

# Drain Cell Verification Check Sheet

(Must be completed by Quality within the first hour of every shift)

Shift: \_\_\_\_\_

Date: \_\_\_\_\_

Verification of Welder, Test Station, Packing Station, and Labels are completed once per shift. Please complete this form and turn into the Quality Manager by the end of shift. If any verifications fail, then do not use that piece of equipment and notify supervisor. Once the equipment is fixed, run verification again before use.

<b>WELDING STATION</b>	Welder Verification - welder as sensors to make sure there is a filter in each fixture and that the green side is up/white side down.						
			No Filter in Fixture, Will not Weld		White Side Up, Will not Weld		QA Personnel Signature
			PASS	FAIL			
	4-Out Welder Fix. #1				4-Out Welder Fix. #1		
	4-Out Welder Fix. #2				4-Out Welder Fix. #2		
	4-Out Welder Fix. #3				4-Out Welder Fix. #3		
	4-Out Welder Fix. #4				4-Out Welder Fix. #4		
	2-Out Welder Fix. #1				2-Out Welder Fix. #1		
2-Out Welder Fix. #2				2-Out Welder Fix. #2			

<b>TEST STATION - LEAK TEST</b>	Test Station Verification - The Leak Tester on the Test Station requires verification by using a GOOD (Green painted part) and BAD (Red painted part) MASTER TEST PARTS. GOOD and BAD MASTER PARTS are put in each test station with the station in Off Line mode. GOOD MASTER TEST PART will pass and the BAD MASTER TEST PART will be rejected if system is working correctly.						
			GOOD (Green) MASTER TEST PART		BAD (Red) MASTER TEST PART		QA Personnel Signature
			PASS	FAIL	PASS	FAIL	
	Test Station #1				Test Station #1		
	Test Station #2				Test Station #2		
Test Station #3				Test Station #3			

<b>TEST STATION - Date Code Stamping</b>	Test Station Verification - The Date Stamping of each part has to be manually changed and verified by each shift. The Test Station has a camera on each station to verify that there is print on the part in the proper area. To test this, turn off the air to the stamper and start a cycle with a good part. The tester will reject the part.								
			DATE CODE TEST WITH NO AIR		Record Date Code Below		PROPER DATE CODE AND READABLE		QA Personnel Signature
			PASS	FAIL	_ _ _ _ _	PASS	FAIL		
	Test Station #1				Test Station #1				
	Test Station #2				Test Station #2				
Test Station #3				Test Station #3					

<b>PACKING STATION / BOX LABEL</b>	Packing Station Verification - The Packing Station has a camera to verify 21 parts are on each of the three layers of the box. To test this, leave a part out on each of the three layers and press the green button to verify that it will fail to accept. <b>Verify the box labels, on the skid of approved boxes, are ready for inventory - box labels pass/fail.</b>						
			FULL BOX BY LAYER CHECK		VERIFY CORRECT BOX LABELS		QA Personnel Signature
			PASS	FAIL			
	Packed Layer #1				Box Label		
Packed Layer #2							
Packed Layer #3							

<b>BURST TEST</b>	Burst Testing - One part from each fixture on the welder should be verified once per shift to see how much pressure it will take to "burst" apart. The complete directions on how to implement this test are in the Yellow Book.					
			RECORD BURST PSI > 14.7 PASS : < 14.7 FAIL			QA Personnel Signature
			BURST PSI	PASS	FAIL	
	Part from 4-Out Weld Fixture #1					
	Part from 4-Out Weld Fixture #2					
	Part from 4-Out Weld Fixture #3					
	Part from 4-Out Weld Fixture #4					
Part from 2-Out Weld Fixture #1						
Part from 2-Out Weld Fixture #2						