

## VI. Quality SOP Lists

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Quality Assurance



In this section are lists of Quality standard operating procedures (SOP) for each of your work stations in your Intercept® IG production line. These procedures are quality items which should be checked on an on-going basis at each work station. Many of the checks are visual only or can be done quickly with a simple “go, no-go” gauge. You may choose to add other items to each list depending on your needs.

In section VII, you will find Quality SOP Posters, which may be printed on 8-1/2” X 11” card stock, then posted in a highly visible location where they can be easily read by each person at the work station.

The SOP posters are not intended to be used in lieu of quality checklists and recording forms, but only as a supplement to them and can serve as reminders of what the basic quality responsibilities are at each work station.

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## Operator of *Intercept*<sup>TM</sup> Spacer Equipment

1. Check order entry.
2. Check strip width.
3. Check machine setups.
4. Check spacer size and shape.
5. Check punches and cutoff.
6. Check sealant thickness and location.
7. Check final corner and gas hole  
sealant skip size.
8. Check matrix thickness and fill.
9. Check matrix adhesion.
10. Check dimensions of folded spacer.
11. Check corners of folded spacer.
12. \_\_\_\_\_
13. \_\_\_\_\_

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## Spacer Folder

1. Check corner-bends, closing corner.
2. Check spacer dimensions-undercut.
3. Check sealant size, shape, location.
4. Mend sealant at 4th corner.
5. Check desiccant size, shape, location.
6. Check ink-jet location & information.
7. Monitor sealant & matrix temperatures.
8. Check punches and cutoff.
9. Check matrix adhesion.
10. Check muntin bar notch locations.
11. Feedback.
12. \_\_\_\_\_
13. \_\_\_\_\_

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### Muntin Bar Fabricator

1. Check size, shape.
2. Check clip fit in spacer & muntin bar.
3. Check cross fit.
4. Check for burrs at ends & crosses.
5. Check for dirt & debris.
6. Check for scratches.
7. Check for other damage-dents, bends.
8. Check notch size at intersections.
9. Feedback.
10. \_\_\_\_\_
11. \_\_\_\_\_
12. \_\_\_\_\_

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## Muntin Bar Installer

1. Check clip fit in spacer & muntin bar.
2. Push clip in all the way.
3. Check for burrs at ends & crosses.
4. Check for dirt & debris.
5. Check for scratches.
6. Check for other damage-dents, bends.
7. Check length of muntin bar.
8. Check number of Verticals & Horizontals against order.
9. Quick visual check of spacer.
10. Feedback.
11. \_\_\_\_\_
12. \_\_\_\_\_

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## Spacer Layup

1. Check glass – size, thickness, squareness, cleanliness, coating surface, edge deletion, edge quality, chips, scratches.
2. Check spacer – size, corners, sealant & desiccant.
3. Check spacer offset (gauge block).
4. Check muntin bars – burrs, scratches, dirt, debris, dents, bends.
5. Check muntin bar clips – pushed in, snapped into spacer.
6. Feedback.
7. \_\_\_\_\_
8. \_\_\_\_\_

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## Sealers (dual seal)

1. Check glass – size, thickness, squareness, cleanliness, coating surface, edge deletion, edge quality, chips, scratches.
2. Check glass mis-match.
3. Check spacer offset (gauge block).
4. Check sightline (gauge block).
5. Check spacer corner bends.
6. Check PIB – thickness, width, skips, voids.
7. Check corner seals (primary).
8. Check that spacer is covered completely.
9. Check that corners are filled.
10. Feedback.
11. \_\_\_\_\_
12. \_\_\_\_\_

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## Exit End (Dual Seal)

1. Check glass mis-match and edge quality.
2. Check sightline.
3. Check PIB/primary – wetout width, skips, voids.
4. Check corner seals (primary).
5. Check coverage of spacer.
6. Check that corners are filled.
7. Cut away excess sealant.
8. Fill voids.
9. Feedback.
10. \_\_\_\_\_
11. \_\_\_\_\_
12. \_\_\_\_\_



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## Exit End Single Seal- HMB and DSE

1. Check glass mis-match and edge quality.
2. Check sightline.
3. Check sealant – wetout width, skips, voids.
4. Check for exposed metal at corners.
5. Mend 4th corner if needed.
6. Check sealant on back of spacer (full coverage).
7. If sealant skip dimension at gas fill hole is wrong, notify Intercept operator.
8. Feedback.
9. \_\_\_\_\_
10. \_\_\_\_\_
11. \_\_\_\_\_

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### Glass Washing

1. Check glass type.
2. Check glass size.
3. Check thickness.
4. Check edge quality.
5. Check for edge damage.
6. Check edge deletion.
7. Check coating and proper orientation on rolls.
8. Check cleanliness.
9. \_\_\_\_\_
10. \_\_\_\_\_
11. \_\_\_\_\_

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### Glass Cutting

1. Check glass type.
2. Check thickness.
3. Check size.
4. Check for edge damage after breakout.
5. Check coating type.
6. Check coating for damage and defects.
7. Check edge cut quality (See PPG Poster).
8. \_\_\_\_\_
9. \_\_\_\_\_