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| A 1 | A. Does supplier have procedures for Teflon Coating?List procedures:List Contract requirements | \_\_\_Yes \_\_\_No |
|  | B. Do procedures meet environmental laws? |  |
|  | C. How does supplier ensure compliance to local Environmental laws? | \_\_\_Yes \_\_\_No |
| Coating Spray Area  | \_\_\_Yes \_\_\_No |
| A 2 | 1. Supplier’s Teflon Coating Spray Area enclosed or isolated?
 | \_\_\_Yes \_\_\_No |
|  | B. Supplier’s Teflon Coating Spray Area exhausted?How? | \_\_\_Yes \_\_\_No |

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|  | C. Are adequate controls in place to protect from contamination? | \_\_\_Yes \_\_\_No |
|  | D. Are adequate controls in place for Temperature, Humidity, and sources of contamination? | \_\_\_Yes \_\_\_No |
| B | E. Adequate safety precautions established?(i.e., respirators, no smoking, no eating, washing of hands) | \_\_\_Yes \_\_\_No |
|  | F. Air supply for spray gun checked for moisture, oil, and hydrocarbons? | \_\_\_Yes \_\_\_No |
|  | G. Spray gun checked for cleanliness prior to use? | \_\_\_Yes \_\_\_No |
|  | H. Written Procedures for cleaning spray gun?Method used: | \_\_\_Yes \_\_\_No |
| B 2 | J. What is the method to transport balls to spray area? |  |

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| B 2 | K. What is the method to handle balls during transport? |  |
|  | L. Are balls protected from contamination?How? | \_\_\_Yes \_\_\_No |
| Primer and Final Coat Material |  |
| A 3 | A. Are receipt inspections performed on Teflon coating material?List inspections performed:List primer used:List final coat used: | \_\_\_Yes \_\_\_No |
|  | B. Are inspections performed on primer and final prior touse?(Temperature, shelf life, separation)List others: | \_\_\_Yes \_\_\_No |

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|  | C. Are inspections documented? Batch Numbers recorded? | \_\_\_Yes \_\_\_No |
|  | D. Primer and final coat strained prior to use?List methods: | \_\_\_Yes \_\_\_No |
|  | E. Storage requirements addressed?List method? | \_\_\_Yes \_\_\_No |
| Ovens |  |
| A 4 | 1. Type of Curing oven?

 |  |
|  | 1. Type of oxidizing oven?

 |  |
|  | C. Written procedures for calibrating ovens?Method:Intervals:Last calibration date: | \_\_\_Yes \_\_\_No |
|  | D. Are ovens exhausted?Method: | \_\_\_Yes \_\_\_No |
| Inspection and Prep of balls for Teflon coating (Ball repair only) |  |
| A5 | A. Procedure for cleaning balls in the as-received condition?List: | \_\_\_Yes \_\_\_No |
| A 5 | B. Document acceptance procedure to determine acceptance for repair? | \_\_\_Yes \_\_\_No |
|  | C. Are dimensions verified? | \_\_\_Yes \_\_\_No |
|  | D. Surface condition inspected? | \_\_\_Yes \_\_\_No |

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|  | E. Generic tests performed to identify material? | \_\_\_Yes \_\_\_No |
|  | F. Results of inspections documented? | \_\_\_Yes \_\_\_No |
|  | G. Welding repair performed?List procedures: | \_\_\_Yes \_\_\_No |
|  | H. Additional Machining required to clean ball?List operations:List cutting fluids:List method for obtaining 16 RHR finish (prior to oxidizing): | \_\_\_Yes \_\_\_No |
|  | J. Cutting fluids or lubricant source of oil or hydrocarbons? | \_\_\_Yes \_\_\_No |

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|  | K. Is ball inspected after machining or welding (dimensions porosity, surface finish) and documented?List others: | \_\_\_Yes \_\_\_No |
| Cleaning after final machining/welding |  |
| A 6 | A. Are solvents used to clean balls?List solvents used: | \_\_\_Yes \_\_\_No |
|  | B. Solvents used a source of hydrocarbons?(If yes, note for question 6E.) | \_\_\_Yes \_\_\_No |
|  | C. Ball dried before final cleaning?List procedure: | \_\_\_Yes \_\_\_No |
|  | 1. Ball protected from contamination during drying?
 | \_\_\_Yes \_\_\_No |
|  | 1. Ball inspected for residual oils/hydrocarbons after cleaning/drying?
 | \_\_\_Yes \_\_\_No |
| Oxidizing of Ball Surfaces  |  |
| A 7 | 1. Specified time between drying and Oxidizing?
 | \_\_\_Yes \_\_\_No |

