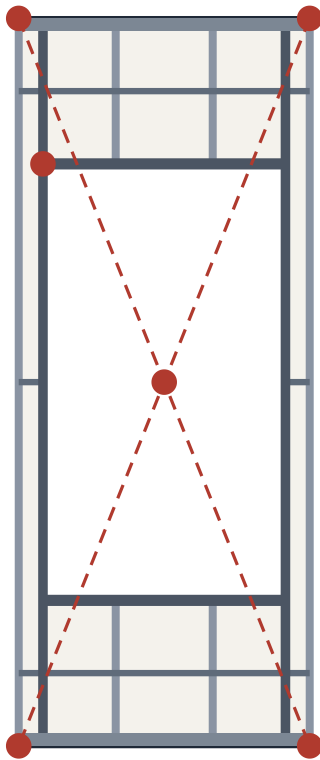


What good looks like and what gets rejected

Every panel gets measured after it is stripped, and the measured values get written down. Not a tick. A tick says somebody looked. A value says what they found, and it is the only thing that can be checked later.



Measure and write the value.

Every criterion below is [PE TO SET].

Red dots: the four corners, the centre and the opening head.

- 1 Length, both edges and the centreline
- 2 Width, both ends and mid height
- 3 Overall thickness at the stated points
- 4 Skin thickness at the panel edge
- 5 Opening size and both offsets
- 6 Squareness, both diagonals
- 7 Bow, in plane and out of plane
- 8 Twist, all four corners on a flat reference
- 9 Face flatness of the finish face
- 10 Insert position from two datums, where inserts exist
- 11 Cumulative run across the whole wall of panels

Where the post-strip measurements are taken on a panel.

The honest problem with this sheet

NOT SETTLED YET

Every acceptance criterion on this page is [PE TO SET]. There is no published dimensional tolerance and no published surface or defect criterion for a cast panel of this construction, in any source this program has found. The engineer of record sets them. **Do not write in a number you remember from precast, from drywall or from a job you worked somewhere else.** Record the measured value and let the quality manager carry the question.

What good looks like and what gets rejected (continued)

Surface and defects on the finish face

Defect	What gets judged	Criterion today
Cracks	Width, length, location, and whether it goes through the skin	[PE TO SET] acceptable, repairable, and reject widths
Voids and bugholes	Diameter, depth, how many per area	[PE TO SET]
Edge and corner damage	How far in from the edge	[PE TO SET]
Honeycomb or segregation	Any	[PE TO SET], normally not acceptable in a structural face
Exposed mesh	Any	[PE TO SET]
Insert or embedment out of position	Measured position against tolerance	Nonconforming. Dispositioned by the engineer of record.
Finish face flatness and texture	Against the reference sample panel	[KEN TO CONFIRM] the reference panel does not exist yet

STOP

There is no reference sample panel yet. One has to be cast, photographed and accepted in writing by Ken, the engineer of record and the third-party inspection agency, and kept in the plant as the thing everything else is compared to. Until that exists, "it looks right" is one person's opinion and nothing on paper can stand in for it.

Repair

A defect in the repairable class is repaired by the written repair procedure and re-inspected. [PE TO SET: the repair procedure, the repair material and its compatibility with 35 pcf cellular concrete, the surface preparation, the cure, and the limit beyond which repair is not allowed.] **A repair made without a written procedure is itself a nonconformance.** Do not patch a panel because it seemed like a small thing.

What good looks like and what gets rejected (continued)

When something fails

- 1 Tag it.
- 2 Move it to the hold area. It does not stay in the line and it does not go to the yard with the good ones.
- 3 Raise QF-22 Nonconformance report.
- 4 The quality manager dispositions it in writing. Where the deviation affects dead load or capacity, the engineer of record dispositions it, in writing.
- 5 Rework or repair is re-inspected against the same criterion by the same inspection.
- 6 The disposition and the re-inspection go on the traveler. The traveler carries the panel's whole history, including its failures.

Two rules about the paperwork that are not negotiable

- **A blank line on a traveler is an inspection that did not happen.** The panel does not advance past it.
- **A line signed in advance is a falsification.** It is a corrective action against the process and action against the person who signed it.

Release

Nothing leaves until the final inspection and release is signed on QF-20 Final unit inspection and release record, and **only the quality manager signs it**. Not the production lead, not the QC inspector, not the owner in a hurry.

THE RECORD YOU SIGN

QF-17 Panel dimensional and surface inspection for the measurements and the surface. QF-22 Nonconformance report when it fails. QF-20 Final unit inspection and release record to let it go.