

NAV19 – FLAME SPRAYING (ISO 4.9)

A 1.	Identify the drawing, specification or document invokes the requirements for flame spraying:	___ Yes ___ No ___ N/A
A 2	a. Does a written detailed procedure exist and is it utilized for the flame spraying process?	___ Yes ___ No ___ N/A
	b. Are procedures readily available?	___ Yes ___ No ___ N/A
A 3.	Is the procedure approved by the Customer? List Procedure and Reference Approval Number, if applicable:	___ Yes ___ No ___ N/A
A 4.	Are procedures/work instructions adequate for control of:	
	a. (Proper Equipment) Guns, Filters Regulators, Flow meters, Wire Feed Control, etc.	___ Sat ___ Unsat
	b. (Proper Materials) Gases, Wire, etc.	___ Sat ___ Unsat
	c. Temperature monitoring - preheat, spraying temp, cooling, etc	___ Sat ___ Unsat
	d. Methods for masking areas	___ Sat ___ Unsat

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	e. Pressure and flow settings	___ Sat ___ Unsat
	f. Gun to work piece distances and angles	___ Sat ___ Unsat
	g. Rate of application	___ Sat ___ Unsat
	h. Final thickness	___ Sat ___ Unsat
A 5	a. Are pieces to be flame sprayed cleaned prior to process?	___ Sat ___ Unsat
	b. List methods and materials used, if applicable:	___ Sat ___ Unsat
	c. Is cleanliness maintained prior to flame spraying?	___ Sat ___ Unsat

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A 6.	Identify inspection methods used to verify conformance with procedures and standards: * Visual ____ * Tensile Bond ____ * Hardness ____ * Thickness ____ *Other (list) ____	___ Sat ___ Unsat
A 7.	What inspection documents exist and are they maintained to confirm inspection process was performed?	___ Yes ___ No
	a. Are inspection documents properly completed and maintained?	___ Yes ___ No
	b. Review and record number of samples: _____	___ Yes ___ No
A 8.	Is traceability maintained for material, which has been flame sprayed?	___ Yes ___ No
A 9.	Is inspection data reviewed and accepted by qualified personnel?	___ Yes ___ No
A 10.	Are corrective actions performed and documented after rejectable attributes have been found?	___ Yes ___ No ___ N/A

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A 11.	Are all tools, gages, meters, utilized for monitoring and/or inspection a part of the manufacturer's calibration program?	___ Yes ___ No ___ N/A
A 12.	Are certifications for raw materials used in flame spraying process reviewed for acceptance and maintained on file for review?	___ Yes ___ No ___ N/A
A 13.	Are personnel performing flame spraying process knowledgeable in the use of the:	___ Yes ___ No ___ N/A
	* Procedure:	___ Yes ___ No ___ N/A
	* Tools	___ Yes ___ No ___ N/A
	* Gages, meters, etc	___ Yes ___ No ___ N/A
A 14.	Are special precautions identified prior to performing flame spray process (i.e. safety issues, hazard material)?	___ Yes ___ No ___ N/A
A 15	a. Are any special handling equipment used or special packaging required after flame spraying process? List:	___ Yes ___ No ___ N/A

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	b. Is handling equipment and packaging requirements accomplished IAW the specification, drawing or procurement spec?	___Yes ___No ___N/A
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Additional Comments/Concerns: