

O&W HEAT TREAT, INC.

Uncontrolled General Distribution Document for Reference Only

Default Hardness Sampling Plan

This uncontrolled general distribution document outlines the default hardness sampling plan to be employed at O&W Heat Treat in the absence of a specified customer or specification sampling plan. The objective of this hardness sampling plan is to test sufficient pieces from strategically selected locations, taking into account the type of heat treat being performed and the type of product being tested, to detect variability in the heat treat process; at the same, the plan will reliably detect instances where an entire order has been made from the wrong material. When required by contract or purchase order, we will obtain pre-approval of this sampling plan from the customer prior to use. O&W certifications will in all cases specify the actual number of pieces tested; it is the customer's responsibility to verify that the total number of pieces tested complies with all applicable specification requirements.

Batch Size	Sample Size (AQL=2.5)
2 - 8	5
9 - 25	5 - 6
26 - 50	7
51 - 150	11
151 - 280	13
281 - 500	16
501 - 1200	19
1201 - 3200	23
3201 - 10000	29

Failure of any one part is cause for rejection of the entire lot.

Exceptions to Sampling Policy

There are several exceptions to the default sampling plan which may result in frequency increases / reductions. These exceptions include: tightened hardness ranges, high hardness parts, parts heat treated for machinability only (i.e., not final heat treat); uncertified/commercial jobs (e.g., tooling); rough blanks requiring excessive prep to hardness inspect (notify customer for prep assist); geometric restrictions; customer or P.O. specified sampling plans; SPC justified frequency reductions, destructive examination necessitated by part size or hardness call-out; no hardness call-out on P.O. (sampling for O&W information only); P.O.'s with multiple part numbers. Please contact us as needed for further details.