

QNP	<p>Production Inspections: OP-86-01 Rev NC</p> <p>Effective Date: Owner Approval by Andrew Adams, QA Manager, on 12-6-17 Management Approval by Craig O. Garneau, President on 12-6-17</p> <p><i>Printed copies of this document are for information purposes only and are uncontrolled. Printed copies are not valid after the date of printing.</i></p>
Production Inspections	

1. PURPOSE

To provide a consistent method for verifying that product requirements have been met at the appropriate stages in production at QNP

2. RESPONSIBILITY

The table below identifies QNP personnel and their responsibility relating to this procedure:

Person	Responsibility
Quality Planning Personnel	<p>Generate shop orders, FM-81-01, and Production Inspection Forms, FM-86-01.</p> <p>Ensure that the package of information traveling with an order provides inspectors with the appropriate criteria/requirements for performing inspections.</p>
Inspection Personnel	<p>Perform inspections in accordance with the requirements of this operating procedure and related work instructions.</p> <p>Work with department supervisors and MRB members to reconcile inconsistencies, errors and nonconformities</p>
MRB Members Department Supervisors	<p>Provide training</p> <p>Assist in performing inspections and reconciling nonconformities as required.</p>

3. APPLICABLE FORMS OR REFERENCES

The table below identifies the code number and title of documents and references applicable to this procedure;

Form/Reference Number	Title
AS9100	Quality Management Systems - Requirements for Aviation, Space and Defense Organizations
ASQR-20.1	UTAS - Supplier Sampling Requirements
AS9102	First Article Inspection Form
FM-81-01	Shop Order/Quality Plan
FM-86-01	Production Inspection Form
FM-86-02	QNP Final Inspection Form
FM-86-03	QNP Certificate of Conformance
OP-71-01	Control of Inspection, Measurement and Test Equipment
OP-75-01	Control of Documented Information
OP-87-01	Control of Nonconforming Outputs

4.1 - All personnel at Quality Name Plate are responsible for quality, and have the authority to contain non-conformities. The authority and training received for individuals to perform specific inspections is documented in QNP's Employee Training Database.

4.2 - The results of Production Inspections are recorded on Production Inspections Report, FM-86-01 which accompanies a Shop Order, FM-81-01 throughout the production process. The sections/inspection points appearing on a Production Inspection Form are customized by processes specific to the order. Quality Planning and MRB personnel may add additional inspection requirements to the Production Inspection Form in response to any special identified risks.

As appropriate, the means for collecting and storing inspection data may be moved to an on-line system independent of the paper copy of FM-86-01. In all cases, inspection data is retained as a quality record per the requirements of OP-75-01 Control of Documented Information.

4.3 - The criteria for acceptance or rejection of parts may be determined from;

- Blueprint tolerances and notes
- Customer instructions
- Instructions on the Shop Order, FM-81-01

- Employee training and experience
- Management direction
- Production Inspection Report, FM-86-01

4.4 - The measuring equipment used for production inspections are controlled through OP-71-01 Control of Inspection, Measuring and Test Equipment. If specific measuring instruments are required for an inspection point, it shall be specified on the Production Inspection Form, FM-86-01, or the Shop Order, FM-81-01.

4.5 - When a production inspection determines that parts do not meet requirements, the affected parts shall be controlled per OP-87-01, Control of Nonconforming Outputs.

4.6 - When sampling inspection is to be used as a means for product acceptance, the sampling plan shall be based on ASQR-20.1 which employs recognized statistical principles and is appropriate to QNP's inspection requirements.

4.7 - QNP does not typically release parts into production before all required inspections have been completed. Should that occur, the product shall be identified and recorded on the Production Inspection Report, FM-86-01 to allow for recall and replacement if it is subsequently found that the parts do not meet requirements.

4.8 - QNP does not typically release product to the customer before all planned arrangements have been satisfactorily completed. Should that be necessary, the customer or a relevant authority shall be contacted for approval. A record of the approval shall be documented on the Production Inspection Report, FM-86-01.

4.9 - When required by customer contract, QNP shall provide the necessary documented evidenced to demonstrate that product meets the defined requirements. This documentation may be presented as;

- The Production Inspection Report, FM-86-01
- A QNP final inspection report, FM-86-02
- A QNP certificate of conformance, FM-86-03
- A customer supplied inspection report or certificate of conformance
- AS9102 Aerospace First Article Inspection Report

All documents required to accompany the product shall be completed and delivered by the time of product delivery.

4.10 - Various methods may be used to monitor inspection points. They shall be used to determine the effectiveness of the inspection point, reduce the risk of nonconforming product being incorrectly accepted, and drive continuous improvement to the In Process and Final Inspection Process.

5. RECORDS/OBJECTIVE EVIDENCE

The retention duration for records referenced in this procedure are available on-line in the FM-75-01 Master Document List with Revision History.

Records are maintained in accordance with OP-75-01 Control of Documented Information.

6. REVISION HISTORY

Revision, approved date, effective date, and a document change summary for this document is located on-line in the FM-75-01 Master Document List with Revision History.