

Inspection

The supplier is to perform a dimensional inspection and record the results. Actual dimensions are to be recorded and reported for each piece inspected. A range of dimensions representing all units delivered is not acceptable. The use of check marks or “OK” is not acceptable except in the case of tool-controlled dimensions. If tooling is used to control or accept dimensions it must be validated prior to use and a First Article Inspection report prepared for the tool-controlled dimensions. The resulting FAI report shall be included with the certification package. Unless otherwise specified on the drawing or purchase order, dimensional inspection will be performed as follows:

Nondestructive inspection, and inspection of critical and major characteristics as defined on the drawing, shall be performed on each piece. Minor characteristics shall be inspected 100% on selected parts being sampled. Parts manufactured per purchase order line item with minor characteristics on the drawing shall be sample inspected at a minimum in accordance with ANSI Z1.4, Single sampling, General Inspection Level II, Normal Inspection. The AQL shall be chosen such that AC=0, RE=1. See the table below for an inspection plan meeting these requirements.

Note: When one piece is being procured, 100% inspection applies to all characteristics and shall be submitted with shipment.

Lot size	Critical	Major Characteristics	Minor
1	100%	100%	1
2 to 8	100%	100%	2
9 to 15	100%	100%	3
16 to 25	100%	100%	5
26 to 50	100%	100%	8
51 to 90	100%	100%	13
91 to 150	100%	100%	20
151 to 280	100%	100%	32
281 to 500	100%	100%	50
501 to 1200	100%	100%	80
1201 to 3200	100%	100%	125

- An attribute that is sample inspected and found discrepant shall be 100% screened.
- The supplier’s inspection report must assure traceability to the purchase order items.