

**PROCEDURE QUALIFICATION FOR
THERMAL CUTTING OF STEEL ARMOR**

Material		Specification
Rolled Homogeneous	<input type="checkbox"/>	MIL-DTL-12560
High Hardness	<input type="checkbox"/>	MIL-DTL-46100
Other	<input type="checkbox"/>	

Note: this does not apply to water jet cutting process

SUPPLIER NAME		
NAME OF OPERATOR	First Last	QUALIFICATION
PROCEDURE NO.	_____	DATE
REPORT REFERENCE ID.	_____	TEST DATE

VARIABLES	VALUES USED FOR QUALIFICATION	QUALIFIED RANGE
Material Heat/Lot	_____	
Process	_____	
Type (Manual or Automatic? Submerged?)	_____	
Electrode Type or Beam Source	_____	
Power Source Parameters	_____	
Current	_____	
Gas (Type and Flow)	_____	
Primary Shield	_____	
Primary Cutting	_____	
Other	_____	
Travel Speed	_____	
Min Preheat (Degrees F)	_____	
Postheat (Degrees F)	_____	
Final Process Temper (time & temp)	_____	
Material Thickness Tested	_____	
Post Cutting Processing	_____	
Type (Grinding, Machining, etc.)	_____	
Material Removal	_____	
VISUAL INSPECTION		
ACCEPTABLE	YES <input type="checkbox"/>	NO <input type="checkbox"/>
LIQUID PENETRANT OR MAGNETIC PARTICLE INSPECTION		
ACCEPTABLE	YES <input type="checkbox"/>	NO <input type="checkbox"/>
HAZ HARDNESS		
Calibration Expiration Date	_____	Plate Hardness (Rc or HB)
Hardness Scale	_____	Max Hardness (of 5 locations) (Rc or HB)
Interpreted By	_____	Min. Hardness (of 5 locations) (Rc or HB)
Organization	_____	Date
Distance from cut edge (Lesser of 1.2T or .625 inch)		_____
ACCEPTABLE	<input type="checkbox"/>	<div style="border: 1px solid black; width: 150px; height: 40px; margin: 0 auto;"></div> Vendor Authorized By _____ Date _____
SIGNATURE OF COMPANY REPRESENTATIVE		
NOT ACCEPTABLE	<input type="checkbox"/>	<div style="border: 1px solid black; width: 150px; height: 40px; margin: 0 auto;"></div> BAE Systems Representative Authorized By _____ Date _____
SIGNATURE OF BAE SYSTEMS REPRESENTATIVE		