Nadcap

AUDIT CRITERIA

AC7117/3 REV. A

Issued 2006-11

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Superseding AC7117/3

161Thorn Hill Road
Warrendale, PA 15086-7527

TO BE USED ON AUDITS STARTING ON OR AFTER JANUARY 18, 2015

Nadcap
AUDIT CRITERIA FOR
PEEN FORMING

Editorial Change made to 8.2 on October 15, 2015

1. SCOPE

This audit criterion is used to survey a facility seeking Nadcap accreditation for the peen forming method. This process method checklist shall be used in conjunction with AC7117.

2. GENERAL INSTRUCTIONS

See AC7117 Section 2.

3. SUBSCRIBER SPECIFIC SUPPLEMENTS — SECTION NA

3.1 Instructions for the Auditors

3.1.1 In completing the prime specific assessment, Auditors are instructed to respond with a “YES” or “NO” to address compliance with each statement or requirement. For any negative responses, the Auditor must clearly indicate if the “NO” reflects noncompliance with respect to existence, adequacy, and/or compliance. Existence relates to documented procedure or policy, and compliance relates to evidence of effective implementation. The “NA” option is used only when the question is not applicable to the Supplier process. Choosing the “NA” option requires an explanation note.

3.1.2 The Auditor shall apply the questions in the supplemental checklist only to the Suppliers who specify the Customer end-users in the audit scope selection herein.

- ☐ U0 – User Unknown
- ☐ U10 – GE Aviation
- ☐ U00 – None
- ☐ U8 – Airbus
- ☐ U11 – The Boeing Company

3.2	U8 – Airbus Supplement *Note: If no peen forming is performed for Airbus check the box to collapse the U8 section.*	SECTION NA		
3.2.1	There are no Airbus (U8) supplement questions for Peen Forming.			
3.3	U10 – GE Aviation Supplement *Note: If no peen forming is performed for GE Aviation check the box to collapse the U10 section.*	SECTION NA		
3.3.1	There are no GE Aviation (U10) supplement questions for Peen Forming.			
3.4	U11 – The Boeing Company Supplement *Note: If no peen forming is performed for The Boeing Company check the box to collapse the U11 section.*	SECTION NA		
3.4.1	(U11) Does the Supplier have controls to ensure that pre-stressing of parts to be shot peen formed do not exceed the elastic limits of the material as required per applicable specifications? *NA only for parts that are not pre-stressed.*	YES	NO	NA
3.4.2	(U11) Does the Supplier verify that sharp edges are radiused prior to peen forming?	YES	NO	
3.4.3	(U11) Are shot peen formed parts inspected for rollover and bulging?	YES	NO	
3.4.4	(U11) Is surface roughness being measured after peen forming to meet the drawing requirements?	YES	NO	NA
4.	**EQUIPMENT** *No additional audit criteria.*			
5.	**ALMEN** *No additional audit criteria.*			
6.	**MEDIA**			
6.1	When large or nonstandard peening media are used for peen forming applications, do they meet applicable specification?	YES	NO	NA
7.	**PERSONNEL**			
7.1	Operator Qualification			
7.1.1	Does the Supplier have a documented procedure which prevents an unqualified operator to perform peen forming?	YES	NO	
8.	**GENERAL PROCEDURES**			
8.1	Records			

8.1.1	Does the Supplier have written procedures to ensure the identity of the specific operator; time, date of start and completion is recorded and retrievable?	YES	NO	
8.1.2	When manual peening is used for peen forming, are there Supplier procedures that control whether the use complies with the Customer requirements?	YES	NO	NA
8.2	Software Quality Assurance *For the purpose of this check sheet, "software" is intended to only cover part-specific process control software (e.g. NC Programs).* *This section applies to Suppliers and processes where the approved process controls are based, at least partially, on a stored and retrieved program or program listing. Typically, these programs are loaded and executed on the peening machine.*	SECTION NA		
8.2.1	Is there a written procedure for the control of software?	YES	NO	
8.2.2	Is each program uniquely identified?	YES	NO	
8.2.3	Is there a revision history maintained of changes to a program?	YES	NO	
8.2.4	Is the program revision identified in the router or operation sheet/work instruction to allow operator to verify against the control header?	YES	NO	
8.2.5	Is there an approval process for new and modified programs?	YES	NO	
8.2.6	Is new or changed program validation (1st piece) approved by quality and records maintained in accordance with the Suppliers quality system and Customer requirements?	YES	NO	
8.2.7	Are the storage requirements for software programs used to control and monitor the product defined and preserved in a way to prevent loss?	YES	NO	
8.2.8	Is there a system in place to prevent unauthorized changes to a program after first piece inspection has been completed and approved?	YES	NO	
8.2.9	Is there a system in place to prevent access to obsolete software?	YES	NO	
8.3	Internal Procedures			
8.3.1	When pre-stress peening is used for forming, are there Supplier procedures that control the use and compliance with Prime requirements?	YES	NO	NA
8.3.2	When surface finish is measured after peen forming, is there Supplier procedures that control the methods and equipment used to measure surface finish?	YES	NO	NA

8.3.3	When surface finish is improved after peen forming, is there Supplier procedures that control the methods used to improve the surface finish? (e.g. sanding, buffing, etc.)	YES	NO	NA

9. JOB AUDIT #1

9.1 Job Information

9.1.1 Since peen forming jobs are frequently performed in combination with compression peening using one of the other AC7117 methods (e.g. Automated peening), it is recommended that the same part peening jobs be audited for this job and the associated peening method.

9.1.2 Complete the following and then check the Supplier's information (technique sheets, travelers) against the purchasing requirements.

9.1.2.1 Job Identity/Number: _____

9.1.2.2 Technique ID: _____

9.1.2.3 Generic Part Description: _____

9.1.2.4 Part Number and Revision level (if applicable): _____

9.1.2.5 Immediate Customer: _____

9.1.2.6 End User (Prime) (If known): _____

9.1.2.7 Purchase Order/Revision Level: _____

9.1.2.8 Part Quantity: _____

9.1.2.9 Serial/Lot Numbers (if provided): _____

9.1.2.10 Start Date of Job: _____

9.1.2.11 Processing Specification and Revision Level: _____

9.1.2.12 Special Purchase Order Requirements: _____

9.1.2.13 Is the job audit part live production, demonstration or previously processed? _____

9.1.2.14 What Export Control Status did the Supplier identify the part as being? _____

9.1.2.15 What status did the Auditor(s) identify themselves as being in the opening meeting? (Restricted or Unrestricted) _____

9.1.2.16 If this job audit is done in combination with another peening method job audit, record the other job number reference here. _____

9.2 Customer Requirements

9.2.1 Are the engineering requirements provided from the purchase order, or in a variety of other forms, flowed down to the shop? YES NO

9.2.2	Are media size and type flowed down to the shop floor?	YES	NO	
9.2.3	Are intensity and strip type flowed down to the shop floor?	YES	NO	NA
9.2.4	Are peening required areas, optional areas, and/or prohibited areas flowed down to the shop floor?	YES	NO	
9.2.5	Is the amount of part coverage flowed down to the shop floor?	YES	NO	NA
9.2.6	Is pre-peen dimensional controls (e.g. fit tolerance), flowed down to the shop floor?	YES	NO	
9.2.7	Are post-peen dimensional controls areas flowed down to the shop floor?	YES	NO	
9.3	Implementation of Supplier Procedures			
9.3.1	Is the peening operation at this facility performed in the correct sequence as allowed by the traveler?	YES	NO	
9.3.2	Have the required Customer approval(s) been obtained for the current technique sheet?	YES	NO	NA
9.3.3	Are all operations, inspections, and tests performed prior to peening recorded on the traveler or electronic form, stamped, signed, or initialed and including date?	YES	NO	
9.3.4	If there are changes in travelers and/or technique sheets, are they approved and dated by authorized personnel?	YES	NO	NA
9.3.5	Do the personnel, who are performing peen forming, and/or saturation peening operations, and final inspections have the required training and qualification?	YES	NO	
9.3.6	Do all gages used to measure parameters in the technique sheet have current calibration identification?	YES	NO	
9.3.7	Are gages that are not calibrated labeled as “reference only” or similarly marked?	YES	NO	NA
9.3.8	Are Almen, part holding, masking, and nozzle fixtures compliant to applicable specifications?	YES	NO	
9.3.9	Is the operator capable of identifying equipment malfunctions?	YES	NO	
9.3.10	Does the operator know how to proceed when there is an equipment malfunction or automatic shut down?	YES	NO	
9.4	Pre-Processing			
9.4.1	Does the Supplier visually inspect the area to be peened for the absence of sharp edges, corrosion, contamination or damage prior to peening and were appropriate actions taken?	YES	NO	

