Your Logo

Your Company Name

INSPECTION PROCESS

Origination Date: XXXX

Document Identifier:	Inspection Process
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the inspection process.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

TABLE OF CONTENTS

1.0 PURPOSE

This document defines the overall inspection process and includes or makes reference to the procedures necessary for the process.

NOTE: The Production process includes all QC inspections and tests within it. Quality is not a separate process.

2.0 THEORY

Production operations or tasks must be conducted under controlled conditions to ensure product quality. By this we mean:

- [redacted]
- [redacted]
- [redacted]
- [redacted]

3.0 PROBLEM RESOLUTION

All employees are instructed to immediately notify a Responsible Authority (RA) whenever a process or product related problem occurs that cannot be corrected according to [redacted]

It is understood that the appropriate responsible authority will occasionally not be available for support; in that event, safely stop the process and contact each of the following personnel in the order listed until [redacted]

- [redacted] er
- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

4.0 PROCEDURE: PRODUCTION DOCUMENTATION

4.1 All revision controlled production documents are available at the point of use and display [redacted]

4.2 In addition to this process procedure, additional production documentation may be required for [redacted]

4.3 Such documentation includes [redacted]

4.4 Records that are created for temporary retention of miscellaneous information are not [redacted]

5.0 PRODUCT IDENTIFICATION

5.1 Product is identified in shop areas by any of the following methods:

[redacted]

5.2 Lot traceability or individual serialization of parts is [redacted].

5.3 Bad (nonconforming) product that has failed an inspection or test and cannot be reworked to comply with requirements is [redacted]. See the ***Control of Nonconformances Procedure***.

5.4 Any parts or product not marked with a tag are [redacted]

5.5 IDENTIFICATION OF TRANSFER CONTAINERS

5.5.1 Whenever a portion of chemical is transferred from its original container to a smaller temporary container, [redacted]

5.5.2 Whenever a portion of chemical is transferred from its original container to a smaller permanent container, [redacted]

6.0 PROCEDURE: PRODUCT HANDLING

6.1 Work instructions and/or training will [redacted]

6.2 In all cases, Operators are to [redacted]

6.3 The Company provides suitable safety and personal protection equipment for handling hazardous or toxic materials. Operators are [redacted]

7.0 PROCEDURE: PRESERVATION

7.1 Operators will employ proper handling, packaging (protection) and cleaning of product and constituent parts while [redacted].

7.2 Operators will employ proper use of controlled atmospheres (argon, dry rooms, etc.) to protect the product

7.3 Operators will employ [redacted].

7.4 Operators will employ [redacted]

7.5 FOD: Foreign Object Damage and Detection: Work instructions and training methods ensure that handling and preservation practices reduce the introduction of foreign objects (FOD) into products.

7.6 Marking and labeling including safety warnings

7.7 Special handling for hazardous materials

8.0 PROCEDURE: CUSTOMER AND GOVERNMENT PROPERTY CONTROL

8.1 Customer and Government Property (C&G Property) means [redacted]

This includes:

8.1.1 [redacted]ment

8.1.2 [redacted]

8.1.3 [redacted]

8.1.4 [redacted]

8.2 All Customer and Government furnished property shall [redacted]

8.3 C&G Property shall [redacted]

8.4 Sensitive material, as defined by the Customer or Government, shall [redacted]

8.5 C&G Property will only be used as [redacted]

8.6 C&G provided equipment shall [redacted]

8.7 Quality shall [redacted]

8.8 Requirements for the control of C&G property shall [redacted]

9.0 PROCEDURE: VALIDATION OF PROCESSES

9.1 Unless otherwise specified by engineering requirements, the form named Design Validation-Verification is used to record results of validation and verification activities.

9.2 Provisions for validation and verification includes:

- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

10.0 PROCEDURE: INSPECTION AND TEST OF PRODUCT

10.1 Receiving inspection is performed according to the ***Receiving Inspection Procedure***.

10.2 First Article Inspection

[redacted]

10.2.7 Any item failing first article inspection must be processed according to the ***Control of Nonconforming Product Procedure***.

10.3 In Process Inspections

[redacted]

10.4 Final Inspection

[redacted]

11.0 PROCEDURE: SHELF LIFE EXTENSION - Subject to Customer Review and/or Approval

11.1 Items that are subject to expiration may [redacted] for instance:

11.1.1 [redacted]

11.1.2 [redacted]

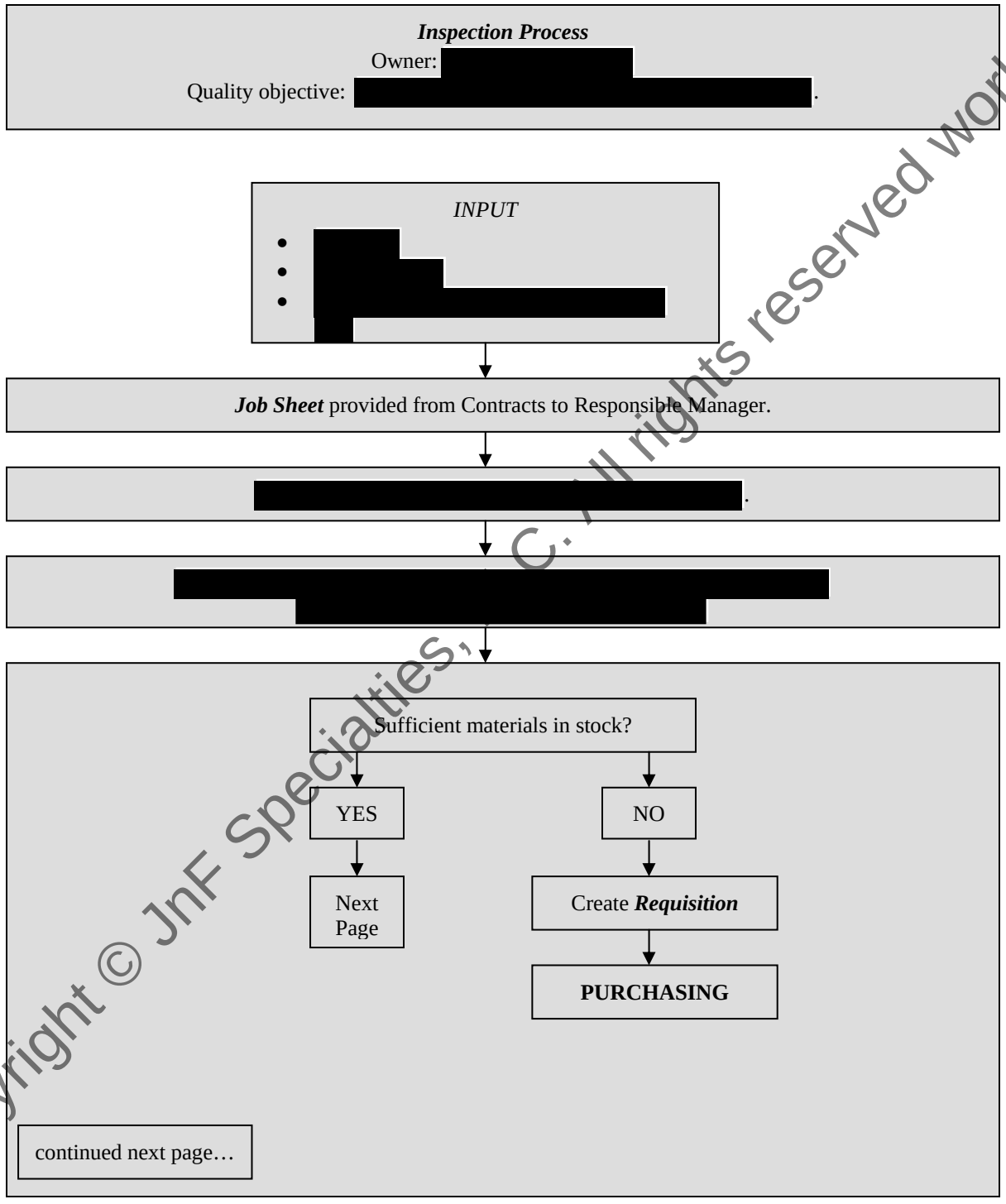
11.1.3 [redacted]

11.1.4 [redacted]

