbericht fastener“ und speichern.**  Create test report under template "ACFB709\_Test report faster" and save. | | | | | | | | | | | | | | | | |
|  | Die Bauteile messen und im Entschichtungskorb ablegen.  Measure the parts and place them in the decoating basket. | | | | | | | | | | | | | | | | |
|  | Beschichtung der Teile vollständig entfernen. **Reihenfolge der Teile nicht ändern!**  Completely remove the coating of the part. Do not change the order of the test parts! | | | | | | | | | | | | | | | | |
|  | Teile 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. | | | | | | | | | | | | | | | | |
|  | **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]** | **Zwischenkontrolle Durchmesser** Intermediate check diameter | | | | | | | | | | | | | | | | Datum  Date | | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | |
| 085 | Externe Anweisung: **--**  External procedure: | | | Interne Anweisung: **ACAA130**  Internal procedure: | | | | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of workstep: | | |  | | | |  | | | | | Uhrzeit | | | |
|  | Prüfmethode:  Test method: | | | **Mikrometerschraube**  Micrometer screw | | | | | | | | | | | | |
|  | Prüfgegenstand:  Test specimen: | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | | | | |
|  | **AC Nummer Prüfmittel:**  AC number of Test equipment: | | |  | | | | |  | | | | |  | | |
|  | Temperatur der Bauteile:  Temperature of parts: | | | **RT** | | | | | | | | | | | | |
|  | Mindestens 3 Messungen je Bauteil  Minimum of 3 measurements per part | | | **BT** | **MP1** | | | | | **MP2** | | | | | **MP3** | |
|  | Nach jeder Messung das Bauteil um 120° drehen. | | | 1 |  | | | | |  | | | | |  | |
|  | Turn the part 120° after each measurement  Messwerte **(mm)** in der Tabelle dokumentieren.  Document measured values in the table. | | | 2 |  | | | | |  | | | | |  | |
|  |  | | | 3 |  | | | | |  | | | | |  | |
|  |  | | | 4 |  | | | | |  | | | | |  | |
|  |  | | | 5 |  | | | | |  | | | | |  | |
|  | **Beurteilung der Bauteile nach Tab. 1:**  Part evaluation according to Table1: | | | **i.O**  passed | X | | | | **n.i.O**  failed | | X | | |  | | |
|  | **Uhrzeit Ende AG:**  End of workstep: | | |  |  | | | |  | |  | | | Uhrzeit | | |
|  |  | | |  | | | | | | | | | | | | |

|  | **[P]** | | | **Glaskugelstrahlen** Glass bead peening | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  | | |  | | | | | | | | | | | | | |
|  | 090 | | | Externe Anweisung: **--**  External procedure: | | | | | | Interne Anweisung: **ACAA9, ACPB38**  Internal procedure: | | | | | | | |
|  |  | | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | |  | | | |  | | | Uhrzeit |
|  |  | | | **Geprüfter Druckluftentnahmepunkt (DLEP):**  Tested compressed air extraction point: | | | | | |  | | | |  | | |  |
|  |  | | | Zulässige Strahlanlage:  Permitted blasting equipment: | | | | | | **GP 1** | | | | | | | |
|  |  | | | Zulässiger Druck:  Permitted pressure: | | | | | | **0,8 – 1,2 bar** | | | | | | | |
|  |  | | | **Fahrtennummer:**  Equipment job number: | | | | | |  | | | |  | | |  |
|  |  | | | **Offenzeit:** Glaskugelstrahlen - Passivierung  Open time: glass bead peening - passivation | | | | | | **≤ 24 h** | | | | | | | |
|  |  | | |  | | | |  | | | | | | | | | |
|  | **[P]** | | **Druckluftreinigen** Cleaning with compressed air | | | | | | | | | | | | | | |
|  |  | |  | | | | | | | | | | | | | | |
|  | 095 | | Externe Anweisung: **--**  External procedure: | | | | | | | Interne Anweisung: **ACAA9, ACAA254**  Internal procedure: | | | | | | | |
|  |  | |  | | | |  | | | | | | | | | | |
|  | **[P]** | | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | |
|  |  | |  | | | | | | | | | | | | | | |
|  | 100 | | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | | | Interne Anweisung: **ACAA29**  Internal procedure: | | | | | | |
