Date Submitted: 17/02/2023 09:32 AM
Submitted By: quality.control2@walsin.co.uk

Walsin Ltd - QA Checklist - Factory Floor

Unit Ref	SG-03-010
Job No	17
Refer to specific Fabrication Dwg, Details, Sections, and Confirm the VR meets MVR Standard.	VR's not to be submitted unless reviewed against and accepted to be in line with MVR.
	At all Steps it is critical that all Swarf is removed, Materials are clean and consideration of any contact on PPC and Glass to avoid potential Damage

Stage 1. Carcass/End Fills/Bracket Inserts + Packets

Procedure	1.1 Check Dimensions of all Carcass parts.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.2

Procedure	1.2 Remove Swarf and oil. De-tape where required
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.3

Procedure	Cavities in-filled using ‘Fabrock’ insulation & fully sealed using Flex 2 as per Schuco recommendations
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.4

Procedure	1.4 Sealant applied to cut faces, Flex 2 as per Schuco recommendations
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan
VR-01 Picture	

Walsin Ltd - QA Checklist - Factory Floor







Walsin Ltd - QA Checklist - Factory Floor

	
VR-01	VR-01

1.5

Procedure	1.5 Frame assembled as per Schuco recommendations.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.6

Procedure	1.6 All connections checked for tightness and levelled.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.7

Procedure	1.7 Clean off excess sealant.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.8

Procedure	1.8 All penetrations & fixings fully sealed.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

1.9

Procedure	1.9 Check frame for squareness across diagonals & adjust if required.
Fabricator Name	Roman Seoane
Checked By	Mark McGuigan

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead

Walsin Ltd - QA Checklist - Factory Floor

Team Lead Name	Mark McGuigan
Signature	
Date	16/02/2023

Stage 2. Lifting Plates/T Brackets/Galv. Back sheet.

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2.1

Procedure	2.1 Check that all critical items from Stage 1 have been fully completed before proceeding.
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

2.2

Procedure	2.2 Anti-Crush Tubes installed into Outer frame Cavity
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

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VR-02: 1No Photo per hook Location	
VR-02	VR-02

2.3

Procedure	2.3 Fit Lifting Plate & T Bracket as per fabrication instruction. Bolts to be tightened to correct torque, Each Nut to be QA'd and sprayed for assurance. (Tightening Torque value 73 N-m)
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

2.4

Procedure	2.4 Back sheet - Bead of silicone applied to internal face of frame (Min. 6mm Bead Full perimeter of Back sheet). See Nozzle Sample for prep
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

VR-03: Photo to include view of Brk Spray'd Yellow for tightening check	
VR-03	VR-03

2.5

Procedure	2.5 Back sheet correctly screwed in position.
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

2.6

Procedure	2.6 All Screws, bolts & Nuts to be fully sealed.
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

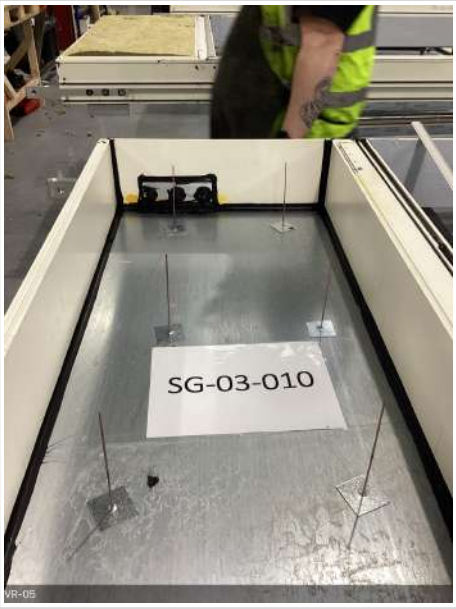
2.7

Procedure	2.7 External bracket penetration to be full sealed to back sheet.
Fabricator Name	Philip Moore
Checked By	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

VR-04: 2No. photos per Bracket	 
VR-04	VR-04

2.8

Procedure	2.8 All Internal Joints between Galv. Sheet, Unit, and Brackets fully sealed and smoothed over.
Fabricator Name	Philip Moore
Checked By	Mark McGuigan
VR-05: 2No. photos per cavity	 
VR-05	VR-05

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

Signature	
Date	16/02/2023

Stage 3. Insulation/Glass Adaptor Sub-Frame

Unit Ref	SG-03-010
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3.1

Procedure	3.1 Check all critical items from Stage 2 have been completed before proceeding.
Fabricator Name	Mark Beggs
Checked By	Mark McGuigan

3.2

Procedure	3.2 Rockwool cut to correct shape and fitted into unit and secured by spike (220mm spike req).
Fabricator Name	Mark Beggs
Checked By	Mark McGuigan

