



2022 Provincial Skills Canada Competition

Auto Body Repair

Secondary

MARK SHEETS

COMPETITOR : _____

A Panel Sectioning Project

points

Replacement Section

points max

<i>Action descriptor</i>						Total Mark
Location of splice on windshield pillar	<i>Didn't read instructions, incorrect by more than 10mm</i>	<i>Out by 6mm either way or short / long</i>	<i>Out by 4mm either way or short / long</i>	<i>Out by 2mm either way or short / long</i>	<i>Measured correctly, within + - 1mm</i>	
Size and quality of root gap (straight lines cut)	<i>No root gap at all, or too wide by 5mm or more</i>	<i>Root gap uneven 0mm to 3mm touching in 5 - 6 places</i>	<i>Root gap uneven 0mm to 3mm touching in 3 - 4 places</i>	<i>Root gap uneven 0mm to 2mm touching in 1- 2 places</i>	<i>Root gap consistent 1mm no contact, even</i>	
Location of insert (lower splice)	<i>Didn't read instructions, incorrect by more than 10mm</i>	<i>Out by 6mm either way or too short / long</i>	<i>Out by 4mm either way or too short / long</i>	<i>Out by 2mm either way or too short / long</i>	<i>Measured correctly, within + - 1mm</i>	
Length of insert (Measure insert before it is welded in)	<i>Didn't read instructions, incorrect by more than 10mm</i>	<i>Out by 6mm either way or short / long</i>	<i>Out by 4mm either way or short / long</i>	<i>Out by 2mm either way or short / long</i>	<i>Measured correctly, within + - 1mm</i>	
Application of weld-through primer	<i>None applied, not sure what it is, knows what it is, just forgot, or wrong time</i>	<i>Applied a mist or drowned it, only one side of sleeve or only on part</i>	<i>Applied mist or drowned both sides of sleeve but not part or vise versa</i>	<i>Applied mist or drowned, but applied to all appropriate areas</i>	<i>Applied even consistent coat to all required areas.</i>	
Quality of spot weld removal	<i>Part is damaged, drilled through 4 or more</i>	<i>Part is damaged, drilled through 3</i>	<i>Part is slightly damaged, drilled through 2</i>	<i>Drilled through 1 or part has slight deformation</i>	<i>No distortion, or damage, no drill through, neat clean edges</i>	

Replacement panel preparation	<i>Panel damaged, distorted, wrong size, not dressed</i>	<i>Edges cut crooked, incorrectly dressed, size out by 2-3mm</i>	<i>Size out by 1-2mm, cut is not consistent, poor fit.</i>	<i>Missed minor area for dressing, fit is a bit tight, less than 1mm in places.</i>	<i>Dressed correctly, fit is equal all the way around, good root gap</i>	
Vehicle panel preparation	<i>Panel damaged or distorted, not dressed, inner cut right through</i>	<i>Edges cut crooked, inner shows 2cut marks, size out by 2-3mm Location is off</i>	<i>Cut is not consistent. Inner has 1 cut mark, location slightly off 1-2mm</i>	<i>slight waver in cuts, surface scar on inner (very minor)</i>	<i>No scars on inner, cut is neat and straight no deformation.</i>	
Inner metal distortion (Sleeve)	<i>Deformation beyond repair</i>	<i>Twisting and or gaps exceeding 3-4mm</i>	<i>Slight twist with slight separation 1-2mm</i>	<i>Some minor warpage, separation less than 1mm</i>	<i>No warpage with good snug fit and no separation</i>	
Grinding of butt weld	<i>Burn through, holes and cracks</i>	<i>Slight cracking, 1-2 pin holes</i>	<i>Spider legs, small pop or pin hole</i>	<i>Slight blueing around weld from dressing</i>	<i>Smooth even grind with no blueing, cracking or pin holes</i>	
Fit of insert (to inner panel)	<i>Deformation beyond repair</i>	<i>Twisting and or gaps exceeding 3-4mm</i>	<i>Slight twist with slight separation 1-2mm</i>	<i>Some minor warpage, separation less than 1mm</i>	<i>No warpage with good snug fit and no separation</i>	
Overall appearance	<i>Burn through, crooked welds, inconsistent sizes and finish, excessive deformation</i>	<i>Joints are crooked, visible deformation excessive pinholes, blueing, spider legs</i>	<i>Slight deformation 1-2mm, welds are slightly skewed, 1-2 pinholes</i>	<i>Slight deformation less than 1mm strait seams</i>	<i>Clean strait welds no deficiencies, fit is good no deformation at joints</i>	

Continuous Welds

points max.