|  |  | | Prüfgegenstand:  Test specimen: | | | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | |
|  |  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | |
|  |  | | **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]** | | **Passivieren** Passivation | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | |
| 105 | | Externe Anweisung: **MIL-DTL-5541**  External procedure: | | | | | | | Interne Anweisung: **ACPB15**  Internal procedure: | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | Uhrzeit |
|  | | **Offenzeit:** Glaskugelstrahlen - Passivierung  Open time: glass bead peening - passivation | | | | | | | **≤ 24 h** | | | | | | | | |
|  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | | |
|  | | Farbe:  Colour: | | | | | | | | **Hellgelb bis Goldgelb**  Light yellow to golden yellow | | | | | | | |
|  | | Zulässiges Behandlungsbad:  Permitted treatment bath: | | | | | | | | **1.1, 1.2, 1.3** | | | | | | | |
|  | | Zulässige Temperatur Bad 1.1:  Permissible temperature Bath 1.1: | | | | | | | | **21 – 38°C** | | | | | | | |
|  | | Tauchzeit Bad 1.1:  Immersion time bath 1.1: | | | | | | | | **15 – 75 s** | | | | | | | |
|  | | Spülzeit 1.2:  Rinse time 1.2: | | | | | | | | **15 – 75 s** | | | | | | | |
|  | | Spülzeit 1.3:  Rinse time 1.3: | | | | | | | | **15 – 75 s** | | | | | | | |
|  | | Dauer Spritzspülen:  Duration of spray rinsing: | | | | | | | | **15 – 75 s** | | | | | | | |
|  | | **Tauchzeit Bad 1.1:**  Immersion time bath 1.1: | | | | | | | |  | | | |  | |  | |
|  | | **Spülzeit 1.2:**  Rinse time 1.2: | | | | | | | |  | | | |  | |  | |
|  | | **Spülzeit 1.3:**  Rinse time 1.3: | | | | | | | |  | | | |  | |  | |
|  | | **Dauer Spritzspülen:**  Duration of spray rinsing: | | | | | | | |  | | | |  | |  | |
|  | | **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 |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | | |  | | | | | | | | | | | | | | | |
| 110 | | | Externe Anweisung: **--**  External procedure: | | | | | Interne Anweisung: **ACPB39**  Internal procedure: | | | | | | | | | | |
|  | | | **Uhrzeit Beginn AG:**  Beginning of  workstep: | | | | |  | | | | | |  | | | Uhrzeit | |
|  | | | Farbe:  Colour: | | | | | **Hellgelb bis Goldgelb**  Light yellow to golden yellow | | | | | | | | | | |
|  | | | **Verwendete Anlage:**  Used equipments: | | | | | **Zentrifuge**  Centrifuge | | | | | X | | **Ofen**  Oven | | | X |
|  | | | **Bauteile < 12 mm Ø in der Zentrifuge**  Parts up to 12 mm Ø in the centrifuge | | | | |  | | | | | | | | | | |
|  | | | Zulässige Zentrifuge:  Permissible centrifuge: | | | | | **Z 1, Z 2** | | | | | | | | | | |
|  | | | Zulässige Reglereinstellung:  Permissible controller setting: | | | | | **< 40 °C** | | | | | | | | | | |
|  | | | **Hinweis:** Zulässige Trocknungstemperatur unter 60 °C  Note: Permissible drying temperature below 60 °C | | | | | | | | | | | | | | | |
|  | | | Empfohlenen Trocknungsdauer:  Recommended drying time: | | | | | **5 – 8 min** | | | | | | | | | | |
|  | | | **Bauteile ≥ 12 mm Ø im Ofen**  Parts ≥12 mm Ø in the oven | | | | |  | | | | | | | | | | |
|  | | | Zulässiger Ofen:  Permitted oven: | | | | | **O 3, O5** | | | | | | | | | | |
|  | | | Empfohlene Trocknungsdauer:  Recommended drying time: | | | | | **≥ 20 min** | | | | | | | | | | |
|  | | | Zulässige Temperatur:  Permissible temperature: | | | | | **45 ±5 °C** | | | | | | | | | | |
|  | | | **Fahrtennummer:**  Equipment job number: | | | | |  | | | | | |  | | |  | |
|  | | | **Uhrzeit Ende AG:**  End of workstep: | | | | |  | | | | | |  | | | Uhrzeit | |
|  | | |  | | |  | | | | | | | | | | | | |
| **[P]** | **Werkerselbstkontrolle** Worker self check | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  |  | | | | | | | | | | | | | | | | | |