3.3

Procedure	3.3 Glass adaptor fitted on bead of sealant (Flex 2).
Fabricator Name	Mark Beggs
Checked By	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

VR-06	 
VR-06	VR-06

3.4

Procedure	3.4 All penetrations & fixings fully sealed.
Fabricator Name	Mark Beggs
Checked By	Mark McGuigan

3.5

Procedure	3.5 Glass adaptor end cavities fully sealed.
Fabricator Name	Mark Beggs
Checked By	Mark McGuigan
VR-07: 4No. Photos	 

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VR-07	VR-07	

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	16/02/2023

Stage 4. Glass Installation

Unit Ref	SG-03-010
Job No	17
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4.1

Procedure	4.1 Check all critical items from Stage 3 have been completed before proceeding.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.2

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Procedure	4.2 Prepare bonding machine for structural sealant application.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.3

Procedure	4.3 Apply structural glazing gasket, alignment to frame critical.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.4

Procedure	4.4 Glass checked for any damage etc.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.5

Procedure	4.5 Internal face of glass cleaned & primed.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.6

Procedure	4.6 Glass adaptor cleaned & primed.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.7

Procedure	4.7 Glass positioned onto unit - Critical glass stamp viewable from inside, bottom right.
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

4.8

Procedure	4.8 Bonding applied to full perimeter of glass unit (full depth 30mm).
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

VR-08		
VR-08	VR-08	

4.9

Procedure	4.9 Unit labelled with time & Date of bonding completed for curing purposes.
Date	16/02/2023
	16/02/2023 12:10 PM
Time	12:10 PM (0 GMT)
Fabricator Name	Kenny Sadler
Checked By	Mark McGuigan

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	16/02/2023

Stage 5. Spandrel Adaptor Sub-Frame/Transom Brackets

Unit Ref	SG-03-010
Job No	17

Walsin Ltd - QA Checklist - Factory Floor

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5.1

Procedure	5.1 Check all critical items from Stage 4 have been completed before proceeding.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.2

Procedure	5.2 Correct Perforated Panel and Secondary Sheet Ready for Install
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.3

Procedure	5.3 Correct Non-Perforated Int & Ext Panel Ready for Install.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.4

Procedure	5.4 Transom brackets fitted to unit, all penetrations & fixings fully sealed.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.5

Procedure	5.5 Frame prepared to receive sub-frame (fully sealed) + install as per Schuco recommendations.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

Walsin Ltd - QA Checklist - Factory Floor

VR-09: 1No. Photo per Sprandrel	 
VR-09	VR-09

5.6

Procedure	5.6 Spandrel sub frame assembled and fully sealed as per Schuco recommendations.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.7

Procedure	5.7 All penetrations & fixings fully sealed.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

5.8

Procedure	5.8 (Perforated only) Internal non-perforated sheet installed on a bed of silicone. Perimeter to have a full bead of silicone applied.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

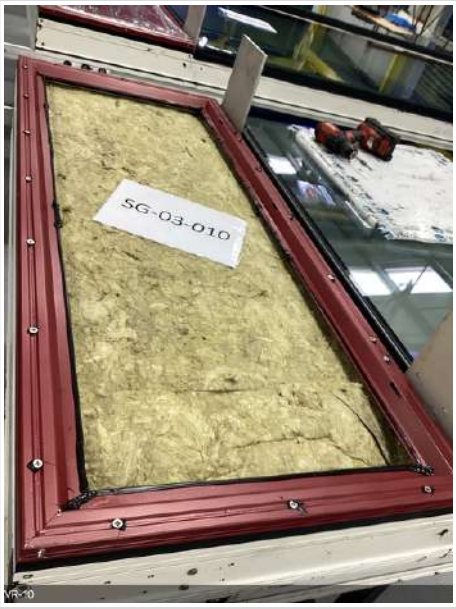
5.9

Procedure	5.9 Aluminium box 'stiffners' fitted.
Fabricator Name	Robert Piotrowski
Checked By	Mark McGuigan

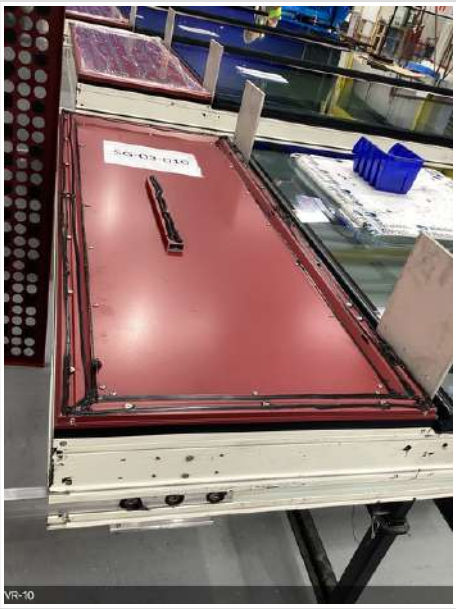
5.10

Procedure	5.10 Spandrel panels fitted to sub-frame (fully sealed) as per Schuco recommendations.
Fabricator Name	Robert Piotrowski