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|  | 1. Specified temperature for Oxidizing?
 | \_\_\_Yes \_\_\_No |
|  | C. Specified method to verify Oxidation? | \_\_\_Yes \_\_\_No |
|  | D. Specified method to cool ball? | \_\_\_Yes \_\_\_No |
|  | E. Ball protected from contamination during cooling? | \_\_\_Yes \_\_\_No |
| Final Surface Preparation prior to Teflon coating |  |
| A 8 | A. List elapsed time between oxidation and final surface preparation: |  |
|  | B. Method use to obtain 32 RHR surface preparation (After Oxidizing): |  |
|  | C. Method use for grit blasting: |  |
|  | D. Does grit blasting remove the oxide coating? | \_\_\_Yes \_\_\_No |
|  | E. Grit blasting equipment checked for sources of moisture, oil or hydrocarbons? | \_\_\_Yes \_\_\_No |
|  | F. Method used to clean ball after grit blasting:List any solvents: |  |
|  | G. Method use to dry ball after cleaning: |  |
|  | H. Ball inspected for residual oils/hydrocarbons after cleaning and drying?Before After | \_\_\_Yes \_\_\_No |
|  | J. Ball inspected for dimensions, before or after cleaning? | \_\_\_Before \_\_\_After |
|  | K. Ball inspected for porosity, before or after cleaning? | \_\_\_Yes \_\_\_No |
|  | L. Ball inspected for surface finish, before or after cleaning? | \_\_\_Yes \_\_\_No |
|  | M. Ball inspected for other inspections, before/after cleaning?List inspections: | \_\_\_Yes \_\_\_No |

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|  | N. Inspections documented? | \_\_\_Yes \_\_\_No |
|  | O. How is ball handled and protected from contamination during inspection, cleaning and drying:Procedure used for applying prime coating |  |
| A 9 | A. Elapsed time between final surface preparation and application of primer coat: |  |
|  | B. Number of final coats: |  |
|  | C. Thickness of coats: |  |
|  | D. Elapsed time between coats: |  |
|  | E. Inspection for continuous and discontinuous coat | \_\_\_Yes \_\_\_No |
|  | F. Method of drying primer coat: |  |
|  | G. Method used to protect material from contamination during drying: |  |
|  | H. Is spray gun cleaned after primer coat?  | \_\_\_Yes \_\_\_No |
| Fusing/curing of primer coat |  |
| A 10 | A. Elapsed time between spray coating and curing: |  |
|  | B. Is material protected from contamination in transporting to ovens? | \_\_\_Yes \_\_\_No |
|  | C. Oven temperature settings: |  |
|  | D. Method used to determine when primer is cured: |  |
|  | E. Temperatures and times in oven recorded? | \_\_\_Yes \_\_\_No |
|  | F. Method used to cool ball after curing: |  |
|  | G. Ball cleaned after cooling? | \_\_\_Yes \_\_\_No |
|  | H. Primer coat inspected after cooling (Visual, Thickness, Adhesion, or other) | \_\_\_Yes \_\_\_No |
|  | J. Inspections documented? | \_\_\_Yes \_\_\_No |
|  | K. Material protected from contamination while staging for final Teflon coating?Procedure used for applying final Teflon coating | \_\_\_Yes \_\_\_No |
| A 11 | A. Elapsed time between primer and final application: |  |
|  | B. Number of final coats: |  |
|  | 1. Thickness of coats:
 |  |
|  | D. Elapsed time between coats: |  |
|  | E. Inspection for proper final coat application? | \_\_\_Yes \_\_\_No |
|  | F. Method of drying final coat: |  |

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|  | G. Method used to protect material from contamination during drying: |  |
|  | H. Is spray gun cleaned after final Teflon coat?Fusing/curing of final Teflon coat | \_\_\_Yes \_\_\_No |
| A 12 | A. Elapsed time between spray coating and curing: |  |
|  | B. Is material protected from contamination in transporting to ovens? | \_\_\_Yes \_\_\_No |
|  | C. Oven temperature settings: |  |
|  | D. Method used to determine when final Teflon is cured: |  |
|  | E. Temperatures and times in oven recorded? | \_\_\_Yes \_\_\_No |
|  | F. Method used to cool ball after curing: |  |
|  | G. Ball cleaned after cooling? | \_\_\_Yes \_\_\_No |

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|  | H. Final coat inspected after cooling (Visual, Thickness, Adhesion, or other) | \_\_\_Yes \_\_\_No |
|  | J. Inspections documented (i.e., adhesion test)? | \_\_\_Yes \_\_\_No |
|  | K. Explain how final Teflon coating inspections are documented. |  |

Additional Comments/Concerns: