

# QUALITY INSPECTION PROCEDURE

## 1] PROGRAMMING –

- Using a pencil, check off all dimension and features. This will assure that nothing is missed.
- If it is a REV [Yellow] compare the OLD PRINT to the NEW PRINT. Mark changes using highlighter.

## 2] FIRST PIECE INSPECTION –

- Operator should make a good part and check it to the print
- Then inspect the first piece in front of a qualified person and get authorized from that person
- Qualified person should ensure that they involve/train operator during first piece inspection if need be
- Same pencil check strategy (as PROGRAMMING) should be followed
- Qualified person will sign the back sheet after the first piece inspection (Same person cannot sign both “set up” and “inspected by” boxes) and they will ensure operator has a “Quality Sheet” for the sampling plan

## 3] SAMPLING PLAN INSPECTION –

- **Quality Inspector will inspect first, last and every 3<sup>rd</sup> consecutive sampling plan parts**
- **All the in-between sampling plan parts will be inspected by operator**
- **Always “Quality Sheet” should be used and all fields should be filled out**
- **Operator (trained by qualified person, whenever needed) will inspect parts according to the sampling plan**

<u>Order Quantity:</u>	<u>[A] Base Sample size</u> <i>(new/revised parts)</i>  [PINK & YELLOW]	<u>[B] Base Sample size</u> <i>(repeat &amp; unchanged parts)</i>  [BLUE]	<u>An example for understanding</u> [For all operators]
1 – 8	2	2	→ Say if it is pink and the count is 125, then it falls in {91-150} category; so totally 20 parts should be inspected.  → Interval would be : $125/20 = 6.25$  → So the qualified person will inspect every 6th part respectively.
9 – 15	3	3	
16 – 25	5	4	
26 – 50	8	5	
51 – 90	13	7	
91 – 150	20	9	
151 – 280	32	11	
281 – 500	50	15	
>501	80	20	