

NINGBO WINDO METAL CO.,LTD

QUALITY CONTROL PLAN FOR FORGING BOLTS

					Standard		ASTM A325M ASME B18.2.3.7M		PAGE 1/1		
No	Revise reason	Revise Item	REVISER	DATE							
steps	Name of process	Processing	Equipment	Manage items		Method of manage			Exception Handling	Precedence	
				Specification	Requirement	Method of inspection	Frequency				Record
				Worker	Inspector						
1	Raw Material Inspection	<input type="checkbox"/>		1.Surface	No scale-manner,Crack concave-convex . Etc	visual		Per Acceptance Standard	Inspection record of Incoming Goods	Fill Out "Rejection Report"	C
				2.Size	Dia (Φ) +0/-0.05mm	Micrometer					B
2	Forging	<input type="radio"/>	Forging Machine	1.Height	Forge Technological Parameter	Vernier Caliper		Per 1 Hour	Forging Punching Inspection Record	Same as Above	A
				2.Across Corner							A
				3.Accros Flat							A
				4.Thread Length							A
				5.Total Length							A
				6.Surface	No crack, burr,dents	Visual Inspection				A	
3	Rolling	<input type="radio"/>	Rolling Machine	1.Go/No Go Gauge	Can Go and No Go	GO/NoGO Gauge		Per 1 Hour	Forging Rolling Inspection Record	Same as Above	A
				2.Thread Length	Per Performance Standard	Vernier Caliper					A
				3.Surface	No break or Flat thread	Visual Inspection					A
4	Heat Treated	<input type="radio"/>	Mesh Belt Furnace	1.Quench Temperature	According to heat treatment technological parameter	Auto-Record		Per 1 Hour	Major technological parameter And Monitoring Record	Same as Above	B
				2.Temper Temperature		Auto-Record					B
				3.quench time		Visual Inspection					B
				4.temper time		Visual Inspection					B
				5.hardness		Rockwell hardness Tester					B
5	Finishing	<input type="radio"/>	Out Partner	1.HDG Thickess(if)	Per Specification	Thickness Tester		Spot Check	Inspection Recording	Same as Above	A
				2.Surface		Visual Inspection					A
6	Final Product Inspection	<input type="checkbox"/>		1.Thickness	Per Specification	Vernier Caliper		Per Sample Inspection Specification	Test Report	Same as Above	A
				2.Across Corners							B
				3.Across Flats							A
				4.Total Length							
				5.Thread Length							
				6.Appearance	No Brack,Flat Thread,No Crack etc	Visual Inspection				B	
				7.Tensile	Per Specification	Universal Tester				A	
7	Packing	<input type="checkbox"/>		1.Appearance	No Damage	Visual Inspection		Full Inspection	Full Inspection	Same as Above	B
				2.Quantity	Per Clients Requirement	Platform Scale		1 / Lot	1 / Lot		B
				3.Label		Visual Inspection		Full Inspection	Full Inspection		C

Marking: — Test — Processing

Precedence: A: Important B: Secondary C: No Efection For Use

QC Department	Prepared By	Mr CAI / 2019-09-15
Checked:		
Approved :		