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Checked By	Mark McGuigan
VR-10: 1No. Photo to show silicone seal	   

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VR-10	VR-10

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	16/02/2023

Stage 6. Gasket/Perimeter Bond/Transom Weather Seal

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6.1

Procedure	6.1 Check all critical items from Stage 5 have been completed before proceeding.
Fabricator Name	Nedelin Vasilev
Checked By	Mark McGuigan

6.2

Walsin Ltd - QA Checklist - Factory Floor

Procedure	6.2 Check alignment between Glass & Spandrel is correct to receive outer gasket.
Fabricator Name	Vasil Dzhenkov
Checked By	Mark McGuigan

6.3

Procedure	6.3 Glass edge prepared to receive outer gasket (clean excess sealant from glass).
Fabricator Name	Nedelin Vasilev
Checked By	Mark McGuigan

6.4

Procedure	6.4 Glass edge & Spandrel cleaned & primed.
Fabricator Name	Vasil Dzhenkov
Checked By	Mark McGuigan

6.5

Procedure	6.5 Perimeter gasket cleaned & primed.
Fabricator Name	Nedelin Vasilev
Checked By	Mark McGuigan

6.6

Procedure	6.6 Structural sealant applied (Dowsil 993 continuous).
Fabricator Name	Nedelin Vasilev
Checked By	Mark McGuigan

6.7

Procedure	6.7 Outer gasket installed and held in position using jig until cured as per Schuco recommendation.
Fabricator Name	Vasil Dzhenkov
Checked By	Mark McGuigan

6.8

Procedure	6.8 Transom seal - backer rod set to required depth (13mm).
Fabricator Name	Vasil Dzhenkov
Checked By	Mark McGuigan

6.9

Procedure	6.9 Apply transom weather seal (Dowsil 791).
Fabricator Name	Nedelin Vasilev
Checked By	Mark McGuigan

6.10

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Procedure	6.10 Outer gasket mitres fully sealed in position; "critical step" ensure gasket joint is tight.
Fabricator Name	Vasil Dzhenkov
Checked By	Mark McGuigan
VR-11: 1No Photo per connection	   
VR-11	VR-11

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan

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Signature	
Date	17/02/2023

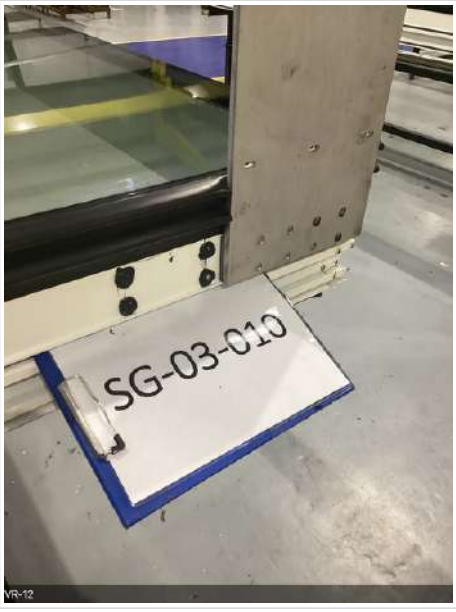
Stage 7. Fin Brackets & Fins

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7.1

Procedure	7.1 Check all critical items from Stage 6 have been completed before proceeding.
Fabricator Name	Laszlo Liszicsan JNR
Checked By	Mark McGuigan

7.2

Procedure	7.2 Fin brackets installed as per Schuco recommendation (outer gasket fins to be sliced at bracket location).
Fabricator Name	Laszlo Liszicsan JNR
Checked By	Mark McGuigan
VR-12: 1No. Photo be Brk	 

Walsin Ltd - QA Checklist - Factory Floor

		
VR-12	VR-12	

7.3

Procedure	7.3 Bullet gasket ends cut & installed.
Fabricator Name	Laszlo Liszicsan JNR
Checked By	Mark McGuigan
VR-13: 2No photo - (TOP & BTM)	 

Walsin Ltd - QA Checklist - Factory Floor

		
VR-13	VR-13	

7.4

Procedure	7.4 Fins & end plates installed.
Fabricator Name	Laszlo Liszicsan JNR
Checked By	Mark McGuigan

7.5

Procedure	7.5 Outer fin kept with panel for delivery to site.
Fabricator Name	Laszlo Liszicsan JNR
Checked By	Mark McGuigan

