



PROCESS CHECK REPORT

Company:			
Process Title	Passivation of Corrosion Resisting Steels & Nickel Based Alloys		
Category(s) of Approval	4zs		
Process Check Report Ref. No:			
Date Of Process Audit:			
Auditor (please print name):			
Nadcap Reference (if applicable):			
Invoked Documents:- HBIFSAS/QA/SC1, QAIS Doc Ref Q5B-008H			
QA Element	Yes	No	
	✓	X	
Calibration Status: All Inspection, Measuring and Test Equipment used in this Process is calibrated, and certified against equipment traceable to National Standards			
Materiel Usage: All Materiel used in this Process is in accordance with requirements of the relevant Process Specification/Standard			
BAEP/BS: All work has been processed in accordance with the latest issue of the relevant BAEP(s) and/or National Standards			
Technique Sheets: All applicable Technique Sheets used, including Inspection Plans, are to the latest issue and have been approved by HBQSC			
Training/Qualification: All relevant personnel involved with this Process are appropriately trained, qualified and assessed periodically			
Internal Audit: The Internal Audit for this Process is current, with no outstanding CAs			
If No to any of the above QA Elements - give details below:			
Audit Comments:			
Auditor:	QA Manager:	Approved by (HBQSC):	
HBQSC/QA/SC194(M).xls	Issue 1	1	



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Invoked Documents Listing

1. Process Specifications

Reference No.	Title	Issue
BAEP 0013 SAE-AMS2700B	PASSIVATION OF CORROSION RESISTING STEELS & NICKEL-BASED ALLOYS	3 FEB. 2004

2. Quality Assurance Instructions To Suppliers

Reference No.	Title	Issue

3. Other Technical Documents Invoked

Reference No.	Title	Issue

4. General

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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Is BAEP 0013 ,SAE-AMS2700B available and at the correct issue.		
Does an internal procedure exist and what is its reference/issue status.		
Is the application for Passivation satisfactorily incorporated into the planning.		
Are history sheets available and fully endorsed.		
Is the passivation bath lined in a acid resisting tank.		
Is the tank containing Passivation lined in a acid resistant tank.		
Is the Passivation done after all machining,forming,welding,heat treatment,blasting,chemical etching and pickling have been completed.		
Are parts been cleaned by grip blasting to BAEP 2002 and BAEP 2004		
Are the jigs made of Stainless Steel for suspension in degreasing and Passivation bath.		
Have parts been degreased before processing and contamination been removed by Alkaline clean.		



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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Is the Supplier testing the Corrosion Resistance for alloys with less than .085% carbon by one of the followings 1. or 2.		
1. Humidity test : parts shall be free from visible red rust after exposure to 95% min relative humidity at 95-115F for not less then 23 hours.		
2. Water Immersion : parts shall be free from visible red rust after immersing for one hour and then alloy drying for another hour, in cycle until elapse 24 hours.		
Is the Supplier testing the Corrosion Resistance of austenitic steels and precipitation hardened steels and ferrite with more than 16% chromium one of the followings 3. or 4.		
3. Copper sulphate Solution : No copper colored deposit presence acceptable after testing with copper sulphate solution.		
4. Salt spray : Parts free from red rust after 2 hours exposure per ASTM B117.		
Is the Surface Appearance free of pitting, smutting, frosting, dimensional changes or any chemical attack on the parts?		



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AUDIT FINDINGS

Details Of Check	Result / Remarks	Action Required
Is the sampling and Testing done per the SAE-AMS2700B Table 2?		
Are operators been adequately trained to perform the specific tasks.		