| 115 | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | | | Interne Anweisung: **ACAA29**  Internal procedure: | | | | | | | | | |
|  | **Uhrzeit Beginn AG:**  Beginning of  workstep: | | | | | | | |  | | | | |  | | | Uhrzeit | |
|  | Prüfgegenstand:  Test specimen: | | | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | |
|  | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | | | | |
|  | Farbe:  Color: | | | | | | | | **Hellgelb bis Goldgelb**  Light yellow to golden yellow | | | | | | | |  | |
|  | **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 | |
|  |  | | |  | | | | | | | | | | | | | | |
| **[Q]** | | **Endkontrolle Sichtprüfung / FAIR erstellen** Final visual Inspection / Write FAIR | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
|  | |  | | | | | | | | | | | | | | | | |
| 120 | | Externe Anweisung: **prEN6118, DIN 9102**  External procedure: | | | | | | | Interne Anweisung:  **ACAA74, ACPB25**  Internal procedure: | | | | | | | | | |
|  | | **Uhrzeit Beginn AG:**  Beginning of workstep: | | | | | | |  | | | | |  | | | Uhrzeit | |
|  | | Prüfgegenstand:  Test specimen: | | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | |
|  | | Bauteile müssen eine gleichmäßige Beschichtung ohne Fehlstellen aufweisen.  Parts must have uniform appearance without any flaws. | | | | | | | | | | | | | | | | |
|  | | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | | | |  | | | | |  | | |  | |
|  | | **Beurteilung der Bauteile:**  Part evaluation: | | | | | | | **i.O**  passed | | | X | | **n.i.O**  failed | | X |  | |
|  | | **FAIR notwendig?**  FAIR necessary? | | | | | | | **Ja**  Yes | | | X | | **Nein**  No | | X |  | |
|  | | **FAIR Dokumentation erstellt?**  FAIR documentation created? | | | | | | | **Ja**  Yes | | | X | | **Nein**  No | | X |  | |
|  | |  | | |  | | | | | | | | | | | | | |
| **[Q]** | **Endkontrolle Durchmesser** Final diameter control | | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | |
| 125 | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | | | | Interne Anweisung: **ACAA130**  Internal procedure: | | | | | | | | |
|  | Prüfmethode:  Test method: | | | | | | | | | **Mikrometerschraube**  Micrometer screw | | | | | | | | |
|  | Prüfgegenstand:  Test item: | | | | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | |
|  | Temperatur der Bauteile:  Temperature of parts: | | | | | | | | | **RT** | | | | | | | | |
|  | Durchmesserprüfung am Bauteil (Sinic)  Diameter inspection on parts (Sinic) | | | | | | | | |  | | | | | | | | |
|  | **AC Nummer Prüfmittel:**  AC number of Test equipment: | | | | | | | | |  | | | |  | | |  | |
|  | **Anzahl geprüfter Bauteile:**  Amount of parts checked: | | | | | | | | |  | | | |  | | |  | |
|  | **Beurteilung der Bauteile:**  Part evaluation: | | | | | | | | | **i.O**  passed | X | | | **n.i.O**  failed | | X |  | |
|  |  | | | | | |  | | | | | | | | | | | |

| **[Q]** | | **Endkontrolle Schichtdicke** Final control thicknes | | | | | | | | | | | | | | | | | | | | | | | | | | | Datum  Date | MA-Stempel  Employee stamp |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
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| 130 | | Externe Anweisung: **prEN6118 (Annex E)**  External procedure: | | | | | | | | | Interne Anweisung: **ACFB709**  Internal procedure: | | | | | | | | | | | | | | | | | |
|  | | Überprüfung der Schichtdickenergebnisse aus dem Prüfbericht nach **ACFB709.**  Checking the coating thickness results from the test report according to ACFB709 | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | **Beurteilung der Schichtdicke:**  Thicknes evaluation: | | | | | | | | | **i.O**  passed | X | | | | | **n.i.O**  failed | | | X | | | | |  | | | |
|  | |  | | | | | |  | | | | | | | | | | | | | | | | | | | | |
