



Factory Inspection Report

| | | | |
|-----------------------------------|--|--------------|--|
| Company Name | | Ref N° | |
| Responsibility for the inspection | | Position | |
| Factory inspector | | oSa official | |

| INSPECTION DETAILS | Applicants | Inspection for members | | | Special inspection |
|----------------------|---------------------|------------------------|--------|-------|--------------------|
| | | First | Second | Third | |
| This inspection | | | | | |
| Date of inspection | | | | | |
| Result of inspection | Conformance | | | | |
| | Minor discrepancies | | | | |
| | Major discrepancies | | | | |

| RESULT OF THIS INSPECTION | Conformance | Minor discrepancies | Major discrepancies |
|--------------------------------|-------------|---------------------|---------------------|
| Quality Management System | | | |
| Safety & Environmental control | | | |
| Conformance to EN Standards | | | |
| Product Marking | | | |
| Availability of Test Records | | | |
| Random Destructive Tests | | | |

| | | | |
|--------------------------------------|---------------------------------|--|---|
| OVERALL ASSESSMENT For applicants | <i>Application can proceed.</i> | <i>Application cannot proceed until all discrepancies have been rectified.</i> | <i>Application process is terminated. Cannot re-apply for 3 years.</i> |
| | | | |
| OVERALL ASSESSMENT For members | <i>Membership can continue.</i> | <i>All discrepancies must be rectified within the agreed timescale.</i> | <i>Use of the oSa logo is suspended until all discrepancies have been rectified. A repeat inspection may be required.</i> |
| | | | |
| Signature of the Inspector | | | Date |

| CONFIRMATION BY THE APPLICANT/MEMBER | | |
|---|------|------|
| I confirm that the factory inspection has been carried out acceptably. I confirm that the inspector has clearly explained the reasons for his conclusions. | | |
| Signature | Name | Date |

| | | |
|--|--|------|
| FOLLOW-UP ON ACTIONS REQUIRED | <i>To be completed by the factory inspector when documentary evidence has been received confirming that all required actions have been carried out</i> | |
| I confirm that all actions have been carried out | Signature | Date |



Factory Inspection Report

| ACTIONS STILL OUTSTANDING FROM THE PREVIOUS FACTORY INSPECTION | Date | Actioned |
|--|------------------------|---------------------------|
| | | |
| DETAILS OF ACTIONS REQUIRED AS A RESULT OF THE INSPECTION | Completion date | Tick when actioned |
| | | |
| <p><i>Factory inspector to sign-off on page 1 of this report when he has received documentary evidence that all actions have been carried out.</i></p> | | |

| COMMENTS BY THE FACTORY INSPECTOR |
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Factory Inspection Report

PRODUCTS TO BE INCLUDED UNDER THE SCOPE OF oSa MEMBERSHIP

Factory inspector to confirm during audit.

| | | | | | | | | | | | | |
|-----------------------------------|----------|--|--|--|--|--|--|--|--|--|--|--|
| Product group | | | | | | | | | | | | |
| Machine type | | | | | | | | | | | | |
| MOS m/s | Highest | | | | | | | | | | | |
| Bond type | | | | | | | | | | | | |
| Wheel grade | Softest | | | | | | | | | | | |
| | Hardest | | | | | | | | | | | |
| Abrasive | Type | | | | | | | | | | | |
| | Coarsest | | | | | | | | | | | |
| | Finest | | | | | | | | | | | |
| Diameter (mm) | Min | | | | | | | | | | | |
| | Max | | | | | | | | | | | |
| Thickness (mm) | Min | | | | | | | | | | | |
| | Max | | | | | | | | | | | |
| Bore size (mm) | Min | | | | | | | | | | | |
| | Max | | | | | | | | | | | |
| ADDITIONAL INFO FOR FLAP PRODUCTS | | | | | | | | | | | | |
| Shape | | | | | | | | | | | | |
| No of flaps | Min | | | | | | | | | | | |
| | Max | | | | | | | | | | | |
| Type of backing | | | | | | | | | | | | |



