

V. Recording Forms

A. Incoming Material

8. Muntin Bars and Clips

Quality Assurance

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

V. Recording Forms

B. Fabricated Items

3. Daily IG Unit

Quality Assurance

Daily IG Unit Checklist and Recording Form

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