| **[Q]** | | **Endkontrolle Schichthaftung** Final coating adhesion Inspection | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | |  | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 135 | | Externe Anweisung: **--**  External procedure: | | | | | | | | | Interne Anweisung: **ACAA58, Waiver7**  Internal procedure: | | | | | | | | | | | | | | | | | |
|  | | Prüfmethode:  Test method: | | | | | | | | | **Ritztest**  Scratchtest | | | | | | | | | | | | | | | | | |
|  | | Prüfgegenstand:  Test item: | | | | | | | | | **5 Bauteile (BT)**  5 Parts (BT) | | | | | | | | | | | | | | | | | |
|  | | Betrachtung:  Examination: | | | | | | | | | **mit 4x Vergrößerung**  with 4x magnification | | | | | | | | | | | | | | | | | |
|  | | Durchführung: Beschichtung mit einer scharfen Klinge bis zum Grundmaterial einritzen.  Es ist nur ein Schnitt pro Bauteill vorzunehmen.  Procedure: Scratch coating with sharp edge. Cut must penetrate the coating down to substrate. Only one cut per part. | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | Eine Trennung der Schicht vom Grundmaterial, Abschälung oder Blasenbildung sind nicht zulässig.  ppearance of coating from substrate, peeling or blistering are not permissible. | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | **Beurteilung der Bauteile:**  Part evaluation: | | | | | | | | | **i.O**  passed | | X | | | | **n.i.O**  failed | | | X | | | | |  | | | |
|  | |  | | |  | | | | | | | | | | | | | | | | | | | | | | | |
| **[Q]** | | **Endkontrolle** Final inspection Shop paper control | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | |  | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 140 | | Externe Anweisung: **--**  External procedure: | | | | | | | | | Interne Anweisung: **--**  Internal procedure: | | | | | | | | | | | | | | | | | |
|  | | 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 vom 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** Packaging | | | | | | | | | | | | | | | | | | | | | | | | | Datum  Date | | MA-Stempel  Employee stamp | |
|  |  | |  | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 145 | | Externe Anweisung: **--**  External procedure: | | | | | | | | Interne Anweisung: **ACAA155**  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 Kommentarfeld eintragen.  Use original Packaging. If other packaging is used describe the reason in comment section. | | | | | | | | | | | | | | | | | | | | | | | | |
|  |  | | **Uhrzeit Ende AG:**  End of workstep: | | | | | | | |  | | | | | |  | | | | | | | Uhrzeit | | | |
|  |  | |  | | |  | | | | | | | | | | | | | | | | | | | | | |
|  | **[WA]** | | **Transportorgansiation** Dispatch Preparation | | | | | | | | | | | | | | | | | | | | | | | | | Datum  Date | | MA-Stempel  Employee stamp | |
|  |  | |  | | | | | | | | | | | | | | | | | | | | | | | | |
|  | 150 | | Externe Anweisung: **--**  External procedure: | | | | | | | | Interne Anweisung: **ACPB37**  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 | | | |
|  |  | |  | | | |  | | | | | | | | | | | | | | | | | | | | |

| **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 |
| perEN6118 | 2016-11 | External |
| MIL-DTL-5541 | Rev. F | External |
| NASM-1312-12 | Rev. 5 | External |
| Waiver 7 | Rev. 0 | Internal |
| ACAA9 | Rev. 1 | Internal |
| ACAA29 | Rev. 2 | Internal |
| AAA58 | Rev. 3 | Internal |
| ACAA74 | Rev. 5 | Internal |
| ACAA113 | Rev. 1 | Internal |
| ACAA130 | Rev. 6 | Internal |
| ACAA136 | Rev. 3 | Internal |
| ACAA155 | Rev. 1 | Internal |
| ACAA254 | Rev. 0 | Internal |
| ACFB671 | Rev. 3 | Internal |
| ACFB709 | Rev. 3 | Internal |
| ACPB15 | Rev. 10 | Internal |
| ACPB25 | Rev. 2 | Internal |
| ACPB28 | Rev. 5 | Internal |
| ACPB35 | Rev. 4 | Internal |
| ACPB37 | Rev. 0 | Internal |
| ACPB38 | Rev. 2 | Internal |
| ACPB39 | Rev. 1 | Internal |