9.4.2	Do the pre-peening cleaning methods used conform to the Customer requirements?	YES	NO	NA
9.4.3	During the job audit, the Auditor shall witness the following pre-processing tasks.			
9.4.3.1	Did the operator and/or appropriate personnel demonstrate proficiency in applying the masking requirements to the parts?	YES	NO	NA
9.4.3.2	Did the operator and/or appropriate personnel demonstrate proficiency in equipment usage and fixture usage?	YES	NO	
9.4.3.3	Did the operator and/or appropriate personnel demonstrate proficiency in the use of Almen gage and Almen strip?	YES	NO	NA
9.4.3.4	Did the operator and/or appropriate personnel demonstrate proficiency in the use of Almen strip fixtures?	YES	NO	NA
9.4.3.5	Did the operator and/or appropriate personnel demonstrate proficiency in calculating the resultant arc height (if pre-bow compensation method is used)?	YES	NO	NA
9.4.4	Are periodic media quality inspections performed at the required intervals?	YES	NO	
9.5	Processing			
9.5.1	Are parts processed in accordance with a technique sheet?	YES	NO	
9.5.2	Does the technique sheet document all relevant operations performed by the operator?	YES	NO	
9.5.3	Do the Almen fixture locations represent the surfaces to be peened?	YES	NO	NA
9.5.4	When used, does the Almen fixture being used provide the same number, type, location, and orientation of the Almen strips described in the technique sheet?	YES	NO	NA
9.6	Technique Sheet and Shop Floor Discipline			
9.6.1	Is the job audit part number specified on the technique sheet and correctly followed in production?	YES	NO	
9.6.2	Is the job audit technique sheet revision controlled and correctly followed in production?	YES	NO	
9.6.3	Are job audit part program(s) with revision identified on the technique sheet and being followed in production?	YES	NO	NA
9.6.4	Are approvals from both Supplier and Customer on the job audit technique sheet and does the technique sheet have required approvals?	YES	NO	NA

9.6.5	Are part specific tooling and fixtures identified on the technique sheet and correctly followed in production?	YES	NO	
9.6.6	Are Almen fixtures identified on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.7	Is part masking identified on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.8	Is the identification of peening equipment listed on the technique sheet and correctly followed in production?	YES	NO	
9.6.9	Is number of nozzles or wheels listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.10	Is air pressure or wheel speed listed on the technique sheet and correctly followed in production?	YES	NO	
9.6.11	Is nozzle size listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.12	Is air jet size listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.13	Is part rotation or translation rate listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.14	Are setup sketches or photos listed on the technique sheet and is the observed set up in the job audit accurately described?	YES	NO	
9.6.15	Is nozzle or wheel translation speed listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.16	Is travel direction, and travel distance to the part listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.17	Is nozzle or wheel position to the part listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.18	Is the part orientation setup relative to the machine listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.19	Is shot flow control listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.20	Is shot flow value listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.21	Is part peening time (or cycles) listed on the technique sheet and correctly followed in production?	YES	NO	
9.6.22	Is Almen strip peening time (or cycles) listed on the technique sheet and correctly followed in production?	YES	NO	NA