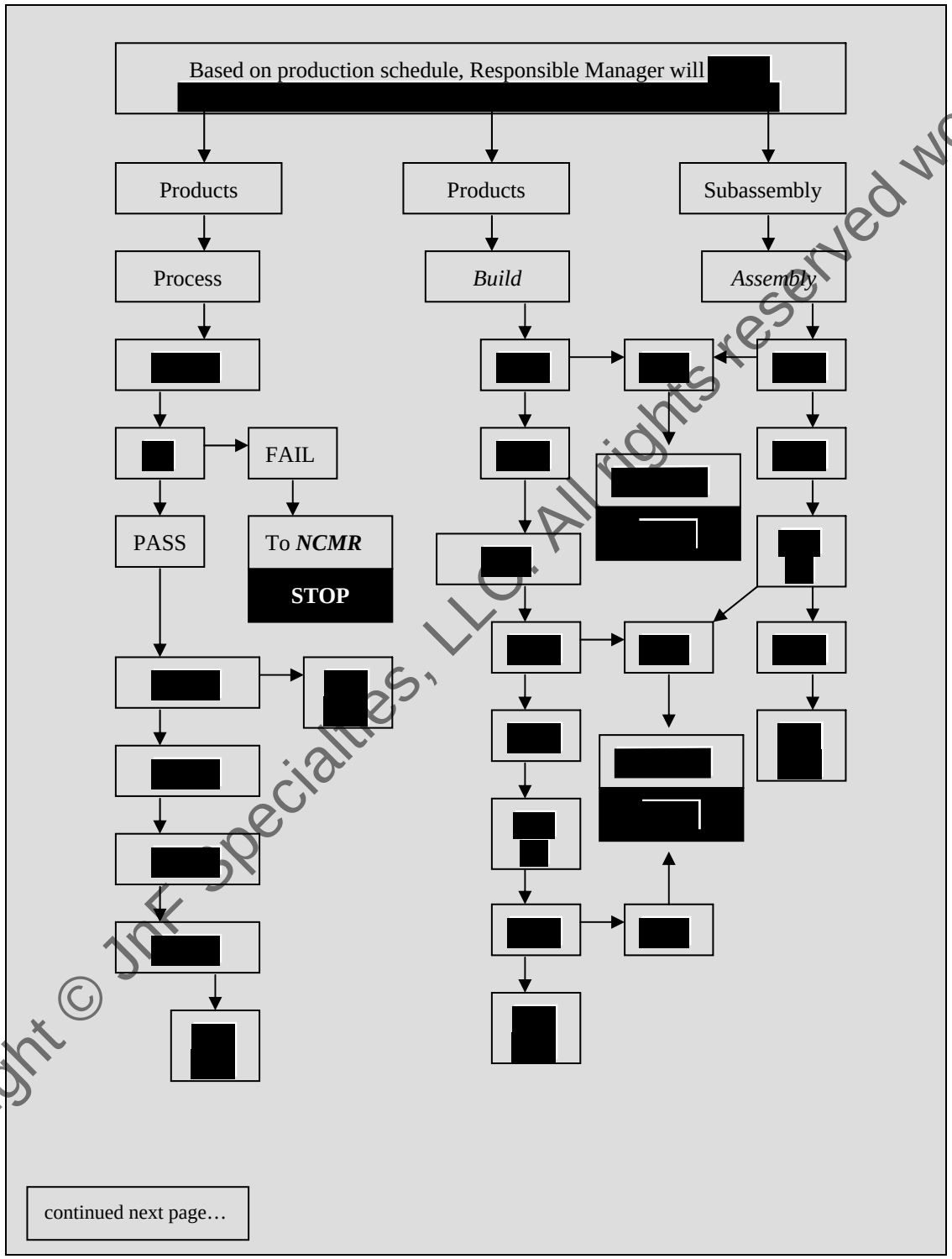
11.2 Chemicals that are purchased [redacted]

11.3 Raw material components whose shelf life has been extended must [redacted]

12.0 PROCESS MAP



from previous page…



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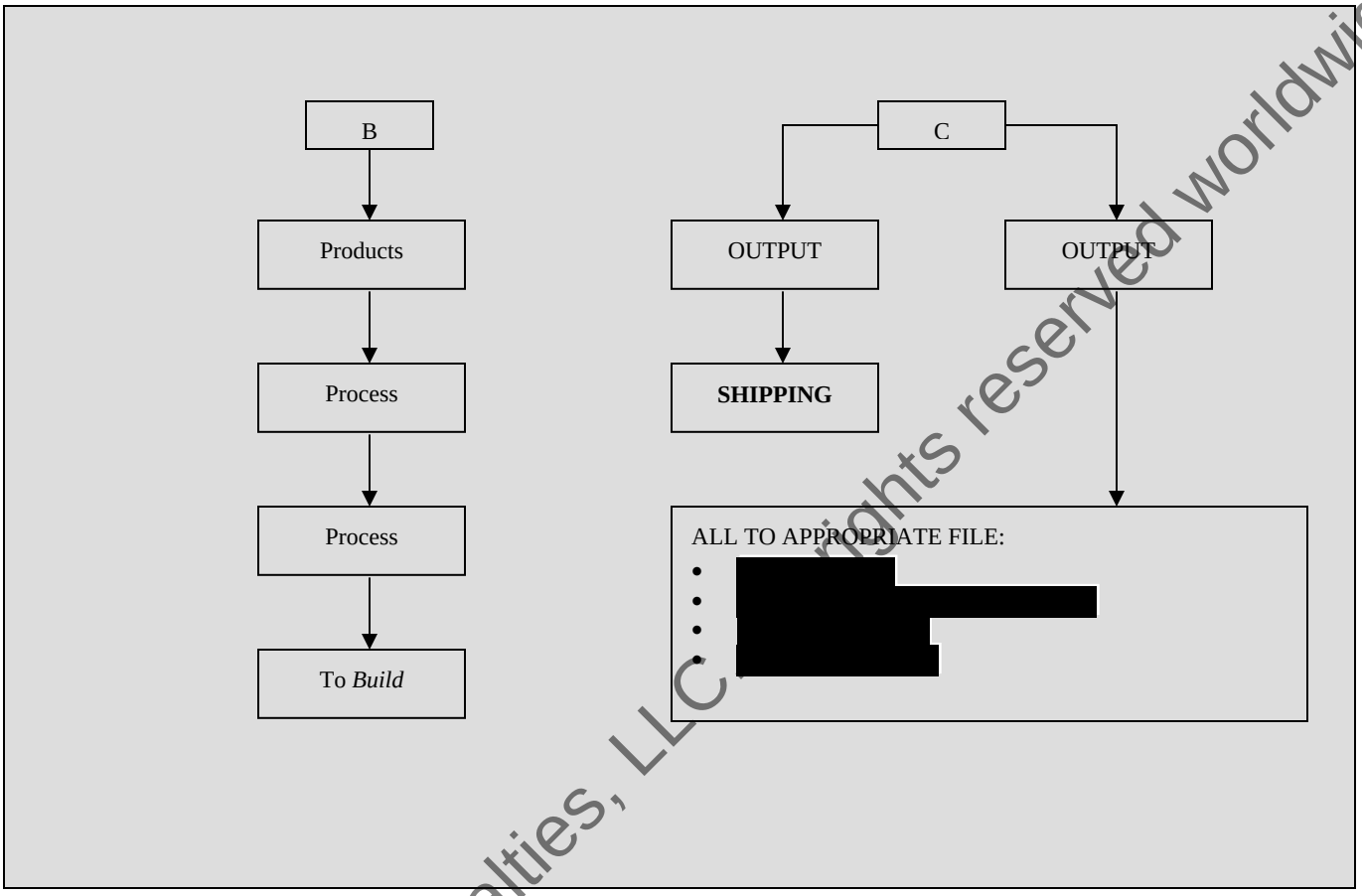


Your Logo

Your Company Name

CONTROL OF NONCONFORMANCES

Origination Date: XXXX

Document Identifier:	Control of Nonconformances
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes procedures for control of nonconformances.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

TABLE OF CONTENTS

1.0 PURPOSE

This document defines and makes reference to the procedures necessary for the control of nonconforming items.

2.0 THEORY

Items that have failed inspections or tests or that in any way does not meet requirements is considered nonconforming. Such items must be controlled to ensure it is not accidentally delivered or used. The Company's system ensures that nonconforming items are identified when found and segregated, investigated and dispositioned. Corrective and/or preventive actions are taken to ensure nonconformances do not reoccur.

