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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: