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Process Audit Worksheet

Note: To return to the DoE Tool, press in upper left hand corner of this screen.

General:

|  |  |  |  |
| --- | --- | --- | --- |
| Audited By: |  | Date: |  |

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| Plant: |  | Station Number: |  | Job Number: |  |

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| Power Supply Model: |  | S/N: |  |  | Initiation: |
|  |  |  |  |  |  |
| Weld Head Model: |  | S/N: |  |  |  |

**Weld Materials:**

|  |  |  |  |
| --- | --- | --- | --- |
| Material 1: | Top | Material 2: | Bottom |
| ⮚ Name: |  | ⮚ Name: |  |
| ⮚ Part Number: |  | ⮚ Part Number: |  |
| ⮚ Base Material: |  | ⮚ Base Material: |  |
| ⮚ Plating Type: |  | ⮚ Plating Type: |  |
| ⮚ Plating Thickness: |  | ⮚ Plating Thickness: |  |
| ⮚ Size: |  | ⮚ Size: |  |
| ⮚ Approved Source: |  | ⮚ Approved Source: |  |

**Weld Head:**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| Electrode 1: |  | | Electrode 2: |  | |
| ⮚ Part Number: |  | | ⮚ Part Number: |  | |
| ⮚ Material: |  | | ⮚ Material: |  | |
| ⮚ Face Size: |  | | ⮚ Face Size: |  | |
| ⮚ Face Shape: |  | | ⮚ Face Shape: |  | |
| ⮚ Tip Length: |  | | ⮚ Tip Length: |  | |
| ⮚ Condition: |  | | ⮚ Condition: |  | |
| ⮚ Polarity: |  | | ⮚ Polarity: |  | |
| ⮚ Stroke: |  | | ⮚ Stroke: |  | |
| ⮚ Down Speed: |  | | ⮚ Down Speed: |  | |
| ⮚ Force Tube Setting: |  | | ⮚ Force Tube Setting: |  | |
| ⮚ Firing Force: |  | | ⮚ Firing Force: |  | |
| ⮚ Air Pressure Setting: |  | | ⮚ Air Pressure Setting: |  | |
| ⮚ Welding Force: |  | | ⮚ Welding Force: |  | |
| ⮚ Weld Cable Length: |  | | ⮚ Weld Cable Length: |  | |
| ⮚ Weld Cable Gauge: |  | | ⮚ Weld Cable Gauge: |  | |
| ⮚ Weld Cable Condition: | |  | ⮚ Weld Cable Condition: | |  |
| ⮚ V Sense Cable Mount: | |  | ⮚ V Sense Cable Mount: | |  |

**Power Supply:**

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | SQZ | UP1 | | WELD1 | DOWN1 | | COOL | UP2 | | WELD2 | DOWN2 | | HOLD |
| Energy: |  |  |  | | |  |  |  |  | | |  |  |
| Time (ms): |  |  | |  |  | |  |  | |  |  | |  |
| Upper Limit: |  |  |  | | |  |  |  |  | | |  |  |
| Lower Limit: |  |  |  | | |  |  |  |  | | |  |  |

Monitor Features Used:  Pre-Weld  Active Part Conditioner (APC)  Energy Limit

|  |  |  |  |
| --- | --- | --- | --- |
| Switch Debounce Time: |  | Footswitch Weld Abort: |  |

**Process:**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Cover Gas Used? | Yes | No | Type of Cover Gas: |  |

|  |  |  |  |
| --- | --- | --- | --- |
| Repetition Rate: | parts per | Production Schedule: | per day |

|  |  |  |  |
| --- | --- | --- | --- |
| Part positioning method: |  | Fixture Model #: |  |
| Part Overlap: |  | Overlap Tolerance: |  |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| Electrode Cleaning Frequency: | | |  | | Cleaning Method: |  |
| Electrode Cleaning Tools: | |  | | | Replacement Criteria: |  |
| Electrode Gap: |  | | | Gap Measurement Tool: | |  |

**Quality Requirements:**

|  |  |  |  |
| --- | --- | --- | --- |
| Pull Strength Requirement: |  | Pull Test Configuration: |  |
| Pull Test Frequency: |  | Pull Test Method: |  |
| Rate of Pull: |  | Pull Test Equipment: |  |

|  |  |  |  |
| --- | --- | --- | --- |
| Weld Spot Location: |  | Weld Spot Size: |  |

|  |  |
| --- | --- |
| Visual Acceptance Criteria: |  |

Notes/Sketches: