A 1		37 31
A 1	A. Does supplier have procedures for Teflon Coating?	YesNo
	List procedures:	
	List Contract requirements	
	B. Do procedures meet environmental laws?	
	B. Do procedures meet environmental laws?	
	C. How does supplier ensure compliance to local Environmental laws?	YesNo
	C. How does supplied clistic compliance to local Environmental laws:	1CSNO
Coating	Spray Area	
		YesNo
A 2	A Compliant Teffor Continue Company Area and and an instant 40	
A Z	A. Supplier's Teflon Coating Spray Area enclosed or isolated?	
		YesNo
	B. Supplier's Teflon Coating Spray Area exhausted?	
	11 Jan 1 Jan	
		37 37
		YesNo
	How?	

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C. Are adequate controls in place to protect from contamination?	YesNo
D. Are adequate controls in place for Temperature, Humidity, and sources of contamination?	YesNo
E. Adequate safety precautions established? (i.e., respirators, no smoking, no eating, washing of hands)	YesNo
F. Air supply for spray gun checked for moisture, oil, and hydrocarbons?	YesNo
G. Spray gun checked for cleanliness prior to use?	YesNo
H. Written Procedures for cleaning spray gun? Method used:	YesNo
J. What is the method to transport balls to spray area?	
	E. Adequate safety precautions established? (i.e., respirators, no smoking, no eating, washing of hands) F. Air supply for spray gun checked for moisture, oil, and hydrocarbons? G. Spray gun checked for cleanliness prior to use? H. Written Procedures for cleaning spray gun?

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B 2	K. What is the method to handle balls during transport?	
	L. Are balls protected from contamination?	
	How?	YesNo
Primer a	and Final Coat Material	
A 3	A. Are receipt inspections performed on Teflon coating material?	
	List inspections performed:	YesNo
	List primer used:	
	List final coat used:	
	B. Are inspections performed on primer and final prior touse? (Temperature, shelf life, separation)	
		YesNo
	List others:	

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	C. Are inspections documented? Batch Numbers recorded?	YesNo
	D. Primer and final coat strained prior to use?	
		YesNo
	List methods:	
	E. Storage requirements addressed?	
	List method?	YesNo
Ovens		
A 4	A. Type of Curing oven?	
	B. Type of oxidizing oven?	
	C. Written procedures for calibrating ovens?	
	Method:	YesNo

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	Intervals:	
	Last calibration date:	
	D. A. 1 4 10	
	D. Are ovens exhausted?	
		YesNo
	Method:	
Inchacti	on and Prep of balls for Teflon coating (Ball repair only)	
A5	A. Procedure for cleaning balls in the as-received condition?	
A3	A. Procedure for cleaning balls in the as-received condition?	
		YesNo
	List:	
A 5	B. Document acceptance procedure to determine acceptance for repair?	
AJ	b. Document acceptance procedure to determine acceptance for repair?	Vag. No.
		YesNo
	C. Are dimensions verified?	
		YesNo
	D. Surface condition inspected?	
	D. Surface condition inspected?	Voc. No.
		YesNo

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	E. Generic tests performed to identify material?	
	E. Generic tests performed to identify material?	Vag. No.
		YesNo
	F. Results of inspections documented?	
	1. results of hispections documented:	YesNo
	G. Welding repair performed?	
	o. Wording repair performed.	YesNo
	List procedures:	
	2.00 p. 000 a. 0.01	
	H. Additional Machining required to clean ball?	
		YesNo
	List operations:	
	List cutting fluids:	
	The state of the s	
	List method for obtaining 16 RHR finish (prior to oxidizing):	
	I Cutting fluids on hybridant source of oil on budge south and	
	J. Cutting fluids or lubricant source of oil or hydrocarbons?	Vog No
		YesNo
1		

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	K. Is ball inspected after machining or welding (dimensions porosity, surface finish) and documented?	YesNo
	List others:	
Cleanin	g after final machining/welding	
A 6	A. Are solvents used to clean balls?	
ΑÜ		YesNo
	List solvents used:	
	B. Solvents used a source of hydrocarbons?	
	(If yes, note for question 6E.)	YesNo
	C. Ball dried before final cleaning?	YesNo
	List procedure:	
	D. Ball protected from contamination during drying?	YesNo
	E. Ball inspected for residual oils/hydrocarbons after cleaning/drying?	YesNo
Oxidizii	ng of Ball Surfaces	
A 7	A. Specified time between drying and Oxidizing?	YesNo