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	17/02/2023

Stage 8. Packing

Unit Ref	SG-03-010
Job No	17

Walsin Ltd - QA Checklist - Factory Floor

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8.1

Procedure	8.1 Rack Number recorded.
Fabricator Name	
Checked By	Mariusz Mueller

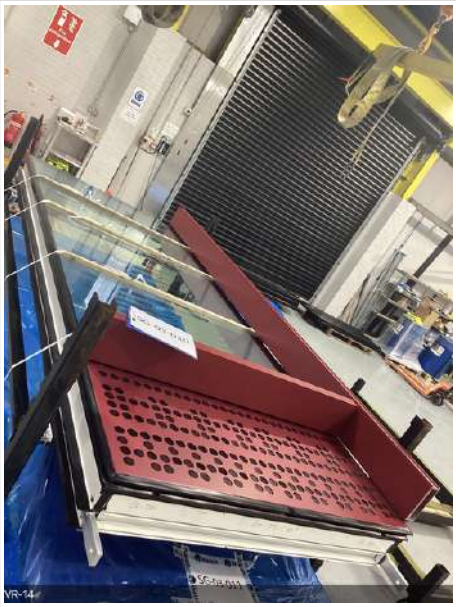
8.2

Procedure	8.2 Rack to be checked is structurally sound and all protective strips and buffers are replaced/present where necessary.
Fabricator Name	
Checked By	Mariusz Mueller

8.3

Procedure	8.3 Ensure bonds are fulled cured taking note of Cure time in Section 4 which could delay packing process are displayed.
Fabricator Name	
Checked By	Mariusz Mueller

8.4

Procedure	8.4 Units are firmly fixed to rack with appropriate strapping with Edge or other protection applied. Take Photo of completed unit fully packed before heat wrapping.
Fabricator Name	
Checked By	Mariusz Mueller
VR-14	 

Walsin Ltd - QA Checklist - Factory Floor

VR-14	VR-14

8.5

Procedure	8.5 Full Rack wrapped with 2No. layers of UV heat wrap and 1No layer of clear Heat Wrap.
Fabricator Name	
Checked By	Mariusz Mueller
VR-15	 
VR-15	VR-15

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	17/02/2023

Stage 9. Logistics Preparation

Unit Ref	SG-03-010
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Refer to specific Fabrication Dwg, Details, Sections, and Confirm the VR meets MVR Standard.	VR's not to be submitted unless reviewed against and accepted to be in line with MVR.

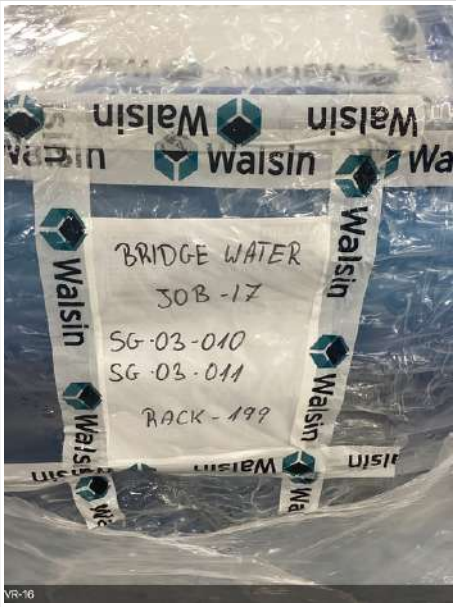
Walsin Ltd - QA Checklist - Factory Floor

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9.1

Procedure	9.1 Confirmation Rack has been fully strapped & heat wrapped by packing team.
Fabricator Name	
Checked By	Mariusz Mueller

9.2

Procedure	9.2 Despatch Docket completed clearly showing - Job No / Unit Seq / Rack I.D, With a copy attached to the Rack
Fabricator Name	
Checked By	Mariusz Mueller
VR-16	 
	 

Walsin Ltd - QA Checklist - Factory Floor

VR-16	VR-16

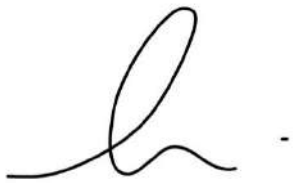
9.3

Procedure	9.3 Rack has been safely removed from factory ensuring not to cause damage to completed units. Any damage to be reported immediately to Team Lead.
Fabricator Name	
Checked By	Mariusz Mueller

9.4

Procedure	9.4 Rack located in the yard ready for dispatch.
Fabricator Name	
Checked By	Mariusz Mueller

Sign Off

Note	Final Inspection Must Be Carried Out and Signed Off by Team Lead
Team Lead Name	Mark McGuigan
Signature	
Date	17/02/2023

Supervisor Sign Off

Supervisor Name	Mariusz Mueller
Signature	
Date/Time	17/02/2023