3.0 GENERAL PROCEDURE

3.1 Nonconformances are any deliverable items made by the Company or raw material used by the Company or returned from the Customer that does not meet:

- [redacted]

3.2 Nonconforming items must be withheld pending disposition by a completed RFS or Bulletin or by direction from Quality. A Calculated Risk Release may [redacted]

3.3 All employees are empowered to [redacted]

3.4 Upon discovery of nonconforming items, an employee may [redacted]

3.5 When an employee cannot bring the item into conformance through immediate rework, the employee shall [redacted]

3.6 If an employee or supervisor [redacted]

3.7 The employee shall [redacted]

3.8 The employee shall [redacted]

3.9 Upon receipt of the RFS, the Quality representative will [redacted]

3.10 Quality will then [redacted]

3.11 If the nonconforming item is ascertained or estimated to be the fault of a Supplier, Quality may [redacted]

3.12 Quality will also [redacted]

3.13 The RFS shall [redacted]

3.14 The MRB consists of the following managers, at a minimum:

- [redacted]
- [redacted]
- [redacted]

3.14.1 MRB Qualification

A Material Review Board member must:

1) [redacted]; or
2) [redacted]

3.15 In the event of a non-unanimous decision, the [redacted] shall [redacted]

3.16 The Company shall [redacted]

4.0 DISPOSITIONS

4.1 Dispositions are classified as Major, Minor or None.

4.1.1 Major: [redacted]

4.1.2 Minor: [redacted]

4.1.3 None: [redacted]

4.2 MRB dispositions may include, but are not limited to:

4.2.1 Clarification

[redacted].

4.2.2 Conditional Acceptance

[redacted]

4.2.3 Non-Deliverable

[redacted]

4.2.4 Notification

It is possible that a Continuous Improvement Opportunity may not exist for all reported conditions. In this case [redacted]

4.2.5 Precautionary

[redacted]

4.2.6 Repair (Non-Standard and Standard)

[redacted]

4.2.7 Request for Waiver/Deviation/Variance

When a supply is considered 'fit-for-use' by the MRB but departs from [redacted]

4.2.8 Return to Supplier (Receiving Inspection)

[redacted]

4.2.9 Rework (Non-Standard and Standard)

[redacted]

4.2.10 Scrap

[redacted]

5.0 CUSTOMER DISPOSITION AUTHORITY

5.1 Major: [redacted].

5.2 RTV and Scrap dispositions are not [redacted].

5.3 Minor: [redacted]

5.4 Scrap, RTV or Standard Rework dispositions are not [redacted].

5.5 None: [redacted].

6.0 PROCESSING SCRAP

6.1 Nonconforming items dispositioned as scrap are [redacted]

6.2 Such scrap is [redacted]

6.3 Identifying scrap with markings is unacceptable unless [redacted]

6.4 Scrap is controlled internally so as not to be made available for possible theft, which [redacted]

Your Logo

Your Company Name

RECEIVING INSPECTION

Origination Date: XXXX

Document Identifier:	Receiving Inspection
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the receiving inspection process.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

TABLE OF CONTENTS

1.0 PURPOSE

This document defines the Receiving process including receiving inspection activities and includes or makes reference to procedures for the various activities within the process.

2.0 THEORY

Receiving is the first line of defense to prevent sub-standard supplies from affecting the Company's process or product quality; however, sampling and 100% incoming inspection is only a part of the collection of applications that are necessary to assure the release of conforming supplies to stock. Receiving inspection cannot provide 100% assurance of product or process quality because the affect that the supplies have on production-level activities cannot be assessed or verified - only by 100% use of supplies will defects be detected in product or process quality.

As a result of teaming and intelligent design, the Company ensures that deliverable supplies meet Customer requirements prior to packaging and shipping.

3.0 PROCEDURE: RECEIVING

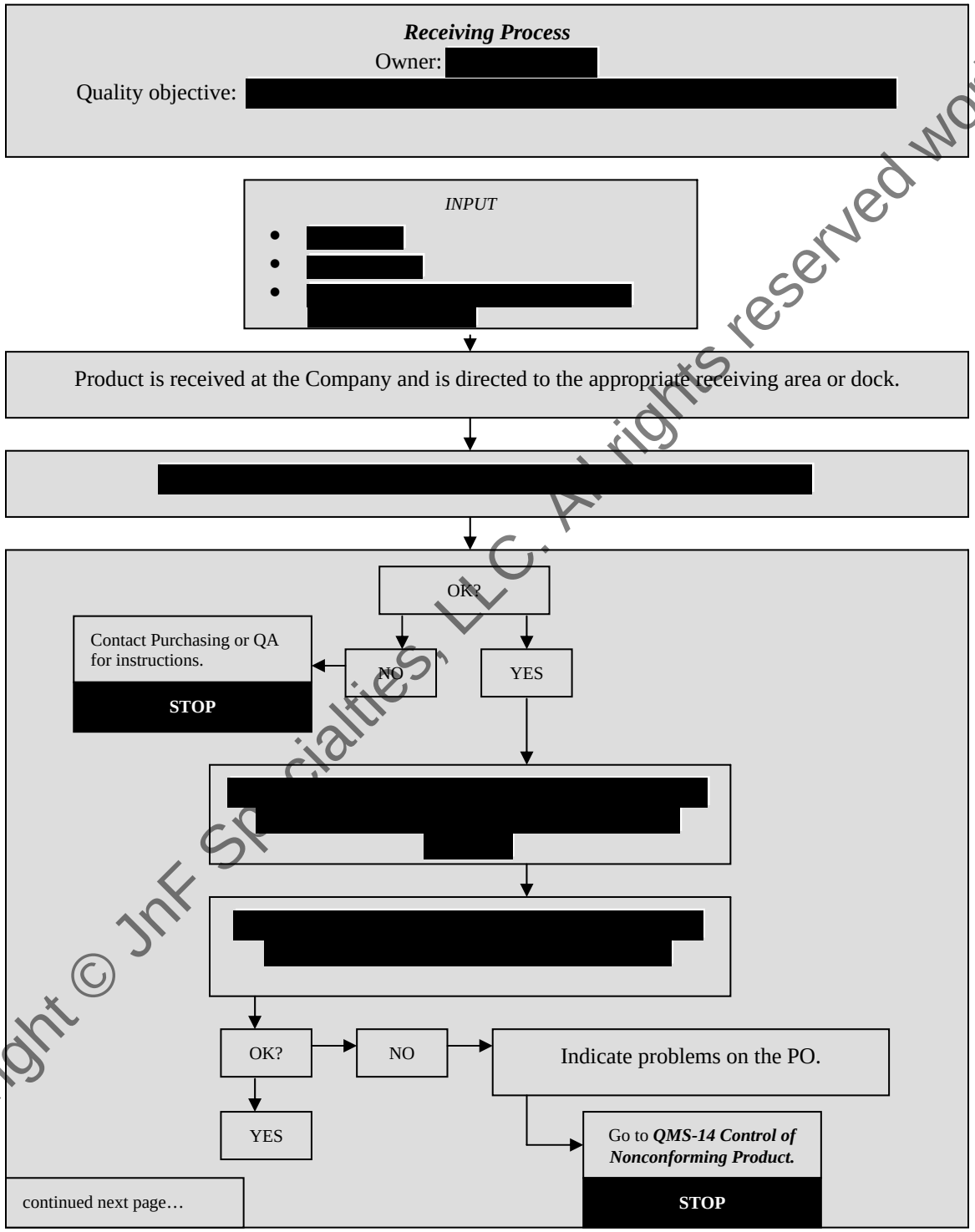
- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

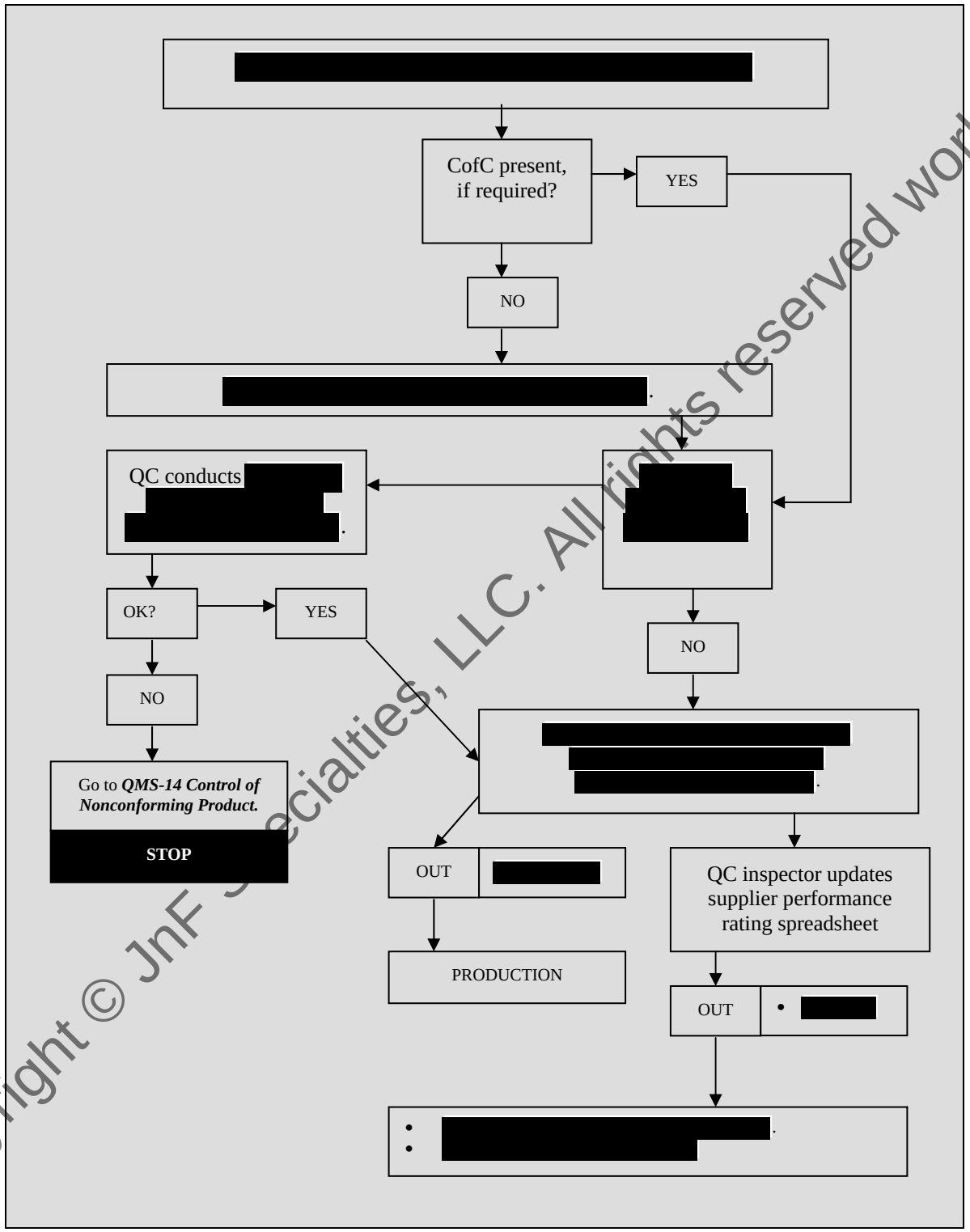
4.0 PROCEDURE: RECEIVING INSPECTION

4.1 The inspector will [redacted]

4.2 Inspections are performed according to [redacted]

PROCESS MAP





APPENDIX A - RECEIVING INSPECTION WORK INSTRUCTIONS

Op 1: [redacted]

Op 2: [redacted]

Op 3: [redacted]

Op 4: [redacted]

Op 5: [redacted]

Op 6: [redacted]

Op 7: SAMPLING PLAN: [redacted]

Op 8: [redacted] then

Op 9: [redacted] then

Op 10: [redacted]

Op 11: When raw material is accepted only by review of Supplier certificate of analysis, review the current Approved Supplier List for item criticality and perform the following activities:

For critical item: [redacted].

For non-critical item: [redacted]

Op 12: [redacted]

Op 13: [redacted]

Op 14: [redacted]

Op 15: [redacted]

Op 16: Complete the inspection record following its format (record applicable M&TE, lot traceability, etc)

Op 17: [redacted]

Op 18: [redacted]

Op 19: [redacted]

Op 20: [redacted]

APPENDIX B - PURCHASE ORDER PROCESSING

Step	IF	THEN
1	Supply is not the Last Item on PO	Produce a copy of the PO - attach packing slip to the copy of PO and forward to Purchasing. Forward [redacted]
2	Supply is the last Item on PO	Attach the Supplier's packing slip to the original PO - produce a copy of the PO - forward [redacted]
2.1	Supply is the last Item on PO	Optional: [redacted]

Your Logo	Inspection Instructions	Specification:	Form Rev: Orig Page 1 of 1
	[redacted]	[redacted]	

[redacted]	[redacted]	[redacted]	[redacted]	[redacted]

Drawing No:		INSPECTION RECORD	Form Rev: Orig
Item Name:		(Your Company Name)	Front
		(Description of Your Inspection Process)	

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Form Rev: Orig Back

(Description of Your Inspection Operation) continued...

Set #	Op 13	Op 14	Op 15	Op 16	Op 17	Op 18	Op 19	Op 20	Op 21	Op 22	Op 23	Op 24	Op 25	Op 26	Op 27	Op 28	Op 29	Op 30	Op 31	Op 32	Op 33	Comments
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35																						

Your Company Name

First Article ☐	Other ☐	**INSPECTION REPORT**	Date:			
Item #:		Item Revision	Previous Report #		RW:	
Item Name:			Date:		Repair:	
J/N:	Lot# - S/N:		Item#:		MR#:	
[redacted]		[redacted]	[redacted]		[redacted]	

[redacted]	[redacted]	[redacted]	[redacted]		[redacted]	[redacted]	[redacted]	[redacted]	[redacted]		[redacted]
	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]		[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
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	[redacted]	[redacted]	[redacted]
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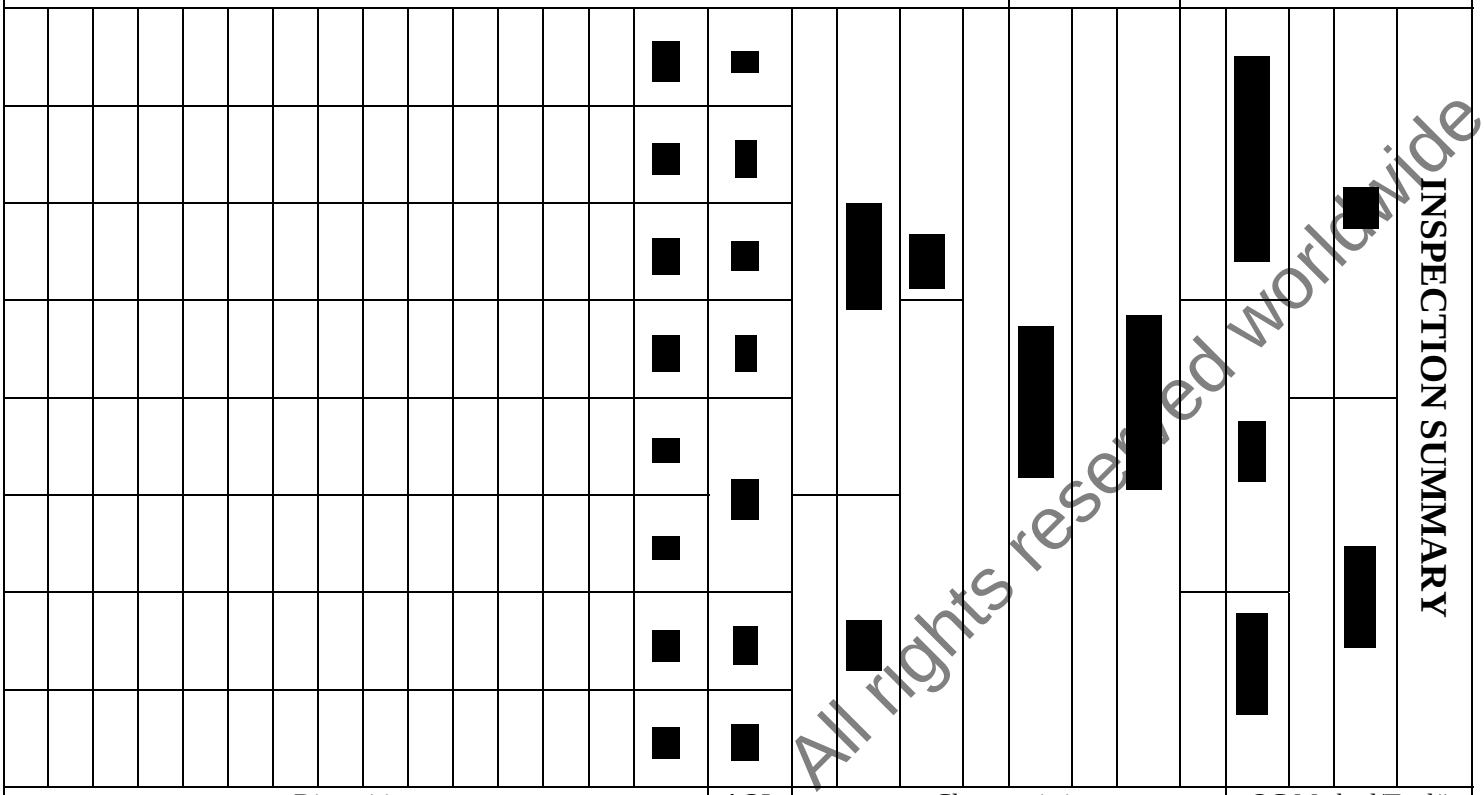
3			
4			
5			