9.6.23	Is media size, hardness, and type listed on the technique sheet and correctly followed in production?	YES	NO	
9.6.24	Is required intensity and test strip type listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.25	Is the amount of coverage listed on the technique sheet and correctly followed in production?	YES	NO	NA
9.6.26	When compression peening is performed with peen forming, is the minimum intensity of the compression peening met?	YES	NO	NA
9.7	Process Validation			
9.7.1	Does the Supplier process substantiation data include a saturation curve consisting of a minimum of 4 points (not including “0” point) for each intensity determination location?	YES	NO	NA
9.7.2	Does the Supplier process substantiation data include intensity verification tests performed at required intervals?	YES	NO	NA
9.7.3	Does the Supplier process substantiation data include appropriate actions (e.g. accept/reject) based on the job audit Almen strip readings?	YES	NO	NA
9.7.4	Verify the following values for two Almen locations or if applicable a single location at two times for the job audit part.			
9.7.4.1	Are the observed Almen strip locations used to verify the intensity correctly located?	YES	NO	NA
9.7.4.2	Is the observed Almen strip type used to verify the intensity correct?	YES	NO	NA
9.7.4.3	Is the observed intensity value compliant to the Customer intensity requirement?	YES	NO	NA
9.7.4.4	Is the observed intensity verification range compliant to requirements?	YES	NO	NA
9.7.4.5	Is the observed initial Almen reading compliant to requirements?	YES	NO	NA
9.7.4.6	Is the observed intermediate Almen reading compliant to requirements?	YES	NO	NA
9.7.4.7	Is the observed final Almen reading compliant to requirements?	YES	NO	NA
9.7.5	For one of the job audits, the Auditor shall witness the generation of saturation curve data and media inspections to verify that the following are correct.			
9.7.5.1	Does the generation of the saturation curve utilize of a minimum of 4 points for each intensity determination location (not including the zero point)?	YES	NO	NA
9.7.5.2	Are the practices of SAE J443 followed?	YES	NO	NA

9.7.5.3	Does the media inspection verify shot size by sieve analysis?	YES	NO	
9.7.5.4	Does the media inspection verify shot fracture counts and shape inspection?	YES	NO	
9.8	Post Peening Inspection			
9.8.1	When required, did the operator and/or appropriate personnel demonstrate proficiency during the inspection of fluorescent tracer?	YES	NO	NA
9.8.2	When required, did the operator and/or appropriate personnel demonstrate proficiency during part inspection for coverage using magnification and other inspection aids?	YES	NO	NA
9.8.3	When required, is final inspection for coverage and effectiveness of applicable masking performed?	YES	NO	NA
9.8.4	When compression peening is performed with peen forming, is complete compression peening coverage controlled in the required areas?	YES	NO	NA
9.8.5	Are part serial numbers maintained throughout the peening operation?	YES	NO	NA
9.8.6	Do the post-peening cleaning methods used conform to the Customer requirements?	YES	NO	NA
9.8.7	Were parts handled, stored, and transported in a manner to prevent damage?	YES	NO	
9.8.8	Did final inspection result in the proper disposition of the part(s) audited?	YES	NO	
9.8.9	Did an inspection check that the part is free from media debris (internal and external), masking residue, edge rollover, and handling damage and were appropriate actions taken?	YES	NO	
9.8.10	Is the traveler properly completed prior to the part continuing to the next operation or shipment to the Customer?	YES	NO	
9.8.11	When required, does the certification that is returned to the Customer meet the Customer requirements?	YES	NO	NA
9.8.12	(INFO) If YES record the Certification number here:	_____		

10.	JOB AUDIT #2	SECTION NA
10.1	Job Information	
10.1.1	Since peen forming jobs are frequently performed in combination with compression peening using one of the other AC7117 methods (e.g. Automated peening), it is recommended that the same part peening jobs be audited for this job and the associated peening method.	
10.1.2	Complete the following and then check the Supplier's information (technique sheets, travelers) against the purchasing requirements.	
10.1.2.1	Job Identity/Number:	_____
10.1.2.2	Technique ID:	_____
10.1.2.3	Generic Part Description:	_____
10.1.2.4	Part Number and Revision level (if applicable):	_____
10.1.2.5	Immediate Customer:	_____
10.1.2.6	End User (Prime) (If known):	_____
10.1.2.7	Purchase Order/Revision Level:	_____
10.1.2.8	Part Quantity:	_____
10.1.2.9	Serial/Lot Numbers (if provided):	_____
10.1.2.10	Start Date of Job:	_____
10.1.2.11	Processing Specification and Revision Level:	_____
10.1.2.12	Special Purchase Order Requirements:	_____
10.1.2.13	Is the job audit part live production, demonstration or previously processed?	_____
10.1.2.14	What Export Control Status did the Supplier identify the part as being?	_____
10.1.2.15	What status did the Auditor(s) identify themselves as being in the opening meeting? (Restricted or Unrestricted)	_____
10.1.2.16	If this job audit is done in combination with another peening method job audit, record the other job number reference here.	_____
10.2	Customer Requirements	
10.2.1	Are the engineering requirements provided from the purchase order, or in a variety of other forms, flowed down to the shop?	YES NO

