A. Incoming Material

**Quality Assurance** 

1. Glass

Inspected by:	Date/Time	Shift	Manufacturer	Glass Type	Thickness	Lite Count	Container Count	Defects/ Damage

A. Incoming Material

**Quality Assurance** 

2. Spacer Steel

Inspected by:	Date/Time	Shift	Mfg.	Steel Type TP or SS	Coil #	Thickness	Slit Width	No oil, rust, dirt, etc.	Defects/ Damage

A. Incoming Material

**Quality Assurance** 

3. Desiccated Matrix

Inspected by:	Date/Time	Shift	Manufacturer	Matrix Lot #	Drum #	Lids Secure No Dents

#### A. Incoming Material

**Quality Assurance** 

4. Dessicated Matrix During Manufacture

Inspected by:	Date/Time Drum Opened	Shift	Lids secure/ no dents	Date Received	Matrix Lot #	Drum #	Moisture Indicator	Dryness test

A. Incoming Material

**Quality Assurance** 

5. Sealants

Inspected by:	Date/Time	Shift	Manufacturer	Sealant Type	Sealant Lot #	Drum #	Defects/ Damage

A. Incoming Material

**Quality Assurance** 

6. Miscellaneous Sealant Tests

Performed by:	Date/Time	Shift	Date Sealant recvd.	Mfr.	Sealant Type	Sealant Lot #	Drum#	Defects/ Damage	Shelf Life	Sealant Butterfly test	Tack free test	Snap time test	Deep Section test	Tab adhesion test	Slump test

A. Incoming Material

**Quality Assurance** 

7. Closure Connector

Date/Time	Shift	Manufacturer	Size	Туре	Clean	Qty
	Date/Time	Date/Time Shift	Date/Time Shift Manufacturer	Date/Time Shift Manufacturer Size	Date/Time Shift Manufacturer Size Type	Date/Time Shift Manufacturer Size Type Clean

A. Incoming Material

8. Muntin Bars and Clips

M-Bars								
Inspected by:	Date/Time	Shift	Manufacturer	Material	Size	Туре	Clean	Qty
_								
Clips								

B. Fabricated Items

1. Spacer (3-Side Hot Melt or DSE) Before Assembly

					Matrix			(	Sealan	t	Spacer						
Operator Initials	Date/Time	Shift	Adhesion Check 1	Adhesion Check 2	Matrix Thickness (Depends On Type)	Matrix filled side to side	Matrix surface smooth with no debris & no voids	Sealant Thickness (Back) .040" ± .005"	Sealant Thickness (Sides) .045 min.	No finger prints moisture, debris gaps, or voids	Width ± .005"	Splay ± .005 Total	Swage .030 - .035 less than spacer w	Corner Flare (none)	Corner Crease Location	No Over or Back Bent Corners	Overall Size of Folded Frame

B. Fabricated Items

2. Spacer (Dual Seal) Before Assembly

					Matrix			Prima	ry Seal			S	pacer			
Operator Initials	Date/Time	Shift	Adhesion Check 1	Adhesion Check 2	Matrix Thickness (Depends On Type)	Matrix filled side to side	Matrix surface smooth with no debris, voids or globs	Primary Sealant Bead Thickness (Sides) .045 min.	No finger prints moisture, debris gaps, or voids	Width ± .005"	Splay ± .005"Total	Swage .030 - .035 less than spacer w	Corner Flare (none)	Corner Crease Location	No Over or Back Bent Corners	Overall Size of Folded Frame

Daily IG Unit Checklist and Recording Form
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Inspected by:	Shift#:	1 2	3		Da	ate:		Tir	ne:		Line Total
	1	2	3	4	5	6	7	8	9	10	
Glass Alignment & Overall Size Tolerance: ±1/32" or as agreed on by customer & manufacturer											
Overall Unit Thickness Corner, edge, center tolerance:Nominal ±1/32											
No Spacer Exposed No spacer beyond glass edges and no "shiners"											
Squeeze-Out Maximum 1/16" past edge of glass (unit must fit in sash)											
Seal Width 3/16" minimum on Spacer No voids, debris, air bubbles, or burrs within 3/16" seal											
Matrix Bead Appearance Edge to edge fill with smooth top surface - no globs											
Glass & Coating Coating on proper surface, no visual defects, proper deletion, clean											
Shell Chips 1/4" maximum (only 1 per unit)											
No Cracks or Scratches None visible at arms length (5 second scan)											
IG Unit Squareness Maximum 1/16"											
Ink Jet Printing Proper info./no smudging/properly aligned											
Muntins Centered within glass, no debris, no rattle, clips pushed in											
Gas Fill Plug Covered Sealant over gas fill plug (check with leak detector)											
Gas Fill Level 95% min. or as specified by customer											
Put X in box for any unit which does not meet all specs	-		Tests:						Total	defects	
If unit does not meet all specs. repair or dispose	of unit		Seal Ad	thesion:				To	tal defecti	ve units	

B. Fabricated Items

Seal Adhesion:		
Immersion:		