

Inspection Instruction
for documented outgoing inspection
according to inscription in drawings
(DOI-Requirements)
II - N°: BGR6036
Version: f

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N°	Characteristic	Target	Method	Remark
1.1	All dimensions with fit tolerances e.g . H7, h6, n6 etc.	according to drawing	< 15mm checked by limit plug gauge or limit gap gauge > 15mm checked by a suitable measuring instrument (display accuracy 1 µm)	
2.1	All shape and positional tolerances	according to drawing	according to DIN standard book N° 7 "Anwendung der Normen über Form- und Lagetoleranzen in der Praxis" published by Beuth-Verlag	
3.1	Dimensions with tolerances within fundamental tolerance group < IT 10	according to drawing	the measuring instrument must be one decimal place more accurate than the tolerance to be measured	fundamental tolerance group according to DIN ISO 286 part 1
4.1	Surface finish of the vacuum flanges	Grooves or marks on vacuum sealing surfaces cross to shaping are not allowed	Vacuum sealing surfaces are marked in the drawing Sealing surfaces are tested with a surface roughness measuring instrument Sealing grooves are tested visually	
5.1	Dimensions to be tested and documented	according to drawing	Comparing resp. Measuring test	Dimensions to be tested and documented are circled in the drawing e.g. 100 +/- 0,01

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lfd.Nr.:	Merkmal	Soll	Methode	Bemerkung
6.1	Other requirements according to drawing	according to drawing (e. g. vacuum test, varnish, hydraulic pressure test, surface dressing etc.)	Vacuum test Varnishing: Pressure test: Surface dressing: qualification by LO acc. to LO standards acc. to LO standards acc. to LO standards	These test results have also to be documented.
6.2	Identification and traceability	The serial number of traceable parts and components (according to the drawing) is to find on the parts / components body and it is to document in the test protocol.	Visual test	

The test results have to be written down in documented outgoing inspection (DOI) protocol
resp. in suppliers quality documents (with similar structure).