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1. Raw Materials and Purchased Parts Inspection

(1) Raw Materials Inspection

Raw materials and purchased parts are from evaluated qualified supplier.

(2) Steel Inspection

Steel appearance has no defects, with inspection certificate of quality.

(3) Casting Inspection

- a. Casting conforms to requirements of drawings, casting size based on GB/T 6414.
- b. Casting surface should be smooth, line is shipshape.
- c. Good casting cleaning, no sand inside.
- d. Chemical component (C, SI, MN, P,S etc), mechanical capacity (strength of extension, hardness etc) have inspection certificates.

(4) Bearing Inspection

- a. Each bearing has certificate of qualification.
- b. Bearing packing should be in good condition, the surface has no scratches.
- c. Inner and outer diameter of bearing & hardness conform to national inspection standard.
- d. By running test to verify its accuracy and performance, each bearing must be without error after trial run at least 1.5 hours.

(5) Electrical Inspection

- a. All electric appliances have certificate of qualification and pass 3C certification.
- b. By running test to verify its performance, all electrical appliances (including all kinds of motor) should be accurate without noise.

2. Production Process Inspection

(1) Self-inspection

Operator checks machining parts, to separate the qualified and unqualified, and make stamping in qualified part, then truthfully fill in inspection sheet.

(2) Mutual Inspection

Next working procedure checks product quality from last working procedure, if find unqualified parts on process, must stop using, reporting to workshop and QC department.

(3) QC Inspection

QC inspector checks batch parts in accordance with drawings and technology process, and make records. Unqualified is strictly not allowed to continue to produce.

(4) Routing Inspection

Each regional QC inspector is responsible for the daily inspection.

(5) Final Inspection

For processed parts, the operator handles them to QC inspectors to check again.

3. Assembling Process Inspection

- a. Assembling process is checked according to drawings and technology process.
- b. For assembly process, Operator makes strict self-checking, then fill in self-inspection sheet which will be sent to QC inspectors to check.
- c. Sliding and rotating parts movement need to be flexible, smooth, no blocking phenomenon.
- d. Each deflection mechanism must be accurate and reliable.
- e. Using coating method to check fixation combined surface and sliding surface, 0.04 mm feeler is not allowed into every junction.
- f. Reverse idle capacity and operating force of each handle meets requirements.
- g. Box cleanness must not exceed indicators, which can into next process when qualified.



4. Finished Goods Inspection

(1) Appearance Inspection

Machine paint surface must be smooth and uniform. The dislocation of combination edge, junction surface gap between door cover and machine tool must not be more than 1 mm. Labels fixed correctly, smoothly and firmly. Electrical and cooling piping must be neatly arranged, hose should not be distorted, folding and breakage. Countersunk screws should not highlight workpiece surface. Oil cup should be parallel with workpiece surface, underlined part of parts should be accurate and clear.

(2) Electrical System Inspection

Each electrical component model, specification, installation position must be correct, movement and performance must be reliable. Power locks, power switch, abrupt stop button and brake equipment must be safe and reliable.

Insulation, pressure and grounding continuity test must comply with requirements, wiring must be accurate and neat. Light color should be correct. All kinds of warning labels must be complete, correct and firm. Electric box must be clean. The electric shielding must be complete.

(3) Performance and Structure Inspection

Main motion mechanism runs from lowest speed without abnormal sound. The start, stop, braking and insurance device, variable speed conversion from main motion and feed mechanism must be flexible and reliable. Lubrication and cooling system must be reliable.

Machine inspection must be done by strict inspection procedures. Using laser interferometer to detect each machine, to test positioning accuracy and repeat positioning accuracy of X, Z axis, ensuring machine accuracy stable and reliable.

(4) Accuracy Inspection

Test accuracy is according to the National Standard Requirements

(5) Accessories and Tools Inspection

Specification and quantity of accessories are checked according to packing list

(6) Documents Inspection

Technical documentations are complete and in good condition. correct and clear.

5. Exported Packing Inspection

- a. Lumber moisture content is not more than 20%
- b. Joint width of each case board is not more than 3 mm, using vertical direction joint , butt plate color is consistent, and surface is flat.
- c. Foot of each side must use iron for reinforcement.
- d. The nails of surface should be distributed uniform.
- e. Overall packing appearance has no deformation, size of box body conforms to contract requirement.
- f. Packing labels are complete, correct and clear.

More information, please feel free to contact with Haisen Team, thanks for your reading.