10.2.2	Are media size and type flowed down to the shop floor?	YES	NO	
10.2.3	Are intensity and strip type flowed down to the shop floor?	YES	NO	NA
10.2.4	Are peening required areas, optional areas, and/or prohibited areas flowed down to the shop floor?	YES	NO	
10.2.5	Is the amount of part coverage flowed down to the shop floor?	YES	NO	NA
10.2.6	Is pre-peen dimensional controls (e.g. fit tolerance), flowed down to the shop floor?	YES	NO	
10.2.7	Are post-peen dimensional controls areas flowed down to the shop floor?	YES	NO	
10.3	Implementation of Supplier Procedures			
10.3.1	Is the peening operation at this facility performed in the correct sequence as allowed by the traveler?	YES	NO	
10.3.2	Have the required Customer approval(s) been obtained for the current technique sheet?	YES	NO	NA
10.3.3	Are all operations, inspections, and tests performed prior to peening recorded on the traveler or electronic form, stamped, signed, or initialed and including date?	YES	NO	
10.3.4	If there are changes in travelers and/or technique sheets, are they approved and dated by authorized personnel?	YES	NO	NA
10.3.5	Do the personnel, who are performing peen forming, and/or saturation peening operations, and final inspections have the required training and qualification?	YES	NO	
10.3.6	Do all gages used to measure parameters in the technique sheet have current calibration identification?	YES	NO	
10.3.7	Are gages that are not calibrated labeled as “reference only” or similarly marked?	YES	NO	NA
10.3.8	Are Almen, part holding, masking, and nozzle fixtures compliant to applicable specifications?	YES	NO	
10.3.9	Is the operator capable of identifying equipment malfunctions?	YES	NO	
10.3.10	Does the operator know how to proceed when there is an equipment malfunction or automatic shut down?	YES	NO	
10.4	Pre-Processing			
10.4.1	Does the Supplier visually inspect the area to be peened for the absence of sharp edges, corrosion, contamination or damage prior to peening and were appropriate actions taken?	YES	NO	

10.4.2	Do the pre-peening cleaning methods used conform to the Customer requirements?	YES	NO	NA
10.4.3	During the job audit, the Auditor shall witness the following pre-processing tasks.			
10.4.3.1	Did the operator and/or appropriate personnel demonstrate proficiency in applying the masking requirements to the parts?	YES	NO	NA
10.4.3.2	Did the operator and/or appropriate personnel demonstrate proficiency in equipment usage and fixture usage?	YES	NO	
10.4.3.3	Did the operator and/or appropriate personnel demonstrate proficiency in the use of Almen gage and Almen strip?	YES	NO	NA
10.4.3.4	Did the operator and/or appropriate personnel demonstrate proficiency in the use of Almen strip fixtures?	YES	NO	NA
10.4.3.5	Did the operator and/or appropriate personnel demonstrate proficiency in calculating the resultant arc height (if pre-bow compensation method is used)?	YES	NO	NA
10.4.4	Are periodic media quality inspections performed at the required intervals?	YES	NO	
10.5	Processing			
10.5.1	Are parts processed in accordance with a technique sheet?	YES	NO	
10.5.2	Does the technique sheet document all relevant operations performed by the operator?	YES	NO	
10.5.3	Do the Almen fixture locations represent the surfaces to be peened?	YES	NO	NA
10.5.4	When used, does the Almen fixture being used provide the same number, type, location, and orientation of the Almen strips described in the technique sheet?	YES	NO	NA
10.6	Technique Sheet and Shop Floor Discipline			
10.6.1	Is the job audit part number specified on the technique sheet and correctly followed in production?	YES	NO	
10.6.2	Is the job audit technique sheet revision controlled and correctly followed in production?	YES	NO	
10.6.3	Are job audit part program(s) with revision identified on the technique sheet and being followed in production?	YES	NO	NA
10.6.4	Are approvals from both Supplier and Customer on the job audit technique sheet and does the technique sheet have required approvals?	YES	NO	NA