Remarks:

Form Rev: Orig

Your Company Name		
Title: (Your Procedure Name)	Doc#:	(Procedure #)
	Rev:	



Disposition	AQL	Characteristic	QC Method/Tool#
N/A		FAI Rev:	Record

Form Rev: Orig

First Piece Inspection Report

Date:		Supplier:	
Part No:		PO No:	
P/N Rev:		Job No:	

[redacted]

Form Rev: Orig

Your Logo

(Your Company Name)
Dimensional Analysis Record

Item Name:		**Customer:**	
Drawing Number:		**Inspector:**	
[redacted]			
[redacted]	[redacted]	[redacted]	[redacted]
[redacted]		[redacted]	
Confidence Interval:		**Cpk:**	

VERIFICATION AND VALIDATION

Program Name:		Job Number:	
Part Number:		Rev:	
REA:		Date:	

[redacted]

VERIFICATION AND VALIDATION

[redacted]

[redacted]

Form Rev: Orig

QC Tags (shrink to fit application – send template to printer to make multi-part form)

GOOD MATERIAL TAG			Your Logo		
P/N:		PO #:		Date:	
Dwg #:		Rev:		Lot #:	
[redacted]		[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]			[redacted]		
[redacted]					
[redacted]:					

Form Rev: Orig

GOOD MATERIAL TAG			Your Logo		
P/N:		PO #:		Date:	
Dwg #:		Rev:		Your Lot #:	
[redacted]		[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]			[redacted]		
[redacted]					
[redacted]					
[redacted]					
[redacted]					
[redacted]					

Form Rev: Orig

WITHHOLD TAG			
Date:		Item Name:	
[redacted]		[redacted]	
[redacted]		[redacted]	
[redacted]			

Form Rev: Orig

BAD MATERIAL TAG			
Date:		Item Name:	
[redacted]		[redacted]	
[redacted]		[redacted]	
[redacted]			

Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
Initials:				

Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
Initials:				

Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
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PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
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PO#:		Lot#:		
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
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PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
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Form Rev: Orig

GOOD MATERIAL TAG		Your Logo		
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Ready For:				
Initials:				

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

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Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
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Form Rev: Orig

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Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

Helpful Hints:

Purchase “presentation” paper in choice of color then print and cut labels as required.

Purchase peel-and-stick labels of the correct size then print as required.

ACCEPTED MATERIAL		Your Logo		
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED				
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Initials:				

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo		
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED				
P/N:		Rev:		Date:
PO#:		Lot#:		
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Initials:				

Form Rev: Orig

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THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED				
P/N:		Rev:		Date:
PO#:		Lot#:		
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Form Rev: Orig

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MR#:		Qty Ok:		
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Form Rev: Orig

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MR#:		Qty Ok:		
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MR#:		Qty Ok:		
Initials:				

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo		
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED				
P/N:		Rev:		Date:
PO#:		Lot#:		
MR#:		Qty Ok:		
Initials:				

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY ________________________________
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY ________________________________
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY ________________________________
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FINAL INSPECTION
PERFORMED BY ________________________________
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY ________________________________
YOUR LOGO

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FINAL INSPECTION
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Helpful Hints:

Purchase “presentation” paper in choice of color then print and cut labels as required.

Purchase peel-and-stick labels of the correct size then print as required.

EO NUMBER:	DATE:	NCMR#:
ENGINEERING ORDER Page of	CLASS I☐ II☐	PERSON REQUESTING ENGINEERING ORDER: PERSON WRITING ENGINEERING ORDER:

DISPOSITION OF EXISTING PARTS/MATERIALS
MRB☐ ACCEPT☐ SCRAP☐ N/A☐
RE-INSPECT☐

Change Orientation Completed By:

Effectivity/Release Date:

Date

Form Rev: Orig

Your Logo

Your Co Name

Address
City - State - Zip
Phone: Fax:
Email:

NON-CONFORMANCE REPORT

Control Number:		PO Number:	
Part Number:		Part Name:	

Form Rev: Orig

Attach Tracking Information

REQUEST FOR SUPPORT

☐**Nonconformance** ☐**Continuous Improvement Opportunity** ☐**Calculated Risk Release**

SUBCONTRACTOR: _____ DATE RECEIVED: _____

RFS#: SHEET _____ OF _____

Traveler#:		Op#:		Quantity Received:		Job Number:	
Item Name:		**Description: ID S/B Spec#, Para# & IS Condition w/Quantity &Dimension Affected**					**# Discrepant**
Dwg/Spec:							
Part#:							
[redacted]							
[redacted]							
[redacted]							
[redacted]							
[redacted]							
[redacted] *and Date Performed or Schedule*:							
Trend? ☐NO ☐ YES *provide details:*							
[redacted]							

[redacted]

ACN=Advance Change Notice; ICAR=Investigation and Corrective Action Request; EO=Engineering Order

Your Logo **Shaded Area for Administrative Use** Form Rev: Orig

Your Logo

Your Company Name

CORRECTIVE AND PREVENTIVE ACTION

Origination Date: XXXX

Document Identifier:	Corrective and Preventive Action
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the procedures used to correct and prevent nonconformities.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

TABLE OF CONTENTS

1.0 PURPOSE

This document provides details and procedures for the process governing the discovery, reporting, resolution and recording of actions taken to correct or prevent nonconformities.

2.0 THEORY

Corrective action is taken to correct nonconformities, which could be product defects found during production, errors found in documents, equipment problems or problems related to how the Company performs functions in its processes. "Corrective action" is simply the "fix" that corrects the problem.

Whenever we take corrective action we also attempt to prevent the problem from recurring, which is known as "preventive action". There are times when preventive action is a standalone activity, specifically when reporting a problem that does not exist at the moment but could exist if something isn't done. Sources for preventive action opportunities include risk management, error proofing, failure mode and effects analysis and reports of product problems by external sources. Having a formal system to record and resolve both existing and potential problems ensures that these problems do not occur or reoccur, thereby improving our products, processes and work environment.

3.0 PROCEDURE: INTERNAL REPORTS

3.1 The Company utilizes a Request for Support (RFS) form to record both nonconformances related to its products, process and quality system as well as compliments or positive feedback. The form and system are [redacted]

3.2 ALL employees are empowered with the ability to report sources of problems and nonconformances.

3.3 No disciplinary action may be attached to the submission of RFS's.

3.4 The Quality Manager has been assigned the role of [redacted].

3.5 For the processing and routing of RFS's see Process Map.

3.6 If the responsible manager determines [redacted]

3.7 Actions taken shall [redacted]

3.8 The Quality Manager shall [redacted]

3.9 In addition to corrective action efforts, management shall [redacted].

3.10 The management review process shall [redacted]

3.11 Where product is suspected of a nonconformance, the Company shall [redacted]

4.0 PROCEDURE: INVESTIGATION & CORRECTIVE ACTION REQUESTS (ICAR's)

4.1 Any purchasing agent may [redacted]

4.2 ICAR's are processed through the same steps as the RFS but are routed to the Supplier for root cause analysis and action planning. ICAR's are logged separately.

