



WORK INSTRUCTION

MACHINE SHOP INSPECTION GUIDELINE

REVISION: 00

PROCEDURE NO.: WI-8.2.4.54

DATE EFFECTIVE: 05/01/14

Machine Type	Material	Quantity	Inspection Sample Size
All Machines Except CNC Lathes	Any	1 to 9	First and Last Piece
		10 Plus	First Piece and One every ten piece
CNC Lathes	Aluminum	1 to 19	Check every piece 100%
		20 Plus	First piece and 1 every 20 pieces
	Steel	1 to 19	Check every piece 100%
		20 Plus	First piece and 1 every 20 pieces
	Brass	1 to 29	Check every piece 100%
		30 Plus	First piece and 1 every 30 pieces
	303 Stainless Steel	1 to 14	Check every piece 100%
		15 Plus	First piece and 1 every 15 pieces
	304 Stainless Steel	1 to 9	Check every piece 100%
		10 Plus	First piece and 1 every 10 pieces
	316 Stainless Steel	1 to 4	Check every piece 100%
		5 Plus	First piece and 1 every 5 pieces
	Incoloy/Inconel	1 to 4	Check every piece 100%
		5 Plus	First piece and 1 every 5 pieces
	Teflon/Plastic	1 to 49	Check every piece 100%
		50 Plus	First piece and 1 every 50 pieces



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/01/14	All	Initial release

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Machine Shop Manager	James Reid	
Senior Management Representative/ Management Representative:	Abe Joseph	