						C	Copper Bi	razing S	kill Ch	heck S	heet				
lame:				_										Points: 0	
SAFETY & (	THERE					7	♦ Pre	e-heating Che	ck Point				◆ Alloy Application Check P	oint	
ITEMS TEMS	OK		NG		Scores	4	1) Heat adjustment						5) Heating up pipes to proper temperature for operation		
.1 Quality - No Leaks	- Oit		110		-	2) Flame length adjustment (40 ~ 50 mm)     3) Keep proper distance between white flame and pipe (2 ~ 3 mm)						6) Running small amount of alloy consistently			
.2 Quality - Proper Sequence Torch Operation 20					-		4) Hea	ating both pipe	es evenly		flame and pipe ( at the same time)	2 ~ 3 mm)	Keep proper distance betwe     Running alloy by keeping pre	en white flame and pipe (2 ~ 3 mm oper temperature	
.1 Appearance (Inside) 90								(Froating inner p	po una outo	, pipo ovorily c	at the came time,				
2 Appearance (Outside) 90															
Knowledge & Operation 144					0	1									
Time 30					0	1									
1 Safety - PPE & Torch 15					-										
2 Clean Up 5					-										
	Downward														
		Do	wnwar	d	_		n 2 Marks Per Jo		y Judges	Uny	ward	1			
		Do	wnwar	d 2	No Upware		n 2 Marks Per Jo Horizon		y Judges		ward 9	1			
		-		_	Upward	d 4	Horizon	ntal 6							
		1		2	Upward 3	d d	Horizon	6 Decision	7		8 9				
eat adjustment - Excessively high or low		1		2	Upward 3	d d	Horizon  4 5  cision Decision	6 Decision	7		8 9		Ø 25.		
lame adjustment (5 cm) - Excessively long or short		1 Decision	D	2 Pecision	Upward 3	Dec	Horizon  4 5  cision Decision  Pre-heating Chec	6 Decision	7 Decisi	sion Dec	8 9 Decision		Ø 25.  Phosphor Copp	4 ver Brazing	
lame adjustment (5 cm) - Excessively long or short		Decision	1	2 Decision	Upward 3 Decision	Dec P	Horizon 4 5 Decision Decision Pre-heating Chec	6 Decision	7 Decisi	sion Dec	8 9 Decision Decision		Ø 25.	4 TO DOING D	
leat adjustment - Excessively high or low Flame adjustment (5 cm) - Excessively long or short Flame distance - Only judge by sound - More than 2 mes, starts over with each joint Uniform pre-heating - Judge only on front side	-	Decision	1 2	2 Decision	Upward 3 Decision 1	Dec P	Horizon 4 5 Decision Decision Pre-heating Chec	6 Decision ck Point 1 2	7 Decisi	Dec	8         9           Decision         Decision		Ø 25. Phosphor Copp  DOWNWARD 2  UPWARD 43.	4 TO DORTS ON TO DORTS	
ame adjustment (5 cm) - Excessively long or short ame distance - Only judge by sound - More than 2 mes, starts over with each joint niform pre-heating - Judge only on front side	-	Decision  1 2 3	1 2 3	2 Decision	Upward 3 Decision 1 2 3	Dec P	Horizon 4 5 Cision Decision Pre-heating Chec	tatal  6 Decision  1 1 2 3 4	7 Decisi	Dec	8 9 Decision  1 2 3		© 25. Phosphor Copp  DOWNWARD 2  UPWARD 4 AV  HORIZONTAL 3	4 TO LORITS ON THE LORITS OF T	
ame adjustment (5 cm) - Excessively long or short ame distance - Only judge by sound - More than 2 nes, starts over with each joint niform pre-heating - Judge only on front side orking temperature - can display some color triation - judge by whether the alloy melts or not - it	-	Decision  1 2 3	1 2 3	2 Decision	Upward 3 Decision 1 2 3	Dec P	Horizon 4 5  cision Decision Pre-heating Chec 1 2 3 4	tatal  6 Decision  1 1 2 3 4	7 Decisi	Dec	8 9 Decision  1 2 3		© 25.  Phosphor Copp  DOWNWARD 2  UPWARD 4 M  HORIZONTAL 3	4 TO LORITS ON THE LORITS OF T	
ame adjustment (5 cm) - Excessively long or short ame distance - Only judge by sound - More than 2 nes, starts over with each joint niform pre-heating - Judge only on front side orking temperature - can display some color riation - judge by whether the alloy melts or not - it to tonits are deducted) nall amount of alloy application with each pass - visual	-   -   -   -   -   -   -   -   -   -	Decision  1 2 3 4	1 2 3 4	2 Decision	Upward 3 Decision 1 2 3 4	1 Dec P	Horizon 4 5 Sision Decision Pre-heating Chec 1 2 3 4 Py Application Ch	detail  6 Decision  k Point  1 2 3 4 heck Point	7 Decisi 1 2 3 4	1 2 3 4	8 9 Decision  1 2 3 4		© 25.  Phosphor Copp  DOWNWARD 2  UPWARD 4 M  HORIZONTAL 3	4 TO LORITS ON THE LORITS OF T	
ame adjustment (5 cm) - Excessively long or short ame distance - Only judge by sound - More than 2 nes, starts over with each joint niform pre-heating - Judge only on front side orking temperature - can display some color riration - judge by whether the alloy melts or not - it of (points are deducted) nall amount of alloy application with each pass - visual servation alone - not judged by length of alloy swipe ame distance - Only Judge By Sound - More than a medistance - Only Judge By Sound - More than	- -	1 Decision  1 2 3 4 5 5	1 2 3 4 5	2 Plecision	Upward 3 Decision  1 2 3 4	1 Dec P 1 1 2 3 3 4 Allo	Horizon 4 5 Sision Decision Pre-heating Chec 1 2 3 4 Py Application Chec	datal  6 Decision  k Point  1 2 3 4 heck Point  5	7 Decisi 1 2 3 4 5	1	8 9 Decision  1 2 3 4		© 25.  Phosphor Copp  DOWNWARD 2  UPWARD 4 M  HORIZONTAL 3	4 TO LORITS ON THE LORITS OF T	
ame adjustment (5 cm) - Excessively long or short ame distance - Only judge by sound - More than 2 nes, starts over with each joint		1 Decision  1 2 3 4 5 6	1 2 3 4 5 6	2 Decision	Upward 3 Decision  1 2 3 4	1	Horizon 4 5  Scision Decision Pre-heating Chec 1 1 2 3 4 4  Dy Application Ch 5 6	tatal  6 Decision  1 1 2 3 4 heck Point  5 6	7 Decisi 1 2 3 4 5 6 6	1 2 3 4 5 6 6	8 9 Decision  1 2 3 4 5 6		Ø 25. Phosphor Copp  DOWNWARD 2  UPNARD 4 I/A  HOREONTAL 3  OUT OF SEQUENCE:	4 TO LORITS ON THE LORITS OF T	

Brazing Operation Evaluation Point Total Score