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	B. Specified temperature for Oxidizing?	YesNo
	C. Specified method to verify Oxidation?	YesNo
	D. Specified method to cool ball?	YesNo
	E. Ball protected from contamination during cooling?	YesNo
Final Su	urface Preparation prior to Teflon coating	
A 8	A. List elapsed time between oxidation and final surface preparation:	
	B. Method use to obtain 32 RHR surface preparation (After Oxidizing):	
	C. Method use for grit blasting:	
	D. Does grit blasting remove the oxide coating?	YesNo

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	E. Grit blasting equipment checked for sources of moisture, oil or hydrocarbons?	YesNo
	F. Method used to clean ball after grit blasting:	
	List any solvents:	
	G. Method use to dry ball after cleaning:	
	H. Ball inspected for residual oils/hydrocarbons after cleaning and drying? Before After	YesNo
	J. Ball inspected for dimensions, before or after cleaning?	BeforeAfter
	K. Ball inspected for porosity, before or after cleaning?	YesNo
	L. Ball inspected for surface finish, before or after cleaning?	YesNo
	M. Ball inspected for other inspections, before/after cleaning?	YesNo
	List inspections:	

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	N. Inspections documented?	YesNo
	O. How is ball handled and protected from contamination during inspection, cleaning and drying:	
	Procedure used for applying prime coating	
4.0		
A 9	A. Elapsed time between final surface preparation and application of primer coat:	
	B. Number of final coats:	
	C. Thickness of coats:	
	C. Thickness of coats.	
	D. Elapsed time between coats:	
	E. Inspection for continuous and discontinuous coat	YesNo
	F. Method of drying primer coat:	

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NAV27	TEFLON COATING (REPAIR OF BALL VALVES)	
	G. Method used to protect material from contamination during drying:	
	H. Is spray gun cleaned after primer coat?	
	11. Is spray guil cleaned after primer coat:	YesNo
Fuging/	curing of primer coat	
A 10	A. Elapsed time between spray coating and curing:	
1110	The Endpood time occurred spray counting and caring.	
	B. Is material protected from contamination in transporting to ovens?	
		YesNo
	C. Oven temperature settings:	
	D. Method used to determine when primer is cured:	
	E. Temperatures and times in oven recorded?	
	•	YesNo
	F. Method used to cool ball after curing:	
	G. Ball cleaned after cooling?	
	-	YesNo

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NAV27	FEFLON COATING (REPAIR OF BALL VALVES)	
	H. Primer coat inspected after cooling (Visual, Thickness, Adhesion, or other)	YesNo
	J. Inspections documented?	YesNo
	K. Material protected from contamination while staging for final Teflon coating?	YesNo
	Procedure used for applying final Teflon coating	
A 11	A. Elapsed time between primer and final application:	
	B. Number of final coats:	
	C. Thickness of coats:	
	D. Elapsed time between coats:	
	E. Inspection for proper final coat application?	YesNo
	F. Method of drying final coat:	

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	G. Method used to protect material from contamination during drying:	
	II Is govern on alcohol from Eural Toffon 20049	
	H. Is spray gun cleaned after final Teflon coat? Fusing/curing of final Teflon coat	YesNo
A 12	A. Elapsed time between spray coating and curing:	
	B. Is material protected from contamination in transporting to ovens?	YesNo
	C. Oven temperature settings:	
	D. Method used to determine when final Teflon is cured:	
	E. Temperatures and times in oven recorded?	YesNo
	F. Method used to cool ball after curing:	
	G. Ball cleaned after cooling?	YesNo

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H. Final coat inspected after cooling (Visual, Thickness, Adhesion, or other)	YesNo
J. Inspections documented (i.e., adhesion test)?	YesNo
K. Explain how final Teflon coating inspections are documented.	

Additional Comments/Concerns:

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