4.3 Failure of a Supplier to respond to an ICAR or to respond with an insufficient action plan may [redacted]

5.0 PROCESS MAP

REQUEST FOR CORRECTIVE ACTION

1	RFCA#:	Date:	NCMR#:
2	☐ Internal	☐ External	
3	To:	Return To: Your Co. Attention: Address:	
4	[redacted]		
9	[redacted]		

Form Rev: Orig

Your Logo	**INVESTIGATION AND CORRECTIVE ACTION REQUEST**

ICAR Responsible Supplier: _____

Customer: _____ Part# _____ Applicable Customer P.O or Job # _____

Customer CA or corresponding documentation received? Y ☐ N ☐ Number: _____

[redacted]

7. [redacted]

9. Congratulate the Team!

Your Logo	**REQUEST FOR DEVIATION / WAIVER**	
1. NAME AND ADDRESS (Your Co)	2. CAGE CODE	3. RDW NO.
	4. PURCHASE ORDER NO.	5. DATE
	4a. PURCHASE ORDER LINE NO.	6. DEVIATION ☐ WAIVER ☐

7. [redacted]

[redacted]

[redacted]

[redacted]

[redacted]

12. [redacted]

[redacted]

[redacted]

[redacted]

[redacted]

Form Rev: Orig

FAILURE ANALYSIS REPORT

☐Nonconformance ☐Continuous Improvement Opportunity ☐Calculated Risk Release

SUBCONTRACTOR:_____ DATE RECEIVED: _____

FR#: SHEET _____ OF _____

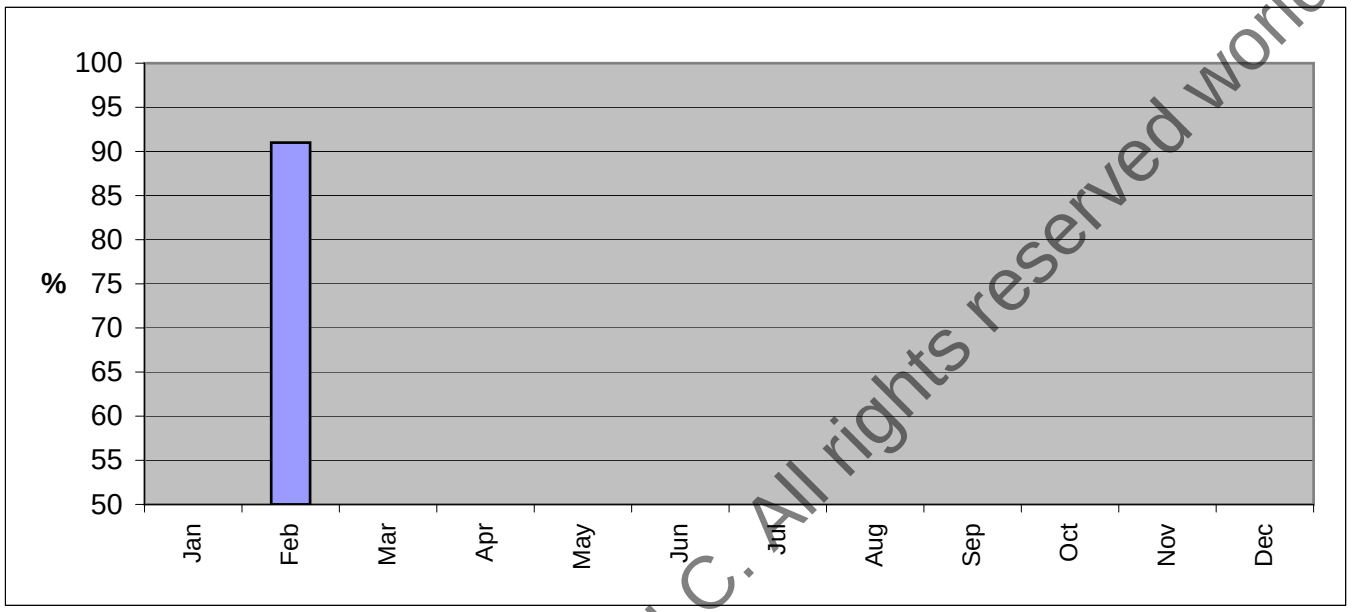
Noncon#:		TravOp:		Quantity Received:		Job Number:	
Item Name:		**Description: ID S/B Spec#, Para#, & IS Condition w/Quantity &Dimension Affected**					**# Discrepant**
Dwg/Spec:							
Part#:							
Part# Rev:							

ACN=Advance Change Notice; RFCA=Request for Corrective Action; RTV=Return to Vendor; Supplement=Add to Existing Procedure

Your Logo Use other side for additional information **Shaded Area for Administrative Use Only**

Form Rev: Orig

Supplier Performance Rating



Supplier Number: #

Production Quality Performance

Month	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov
Performance Report		91									
PDR Score		1									
PQR Score		.7									
PC Score		1									
RFCA Score		1									

Performance Rating Standards

Gold - 95% to 100%
Silver - 90% to 94%
Bronze - 80% to 89%
Yellow - <80%
Red - <50%