Action Descriptor						Total Mark
Width	15 - +15mm	13mm-14mm	11mm-12mm	9mm-10mm	3mm-8mm	
Height	9mm-10mm or 2mm+ undercut	8mm-9mm or .5mm-1mm undercut	6mm-7mm	4mm-5mm	1.5mm-3mm	
Penetration	No sign of penetration, or very, very, faint	Less than 2mm, sporadic gaps	6.5mm-7mm or minor inconsistency	5mm-6mm consistent	2mm-5mm consistent	
Cracks	5mm - +	3.5mm – 4mm	Less than 3mm	Faint sign of one starting	No cracks at all	
Burn-through	Burn through not repaired at all Any size.	Burn through repaired greater than 4mm	Burn through repaired 3.5mm- 4mm	Repaired burn through, less than 3mm	No burn through at all	
Undercuts (groove on edge of weld in panel)	Continuous undercut	Undercut 4.5mm – 6mm+	Undercut 2.5mm- 4mm	Undercut only on corners, or, Less than 2mm	No undercut present at all	
Porosity	4.5mm +	3.5mm-4mm	2.5mm-3mm	Less than 2mm	No porosity present	
Gaps and skips	More than 6 skips and gaps, totaling over	3- 6 skips Totaling 4 or more mm	1-3 skips 3mm- 4mm	1 – 2 skips under 3mm	No skips, No gaps	
Consistency of beads (nice straight bead)	Weld is off by 4.5mm or more, shows double pass	Weld is off spec by 2mm – 4mm	Thickness and height, waver side to side exceed specs by +/- 1mm	Slight waver, +/- 1-2mm	Nice strait beads, no waving, all are straight, ecstastically pleasing	
Overall appearance	Major physical imperfections over and above 7mm	3-4 medium imperfections totaling between 5mm-7mm	3-4 minor imperfections 3mm- 5mm	1-2 minor imperfections under 3mm	No imperfections visible	

Plug Welds **points max.**

Action Descriptor						
Recommended plug weld hole size = 5/16 or 8mm	<i>Hole is wrong size and or in wrong place or not at all.</i>	<i>Hole is out of shape oval or oblong and out of speck by 2-4mm</i>	<i>Hole is out of shape, oval or oblong by 1-2mm</i>	<i>Hole is within speck, but out by 1-2mm</i>	<i>Hole is centred and within speck</i>	
Correct number and placement of plug welds	<i>Missing more than 2 plug welds, more than 4 out of placement</i>	<i>Missing 1 -2 plug welds More than 4 out of placement.</i>	<i>Placement of 3-4 welds out by 2-5mm</i>	<i>Placement of 1-2 welds out by 2-3mm</i>	<i>No issues with amount and location</i>	
Weld size and height <small>(use judgement, subjective scoring if multiple welds out slightly, or one weld out greatly)</small>	<i>More than 6 welds in error or error is greater than 7mm</i>	<i>4-6welds out by 1-7mm In height or diameter</i>	<i>1-4 welds out by 1-5mm In height or diameter</i>	<i>1-2 welds out by 1-2mm in height or diameter</i>	<i>All welds meet height and diameter criteria</i>	
Penetration	<i>Miss, happy face, half-moon, on face side with a "pimple" greater than 3mm in height (back side)</i>	<i>13-14mm melt through with a "pimple" greater than 3mm in height (back side)</i>	<i>13mm melt-through, "pimple" between 1.5 – 3mm</i>	<i>11-12mm melt-through</i>	<i>Meets criteria 0-10mm</i>	

Total Points for Sectioning Project _____

Time Started _____ **Time Completed** _____ **Total Time** _____

COMPETITOR # _____



Minutes	Task	Marks
	A) Panel Sectioning	
	B) Measuring	N/A
	C) Aluminum Welding	N/A
	D) Door Skin	N/A
	E) Plastic Repair	N/A
	F) Aluminum Dent Repair	N/A
	Total	

Safety - Total Marks:	
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