


Supplier First Article Inspection

Work Instructions 04-04-010
Compliance with QAI 03-01-125

Supplier Delegated Inspection Program



Address http://ictwebdev01/about_us/scm_specifications.htm Go Links

Supplier Information

Contractual Flowdown Specifications

EDI
 EDI Guide MRP Forecast Requirements X12 830 Release 1-1
 EDI Guide Purchase Order Change X12 860 Version 4010 Release 1-1
 EDI Guide Purchase Order X12 850 Version 4010 Release 1-1
 EDI Guide Scheduling Agreement Release X12 830 Version 4010 Release 1-1

Beech Specs
 BS23431 Electrostatic Discharge Sensitive Device Protection Revision F
 BS24405 Source Control for Electrostatic Discharge Sensitive (ESDS) Devices Revision D
 BS25526 Specification for Stress and Enbrittlement Processes Revision
 BS25691 Control of Manufacturing Processes For Suppliers and Outside Production

Barcode (software)
 Barcode Software Frequently Asked Questions
 Raytheon Receiving Bar Code Label Specification Revision B

Supplier Delivery Requirements Specification
 Raytheon Aircraft Company Supplier Delivery Requirement Specification 01-03

Supplier Delegated Inspection Program
 QAI 03-01-125: Supplier Delegated Inspection Program

First Article Inspection
 WI: Supplier First Article Inspection
 FORM: Supplier First Article Checklist Cover Sheet
 FORM: Supplier First Article Inspection (FAI)
 FORM: Supplier FAI Continuation Attachment
 FORM: Assembly Tools Record
 FORM: Assembly FAI Summary

Available on the web:

- **WI 04-04-010: Supplier First Article Inspection**
- **FAI Forms**
- **QAI 03-01-125: Supplier Delegated Inspection Program**

• <http://www.hawkerbeechcraft.com>

- About Us
- Supply Chain Management
- Supplier Information
- Contractual Flow down
- Select “Specifications”

Procedures and Responsibilities

Completing a First Article Inspection Report (FAIR) for Hawker Beechcraft Corporation involves:

- **Compliance with drawings: Drawing revision must be validated to the PO.**
 - Engineering Drawing
 - Engineering Change Order
 - Part List
- **Compliance with specifications**
- **Compliance with Condition of Supply (COS) or Manufacturing Planning (MFP)**
- **Compliance with Purchase Orders (PO) requirements**

Suppliers using AS9102 forms must refer to HBC FAI Work Instruction 04-04-010 and complete additional requirements in this Work Instruction such as:

- **Checklist**
- **Assembly Tools Records when applicable**

FAIR Record and Retention

- The completed FAIR package will be filed at the supplier for a minimum of 5 years for All Delegated Suppliers.
- The completed Checklists Cover sheet will be provided to HBC QA contact Electronically.
 - **Example of documentation in an FAIR:**
 - Manufacturing Routing Sheets
 - Complete FAI forms
 - Reference Exhibits supporting FAI
 - Material certifications
 - Special process/operator certifications
 - Inspection plans
 - Process capability studies
 - Gauge correlation
 - Drawing correlations to FAI
 - Part marking replication

FAI Training

Identification of FAI Forms / Common Practices

- **FAI identification number**
 - **Provided by supplier**
 - **It is usually the Job Number or Routing Number**
 - **Located on the top right section of report sheet**

- **Do not leave any item (cell) blank, write N/A in the cell when an item is non applicable**

- **Voiding line items or specific entry**
 - **One line cross out in ink**
 - **Date voided**
 - **Initialed by person voiding**
 - **Description of void on reverse side of document**
 - **Signature, stamp and date shall accompany the description of void**

FAI Training

Checklist Cover Sheet (78-33607)

Checklist Cover Sheet (78-33607)

- ID (Work or Job Number)
- Supplier Name
- Date of FAI
- Engineering Part Number and Rev.
- COS / MFP Number and Rev.
- Purchase Order Number

The supplier should also record:

- Engineering Revision Number
- HBC Purchase Order Number

On this Checklist

Submitted electronically
to HBC

Supplier First Article Checklist Cover Sheet

Supplier Name: _____ ID#: _____
 Part Number: _____ Rev: _____ FAI Date: _____
 COS / MFP: _____ Rev: _____ PO #: _____

Section 1: Manufacturing Planning (Supplier planning meet: the name of EAC planning for special processing, sequence, scheduled specifications, & special operations.)
 All Dies Used: _____
 All Assembly: _____

Section 2: Processing Documents (All required processing documents [include drawings], EAC & industry standards, are current and available to the supplier.)
 Supplier File Current: _____
 EAC Document Control List for Supplier for Revisions: _____
 Supplier Has Google Access: _____

Section 3: Purchase Order (Both EAC and Supplier Purchase Order reflect required quality requirements including MISCs (Miscs/Miscs) Group coding correct.)
 EAC Purchase Order: _____
 Supplier Purchase Order or Subject: _____

Section 4: Inspection Method (All inspection methods have been verified.)
 Electronic: _____
 Manual: _____
 Tool: _____

Section 5: Tooling (All tooling is accountable in a tool control system which includes ~~inspection~~ requirements.)
 EAC: _____
 Supplier: _____

Section 6: First Article Inspection
 Final Miscs / Certifications: _____
 Processing Certifications: _____
 All Drawing Dimensions/Spec: _____
 Fit Check (If Required): _____

Section 7: Production Quality Inspection Plan generated (EAC/Supplier) _____

Assembly

- **First Article Inspection of an Assembly Involves:**
 - **Checklist Cover Sheet (78-33607)**
 - **Supplier First Article Inspection (78-33608)**
 - **Assembly Tools Record (78-33610)**
 - **Assembly FAI Summary (78-33611)**
 - **Detail FAIR Package(s) for each component as required**

FAI Training

Complete Package Layout

	<u>ID # Examples</u>
1 Checklist Cover Sheet (assembly)	
2 Assembly FAI Summary	ID# A_1
3 Assembly Tolls Record	
4 FAI (assembly) Tool	
5 Checklist Cover Sheet (primary detail)	
6 FAI (primary detail)	ID# A_2
7 Continuation Attachment (primary detail)	
8 Checklist Cover Sheet (secondary detail)	
9 FAI (secondary detail)	ID# A_3
10 Continuation Attachment (secondary detail)	

- The checklist will be sent to HBC through SQA contact for the Supplier electronically.
- **For Government products only: the complete FAI package must be shipped with the parts.**