Supplier Name:	(name)
Overall Rating %:	91

Your Company Name
Address
Phone
Fax
Email

Pareto Analysis, (YEAR)
Request for Support Trend Chart

Date: _____

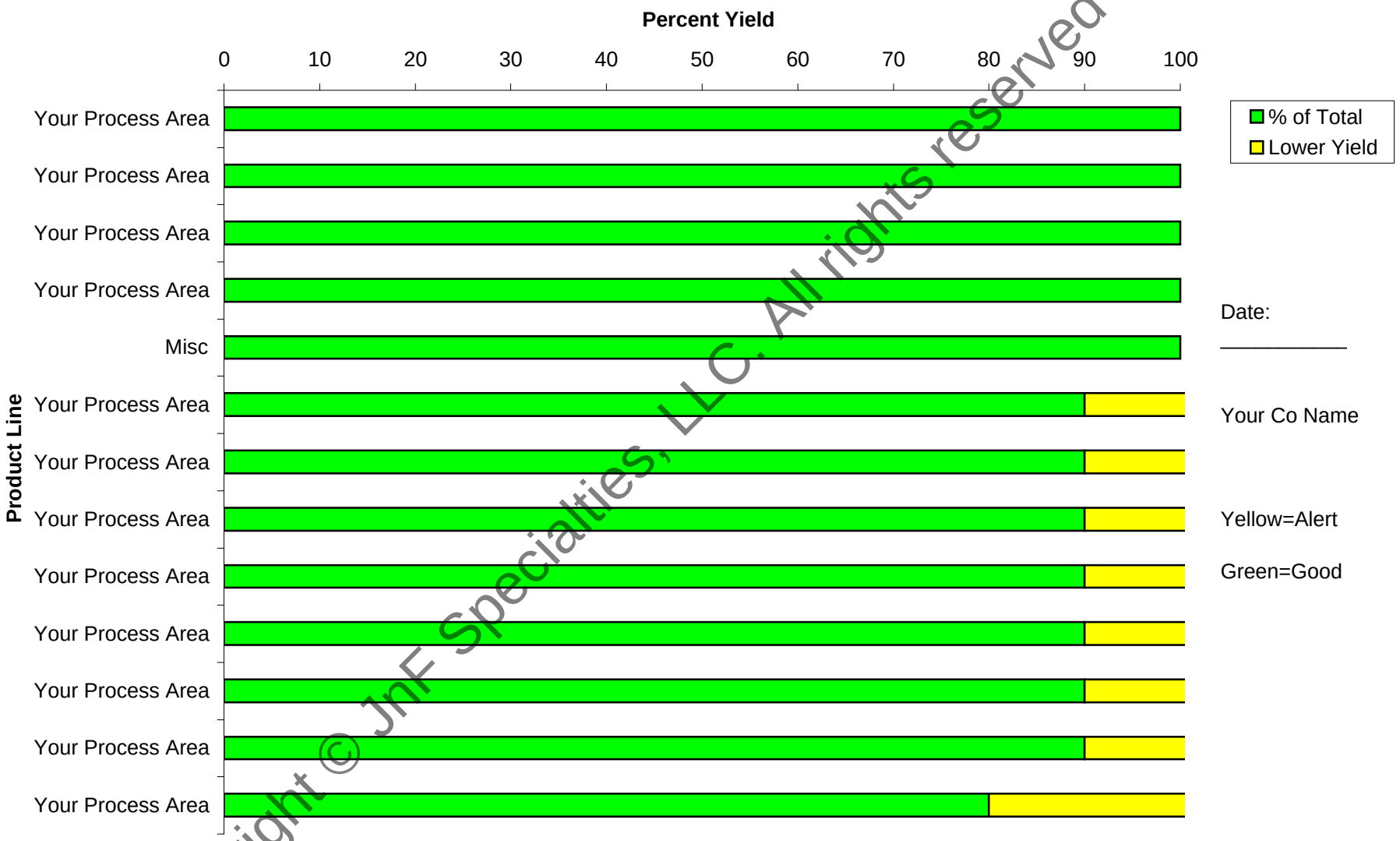
Your Co Name

Yellow=Alert

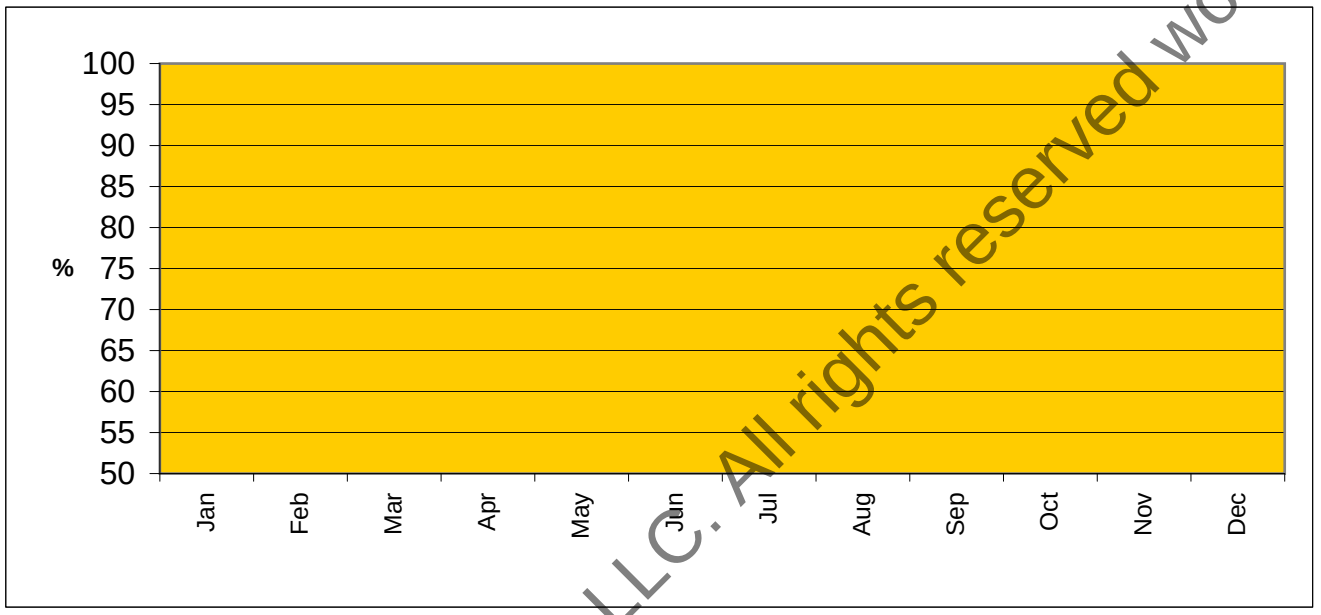
Green=Good

Form Rev: Orig

Pareto Analysis, year
Product Line Yields



Product Yield Rating



Product Yield Rating

Month	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	
Average Rating %												
Desired Yield												
Actual Yield												

Form Rev: Orig

Performance Rating Standards

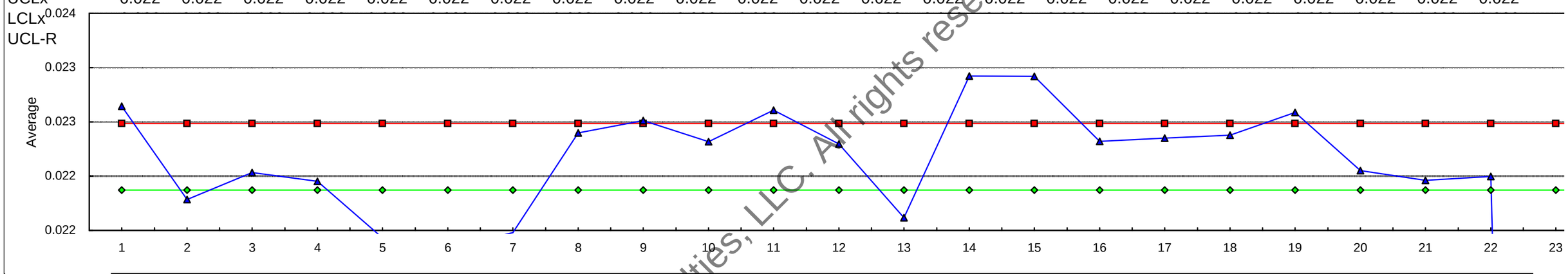
Gold - 95% to 100%
Silver - 90% to 94%
Bronze - 80% to 89%
Yellow - <80%
Red - <50%

Product Name:

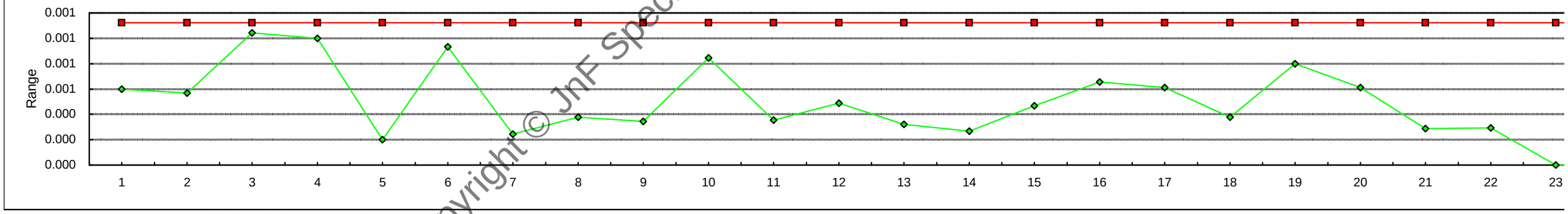
Overall Rating %: #DIV/0!

Your Co Name
Your Address
Phone: Your#
Fax: Your#
Email: Your email

Sample #	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	19	18	19	20	21	22
Comments:																							
Date:																							
Time:	11:19	11:35	11:51	12:07	12:30	01:30	03:30	06:09	06:58	07:46	08:34	09:22	10:11	10:59	11:47	12:35	01:24	01:24	02:12	04:44	05:33	06:21	
Operator:	YS	YS	YS	YS	RC	RC	RC	IS	IS	RC	DD	DD	IS	IS	RC	DD	YS	DD	DD	IS	IS	IS	
Sample 1	0.0229	0.0215	0.0218	0.0217	0.0214	0.0208	0.0216	0.0225	0.0225	0.0223	0.0226	0.0221	0.0214	0.0230	0.0226	0.0227	0.0222	0.0223	0.0230	0.0221	0.0220	0.0220	
Sample 2	0.0228	0.0220	0.0216	0.0224	0.0213	0.0216	0.0213	0.0223	0.0226	0.0224	0.0227	0.0225	0.0217	0.0228	0.0227	0.0220	0.0226	0.0224	0.0226	0.0219	0.0218	0.0218	
Sample 3	0.0223	0.0217	0.0226	0.0220	0.0215	0.0217	0.0216	0.0222	0.0224	0.0228	0.0224	0.0222	0.0217	0.0229	0.0231	0.0226	0.0221	0.0226	0.0222	0.0219	0.0219	0.0220	
Sample 4	0.0224	0.0218	0.0222	0.0214	0.0215	0.0212	0.0215	0.0224	0.0223	0.0219	0.0227	0.0221	0.0217	0.0229	0.0230	0.0222	0.0222	0.0224	0.0228	0.0219	0.0219	0.0220	
Sample 5	0.0227	0.0219	0.0220	0.0223	0.0215	0.0214	0.0215	0.0225	0.0227	0.0222	0.0226	0.0226	0.0217	0.0230	0.0231	0.0222	0.0227	0.0222	0.0223	0.0225	0.0221	0.0221	
Sum:	0.1132	0.1089	0.1102	0.1098	0.1072	0.1067	0.1074	0.1120	0.1126	0.1116	0.1130	0.1115	0.1081	0.1146	0.1146	0.1116	0.1118	0.1119	0.1129	0.1103	0.1098	0.1100	
Average: (x)	0.0226	0.0218	0.0220	0.0220	0.0214	0.0213	0.0215	0.0224	0.0225	0.0223	0.0226	0.0223	0.0216	0.0229	0.0229	0.0223	0.0224	0.0224	0.0226	0.0221	0.0220	0.0220	
Range - R	0.0006	0.0006	0.0010	0.0010	0.0002	0.0009	0.0002	0.0004	0.0003	0.0008	0.0004	0.0005	0.0003	0.0003	0.0005	0.0007	0.0006	0.0004	0.0008	0.0006	0.0003	0.0003	
Xbar Control ?	?	?	O.K.	O.K.	?	?	?	O.K.	?	O.K.	?	O.K.	?	?	?	O.K.	O.K.	O.K.	?	O.K.	O.K.	O.K.	
UCLx	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022	0.022
LCLx																							
UCL-R																							

