General Overview

This document should be referred to as a guide during visual & dimensional inspection of the extruded hollow D-Seal.

This Standard Inspection Process Guide covers the below visual inspection steps.

- Smooth surface finish
- Crease free material
- Pit free material
- Inclusion free material

Visual inspection of material should be carried out by all relevant production areas Extrusion

Production paperwork should be stamped to show that this guide has been followed and that visual inspection of the material/item has passed.

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1. Surface finish

Item(s) should be inspected under an inspection lamp to look for surface inconsistencies such as ripples or bubbles, the items should be moved under the inspection lamp so that the surface can be checked under different lighting angles.

The item(s) surface should be checked using touch so that any inconsistencies, not shown visually can be detected by this method.

The surface should be smooth following this inspection step.

If the surface is not smooth following this step visual inspection has failed and this should be raised with a team leader or a member of the Quality team for advice and further inspection

2. Creases, Pits and Inclusions

Material/Items should be free from creases, pits or inclusions the same inspection method should be used as above, If creases, pits or inclusions are found visual inspection has failed and this should be rejected and raised with a team leader or a member of the Quality team for advice or further inspection.

Pits or indentations found should be measured by the Quality team, Specifications should be checked for tolerance on permissible surface indentations and these documents

Dimensional checks

The dimensions should be checked against Sellafield Ltd Drawing number B85054, EDF drawing number PED/XX/3027/5. & JW drawing 171901.

1. **Critical measurements**

Both depth & section measurements should be taken with a calibrated Vernier (see Fig 1 & 2)

Fig 1

Fig 2

Hole size should be taken with a calibrated Vernier in-line with Fig 3 and meet tolerances stated on customer tolerance drawing.

Fig 3

To gain the hole centralization dimension a 2mm rod is to be placed into the hole (see Fig 4.)The measurement should be taken using a calibrated Vernier take the depth measurement from base to top of the 2mm rod and taking away 1mm. to give the correct measurement (see Fig 5.)

Fig 4

Fig 5

IF IN DOUBT ASK!

End