Factory Inspection Report

QUALITY MANAGEMENT O = By observation only C = Requires confirmation

| Quality System | | Details & comments | YES | NO |
|----------------------------|---|--------------------|-----|----|
| C | All records required to be made available for examination had been collected in advance of the inspection | | | |
| C | Operates a formal quality system | | | |
| C | Conformance to EN standards stated | | | |
| C | Conducts raw material quality control | | | |
| C | Conducts in-process inspection | | | |
| C | Conducts final inspection | | | |
| C | Has procedure for non-conformance | | | |
| C | Conducts management review and audit | | | |
| C | Operates an acceptable product traceability system | | | |
| Records | | Details & comments | YES | NO |
| C | Possesses acceptable design test results | | | |
| C | Recording and analysis of rejects and defects | | | |
| C | Recording and analysis of customer complaints | | | |
| C | Recording and retrieval of inspection records | | | |
| C | Records will be kept for sufficient time | | | |
| Testing equipment | | | | |
| C | Possesses all of the necessary equipment | | | |
| C | Conducts functioning checks | | | |
| C | Conducts periodic calibration | | | |
| C | Calibration status clearly marked | | | |
| C | Keeps appropriate records | | | |
| Raw materials and products | | | | |
| O | Has suitable handling and storage facilities | | | |
| Products tested in-house | | | | |
| O | Sufficient to conduct audit | | | |
| C | Samples available for testing | | | |
| C | All samples met the requirements | | | |

| OVERALL ASSESSMENT OF QUALITY MANAGEMENT SYSTEM | Conformance | Minor Discrepancies | Major Discrepancies |
|---|-------------|---------------------|---------------------|
| | | | |



Factory Inspection Report

SAFETY & ENVIRONMENTAL CONTROL

O = By observation only C = Requires confirmation

| Risk Management | | Details & comments | YES | NO |
|--------------------------------------|---|--------------------|-----|----|
| C | Does an effective risk management system seem to be in place? | | | |
| O | Do the working conditions seem generally safe? | | | |
| O | Are the working areas clean and tidy and free from obvious hazards? | | | |
| Plant & Equipment | | | | |
| O | Does machinery seem in good condition? | | | |
| O | Are there any obvious unsafe practises? | | | |
| Personal protective equipment | | | | |
| C | Designated areas of PPE | | | |
| C | Enforcement of PPE | | | |
| External discharges | | Details & comments | | |
| C | Does an environmental control system seem to be in operation? | | | |
| O | Evidence of external smells | | | |
| O | Visible external discharge of dust/fumes | | | |
| O | Evidence of water pollution | | | |
| Internal controls | | | | |
| O | Evidence of control equipment | | | |
| O | Evidence of excessive dust | | | |
| O | Evidence of excessive noise or vibration | | | |
| O | Evidence of excessive temperature | | | |
| O | Evidence of excessive fumes/smell | | | |
| Hazardous materials | | | | |
| O | Evidence that hazardous materials are identified, stored and handled safely | | | |

| OVERALL ASSESSMENT OF SAFETY & ENVIRONMENTAL CONTROL | Conformance | Minor Discrepancies | Major Discrepancies |
|--|-------------|---------------------|---------------------|
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Factory Inspection Report

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|--|-----------------------------|------------|-----------|
| CONFORMITY TO EN 12413 - BONDED ABRASIVES | Applicable to audit: | YES | NO |
|--|-----------------------------|------------|-----------|