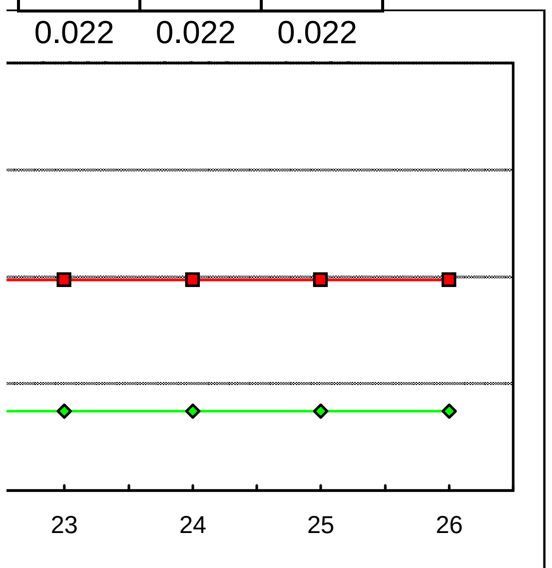


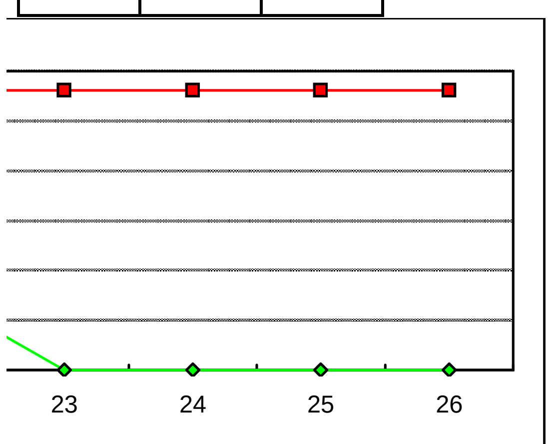
Range Control ?	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	O.K.	



The upper and lower control limit calculations are located under the x-bar graph

23	24	25	Grand Avg	Std.Dev.
				0.0005
			0.0222	
			0.0005	
0.022	0.022	0.022		

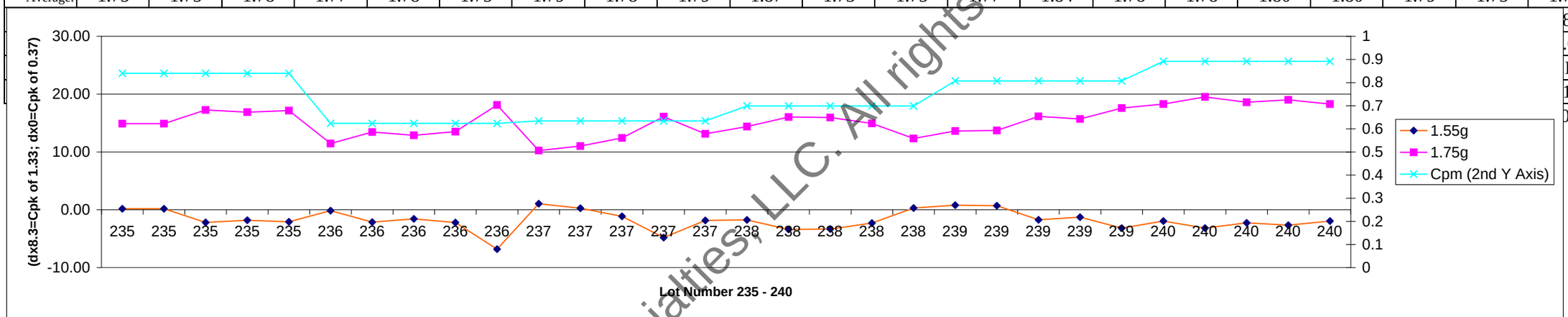




USL, g: 1.75 LSL, g: 1.55 Sample Process

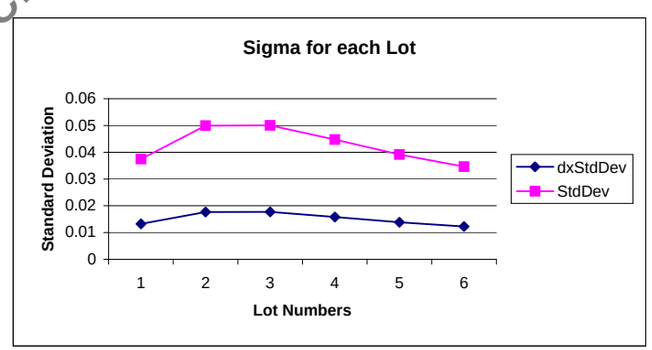
Process Acceptance Chart

Lot#:	235	235	235	235	235	236	236	236	236	236	237	237	237	237	237	238	238	238	238	238	239
Comment:																					
Date:																					
1	1.76	1.75	1.84	1.82	1.77	1.74	1.78	1.76	1.78	1.91	1.75	1.76	1.78	1.78	1.80	1.80	1.84	1.85	1.80	1.77	1.76
2	1.73	1.73	1.84	1.80	1.84	1.76	1.71	1.79	1.79	1.84	1.75	1.75	1.78	1.79	1.86	1.82	1.71	1.85	1.77	1.77	1.76
3	1.75	1.74	1.73	1.81	1.76	1.73	1.76	1.76	1.77	1.93	1.68	1.69	1.79	1.88	1.73	1.81	1.85	1.77	1.81	1.80	1.72
4	1.74	1.66	1.76	1.78	1.75	1.76	1.78	1.80	1.74	1.88	1.67	1.74	1.73	1.85	1.75	1.83	1.77	1.77	1.78	1.76	1.77
5	1.77	1.81	1.74	1.75	1.75	1.73	1.84	1.81	1.79	1.85	1.78	1.76	1.77	1.88	1.83	1.78	1.85	1.81	1.80	1.67	1.73
6	1.79	1.77	1.80	1.76	1.77	1.76	1.81	1.71	1.78	1.88	1.79	1.73	1.75	1.81	1.79	1.76	1.79	1.80	1.78	1.66	1.75
7	1.72	1.76	1.77	1.75	1.83	1.76	1.81	1.78	1.83	1.85	1.70	1.75	1.76	1.83	1.77	1.70	1.84	1.77	1.76	1.78	1.71
8	1.72	1.76	1.75	1.72	1.75	1.78	1.81	1.81	1.83	1.82	1.73	1.78	1.80	1.86	1.73	1.72	1.78	1.80	1.79	1.75	1.71
Average:	1.75	1.75	1.78	1.77	1.78	1.75	1.79	1.78	1.79	1.87	1.73	1.75	1.77	1.84	1.78	1.78	1.80	1.80	1.79	1.75	1.74



$$dx = \frac{avg - LSL}{\sigma / \sqrt{n}} > 4\sqrt{n} - 3$$

$$dx = \frac{USL - avg}{\sigma / \sqrt{n}} > 4\sqrt{n} - 3$$



dx provides a means to answer the question:
Are we making acceptable parts? -- instead of -- Are we in control?

The Cpm capability index depends on both variability and centering.

This is not a control chart

Acceptance is based on the Lower Acceptance Limit

Process Acceptance Chart

239	239	239	239	240	240	240	240	240
1.79	1.72	1.78	1.77	1.80	1.73	1.78	1.80	1.76
1.67	1.74	1.80	1.80	1.80	1.79	1.77	1.84	1.84
1.74	1.80	1.77	1.79	1.76	1.84	1.79	1.79	1.73
1.75	1.81	1.78	1.90	1.78	1.83	1.73	1.80	1.73
1.76	1.80	1.73	1.78	1.76	1.76	1.75	1.78	1.80
1.74	1.77	1.73	1.79	1.78	1.81	1.80	1.73	1.85
1.74	1.75	1.78	1.81	1.72	1.79	1.79	1.76	1.77
1.73	1.80	1.77	1.71	1.79	1.76	1.81	1.76	1.71
1.74	1.77	1.77	1.79	1.77	1.79	1.78	1.78	1.77
0.72	-1.71	-1.26	-3.16	-1.94	-3.17	-2.25	-2.66	-1.94
13.72	16.15	15.70	17.60	18.29	19.52	18.60	19.01	18.29
O.K.	Out	Out	Out	Out	Out	Out	Out	Out
0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113
0.80716	0.80716	0.80716	0.80716	0.89172	0.89172	0.89172	0.89172	0.89172

Lot#:	235	236	237	238	239	240
dxStdDev	0.01325	0.01766	0.0177	0.01582	0.01385	0.01223
StdDev:	0.03748	0.04995	0.05005	0.04473	0.03918	0.0346
Avg:	1.765	1.79525	1.77275	1.783	1.76275	1.77925

Add to Cart