10.6.5	Are part specific tooling and fixtures identified on the technique sheet and correctly followed in production?	YES	NO	
10.6.6	Are Almen fixtures identified on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.7	Is part masking identified on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.8	Is the identification of peening equipment listed on the technique sheet and correctly followed in production?	YES	NO	
10.6.9	Is number of nozzles or wheels listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.10	Is air pressure or wheel speed listed on the technique sheet and correctly followed in production?	YES	NO	
10.6.11	Is nozzle size listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.12	Is air jet size listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.13	Is part rotation or translation rate listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.14	Are setup sketches or photos listed on the technique sheet and is the observed set up in the job audit accurately described?	YES	NO	
10.6.15	Is nozzle or wheel translation speed listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.16	Is travel direction, and travel distance to the part listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.17	Is nozzle or wheel position to the part listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.18	Is the part orientation setup relative to the machine listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.19	Is shot flow control listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.20	Is shot flow value listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.21	Is part peening time (or cycles) listed on the technique sheet and correctly followed in production?	YES	NO	
10.6.22	Is Almen strip peening time (or cycles) listed on the technique sheet and correctly followed in production?	YES	NO	NA

10.6.23	Is media size, hardness, and type listed on the technique sheet and correctly followed in production?	YES	NO	
10.6.24	Is required intensity and test strip type listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.25	Is the amount of coverage listed on the technique sheet and correctly followed in production?	YES	NO	NA
10.6.26	When compression peening is performed with peen forming, is the minimum intensity of the compression peening met?	YES	NO	NA
10.7	Process Validation			
10.7.1	Does the Supplier process substantiation data include a saturation curve consisting of a minimum of 4 points (not including “0” point) for each intensity determination location?	YES	NO	NA
10.7.2	Does the Supplier process substantiation data include intensity verification tests performed at required intervals?	YES	NO	NA
10.7.3	Does the Supplier process substantiation data include appropriate actions (e.g. accept/reject) based on the job audit Almen strip readings?	YES	NO	NA
10.7.4	Verify the following values for two Almen locations or if applicable a single location at two times for the job audit part.			
10.7.4.1	Are the observed Almen strip locations used to verify the intensity correctly located?	YES	NO	NA
10.7.4.2	Is the observed Almen strip type used to verify the intensity correct?	YES	NO	NA
10.7.4.3	Is the observed intensity value compliant to the Customer intensity requirement?	YES	NO	NA
10.7.4.4	Is the observed intensity verification range compliant to requirements?	YES	NO	NA
10.7.4.5	Is the observed initial Almen reading compliant to requirements?	YES	NO	NA
10.7.4.6	Is the observed intermediate Almen reading compliant to requirements?	YES	NO	NA
10.7.4.7	Is the observed final Almen reading compliant to requirements?	YES	NO	NA
10.7.5	For one of the job audits, the Auditor shall witness the generation of saturation curve data and media inspections to verify that the following are correct.			
10.7.5.1	Does the generation of the saturation curve utilize of a minimum of 4 points for each intensity determination location (not including the zero point)?	YES	NO	NA
10.7.5.2	Are the practices of SAE J443 followed?	YES	NO	NA

10.7.5.3	Does the media inspection verify shot size by sieve analysis?	YES	NO	
10.7.5.4	Does the media inspection verify shot fracture counts and shape inspection?	YES	NO	
10.8	Post Peening Inspection			
10.8.1	When required, did the operator and/or appropriate personnel demonstrate proficiency during the inspection of fluorescent tracer?	YES	NO	NA
10.8.2	When required, did the operator and/or appropriate personnel demonstrate proficiency during part inspection for coverage using magnification and other inspection aids?	YES	NO	NA
10.8.3	When required, is final inspection for coverage and effectiveness of applicable masking performed?	YES	NO	NA
10.8.4	When compression peening is performed with peen forming, is complete compression peening coverage controlled in the required areas?	YES	NO	NA
10.8.5	Are part serial numbers maintained throughout the peening operation?	YES	NO	NA
10.8.6	Do the post-peening cleaning methods used conform to the Customer requirements?	YES	NO	NA
10.8.7	Were parts handled, stored, and transported in a manner to prevent damage?	YES	NO	
10.8.8	Did final inspection result in the proper disposition of the part(s) audited?	YES	NO	
10.8.9	Did an inspection check that the part is free from media debris (internal and external), masking residue, edge rollover, and handling damage and were appropriate actions taken?	YES	NO	
10.8.10	Is the traveler properly completed prior to the part continuing to the next operation or shipment to the Customer?	YES	NO	
10.8.11	When required, does the certification that is returned to the Customer meet the Customer requirements?	YES	NO	NA
10.8.12	(INFO) If YES record the Certification number here:	_____		