

Quality Control Manual

The inspection and test steps every rebuilt pump and machined part passes before packing.

Production Route

Stage	What Happens
Turning and milling	Blanks are turned and milled from certified bar and forging stock on CNC machines.
Heat treatment	Carburising, quenching, tempering or nitriding to the route the original part uses.
Grinding	Bores, spline seats and running faces are ground after heat treatment so distortion is removed.
Lapping and superfinishing	Valve plates, shoe faces and block faces are lapped so the pair seals under pressure.
Inspection	Dimensions, hardness and surface finish are recorded against the drawing on a sampling plan.
Assembly and test	Complete pumps are built, run in and tested for efficiency, leakage and noise before packing.

Inspection and Test

- Incoming material certificates are checked against the grade called for on the drawing.
- Hardness is measured after heat treatment on every batch and recorded on the batch card.
- Critical bores and running faces are gauged against the drawing tolerance, not against a sample part.
- Mating parts are matched as a set so the block, shoes and valve plate run in together.
- Rebuilt pumps are bench tested for volumetric efficiency, external leakage and sound level.
- Parts are cleaned, oiled and vacuum sealed so they arrive without surface rust.

Documentation Available

Document	Content
Material certificate	Mill certificate for the steel grade used in the batch
Hardness report	Surface and core hardness readings after heat treatment
Dimensional report	Measured values for the critical features named on the drawing
Test bench report	Flow, efficiency, leakage and sound readings for a rebuilt pump
Packing list and photographs	Carton contents and photographs of the packed goods before shipment

Warranty

Rebuilt pumps and machined parts carry a twelve month warranty, on the same terms as the original part. Fluid cleanliness, suction condition and correct installation are the factors that most affect how long a repair lasts, and the installation guide covers them.

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