| Product selection and design | Section in Standard | Comments | YES | NO |
|--|----------------------------|-----------------|------------|-----------|
| Defined maximum operating speeds | 5.1.2 & T6 | | | |
| Defined dimensional limits | 5.3.1 T6 | | | |
| Minimum burst speeds | 5.2.1 & T4 | | | |
| Side load and impact capacity | 5.2.3/T5 | | | |
| Mounted points - Burst speed and spindle deflection values | 5.2.2/B.1 | | | |
| Marking requirements | 5.5 & Annex A | | | |
| Legible and indelible | A.2 | | | |
| On the product wherever possible (> 80mm diameter) | A.2 | | | |
| Name of the manufacturer | A.1.1/ T.A1 | | | |
| Dimensions in millimetres | A.1.1/ T.A1 | | | |
| Specification mark in accordance with ISO 525 | A.1.1/ T.A1 | | | |
| Maximum operating speed in both m/s and rpm | A.1.1/ T.A1/E | | | |
| Appropriate restrictions of use warnings | A.1.1/ T.A2 | | | |
| Code number for traceability of manufacture | A.1.1/ T.A1 | | | |
| Expiry date for portable resinoid wheels | A.1.2.2 | | | |
| Mounting indications where applicable | A.1.2.3 | | | |
| Optional colour stripe where used | D | | | |
| Declaration of conformance "EN12413" | A.1.1/ T.A1 | | | |
| Blotters or Washers | | | | |
| Blotters supplied where required | 5.6 | | | |
| Inspection and testing by the manufacturer | | | | |
| Safety speed | 6.1.1.3/T7 | | | |
| Burst speed | 6.1.2.1/T7 | | | |
| Visual inspection and verification of the marking | 6.1.1.1 / 6.1.5 | | | |
| Conduct ring test where appropriate | 6.1.1.2 | | | |
| Wheel dimensions according to ISO 13942 | 5.3.2 & 6.1.3 | | | |
| Out-of-balance according to ISO 6103 | 5.4 & 6.1.4 | | | |
| Scope of the inspection | | | | |
| Tested at the defined frequency | 6.2 T7 | | | |
| Information for Use | | | | |
| Bring information to the notice of the end user | 7 | | | |

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|---|--------------------|----------------------------|----------------------------|
| OVERALL ASSESSMENT OF CONFORMITY TO EN 12413 | Conformance | Minor Discrepancies | Major Discrepancies |
| | | | |



Factory Inspection Report

| CONFORMITY TO EN 13236 - SUPERABRASIVES | | | Applicable to audit: | YES | NO |
|--|----------------------|-------------|----------------------|-----|----|
| Product selection and design | Section in Standard | Comments | YES | NO | |
| Maximum operating speeds: | Grinding wheels | 5.2.4 / T6 | | | |
| | Diamond saws | 5.3.4 / T8 | | | |
| | Diamond Wires | 5.4.3 | | | |
| | Mounted wheels | 5.5.2 / C | | | |
| | Other superabrasives | 5.6.4 / T14 | | | |
| Minimum burst speeds: | Grinding wheels | 5.2.3 / T5 | | | |
| | Diamond saws | 5.3.3 / T7 | | | |
| | Other superabrasives | 5.6.3 / T13 | | | |
| | Mounted wheels | 5.5.3 / C | | | |
| Bore tolerance: | Grinding wheels | 5.2.1 | | | |
| | Diamond saws | 5.3.1 | | | |
| | Other superabrasives | 5.6.2 | | | |
| Requirements for metal saw blanks | 5.3.5 | | | | |
| Design and position of cuts and openings in the metal blank of cutting-off wheels for hand-held applications | 5.3.5.3 | | | | |
| Maximum segment height for diamond saws | 5.3.6.2. | | | | |
| Requirements for diamond wires | 5.4 | | | | |
| Marking requirements | 5.7 / Annex A | | | | |
| Legible and indelible | A.2 | | | | |
| On the product wherever possible (> 80mm diameter) | A.2 | | | | |
| Name of the manufacturer | A.1.1 | | | | |
| Maximum operating speed in both m/s and rpm | A.1.1 / E | | | | |
| Optional colour stripe where used | B | | | | |
| Direction of rotation where applicable | A.1.1 | | | | |
| Appropriate restrictions of use warnings | A.1.1 / T.A2 | | | | |
| Code number for traceability of manufacture | A.1.1 | | | | |
| Declaration of conformance "EN13236" | A 1.1 | | | | |
| Blotters or Washers | | | | | |
| Blotters supplied where required | 5.2.5 | | | | |
| Inspection and testing by the manufacturer | | | | | |
| Safety speed test/burst test: | Grinding wheels | 6.1. & T21 | | | |
| | Diamond saws | 6.2 & T23 | | | |
| | Other superabrasives | 6.5.1 & T25 | | | |
| | Mounted wheels | 6.4.1 | | | |
| Determination of neutral point position | 5.3.7 & 6.5 | | | | |
| Design and position of cuts and openings in the metal blank of cutting-off wheels for hand-held applications | 5.3.5.3 | | | | |
| Visual inspection | 6.1.1 | | | | |
| Ring test (vitrified core only) | 6.1.2 | | | | |
| Bending test for saws | 6.2.2 | | | | |
| Shear strength of dish wheels | 6.2.3.1 | | | | |
| Information for Use | | | | | |
| Bring information to the notice of the end user | 7 | | | | |

| OVERALL ASSESSMENT OF CONFORMITY TO EN 13236 | Conformance | Minor Discrepancies | Major Discrepancies |
|--|-------------|---------------------|---------------------|
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Factory Inspection Report

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|--|-----------------------------|------------|-----------|
| CONFORMITY TO EN 13743 - COATED ABRASIVES | Applicable to audit: | YES | NO |
|--|-----------------------------|------------|-----------|

| Product selection and design | Section in Standard | Comments | YES | NO |
|---|----------------------------|-----------------|------------|-----------|
| Observe defined maximum operating speeds | 5.1.2 / T5 | | | |
| Conform to defined dimensional limits | 5.3 & T5 | | | |
| Minimum burst speeds | 5. 2 & T4 | | | |
| Burst speed and spindle deflection values | 5.2.2 | | | |
| Marking requirements | 5.4 / Annex A & B | | | |
| Legible and indelible | A2 | | | |
| On the product wherever possible | A2 | | | |
| Name of the manufacturer | A.1.1 / Table A.1 | | | |
| Dimensions in millimetres | A.1.1 / Table A.1 | | | |
| Maximum operating speed in both m/s and rpm | A.1.1 / Table A.1 / C | | | |
| Optional colour stripe if used | Annex B / Table B.1 | | | |
| Appropriate restrictions of use warnings | A.1.2 / Table A2 | | | |
| Code number for traceability of manufacture | A.1.1 / Table A.1 | | | |
| Declaration of conformance "EN 13743" | A.1.1 / Table A.1 | | | |
| Inspection and testing by the manufacturer | | | | |
| Safety speed test or burst test | 6.2 & T8 | | | |
| Visual inspection and verification of the marking | 6.1 / 6.4 | | | |
| Dimensional requirements | 6.3 | | | |
| Information for Use | | | | |
| Bring information to the notice of the end user | 7 | | | |

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|---|--------------------|----------------------------|----------------------------|
| OVERALL ASSESSMENT OF CONFORMITY TO EN 13743 | Conformance | Minor Discrepancies | Major Discrepancies |
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Factory Inspection Report

Destructive Bending Test

| Product | Brand/Type | MOS [m/s] | Dimensions | | | | | | | | | M _b [Nm] | Requirements | | Comments | |
|---------|------------|--------------|------------|-----------|-----------|------------------------|-----------|------------------------|------------------------|-------------------|-----------------|------------------------|------------------------|-----------------|----------|--|
| | | | D [mm] | T [mm] | H [mm] | X ₁ [mm] | E [mm] | L _v [mm] | L ₂ [mm] | $\frac{L_2}{X_1}$ | $\frac{X_1}{E}$ | | M _b [Nm] | $\frac{X_1}{E}$ | | |
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Requirements: $M_b = \frac{L_v \cdot E^2 \cdot \sigma_b}{6}$

