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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: