

AESQ First Article Inspection (FAI) RM 13102 Webinar

Welcome! We will start the webinar shortly.



AESQ – Aerospace Engine Supplier Quality Strategy Group

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Webinar Overview

We are **recording** today's webinar and will distribute the video link following the close of the webinar. It will also be posted on the AESQ website for free viewing.

We will take **questions** during today's webinar using the **Chat** feature.

Please remain on Mute during the presentation to prevent background noise. We will also be muting all lines at the start of the session.



AESQ First Article Inspection (FAI) RM 13102 Webinar



Carrie Sharkey
Rolls Royce



Larry Bennett
GE Aviation



Michele Althoff
Pratt & Whitney



Jason Sink
GE Aviation



Gary Maret
Consolidated Precision Products



Klaus Dietershagen
MTU Aero Engines

AGENDA			
	Topic	Presenter	Duration
1	Introduction to Event	Carrie Sharkey	5
2	AS13100 Requirements specific to FAIR (8.5.1.6)	Carrie Sharkey	10
3	FAIR Reference Manual RM 13102	Carrie Sharkey Michele Althoff	20
4	SMIG Purpose and Accountabilities	Michele Althoff	10
5	CoP LinkedIn page	Gary Maret	5
6	FAIR Challenges	Jason Sink	10
7	Future Plans for SMIG	Carrie Sharkey	5
8	Q&A-post in chat	Klaus Dietershagen	25

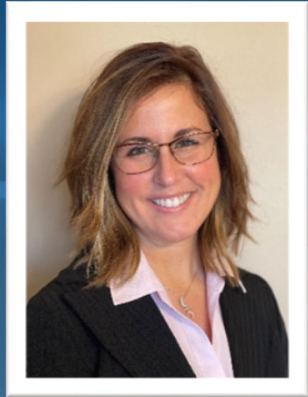
FAIR-First Article Inspection Report
CoP-Community of Practice
SMIG-Subject Matter Interest Group
Q&A-Questions and Answers

AESQ – Aerospace Engine Supplier Quality Strategy Group

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Total: 1.5hrs ³

AS13100 REQUIREMENTS SPECIFIC TO FAIR (8.5.1.6)



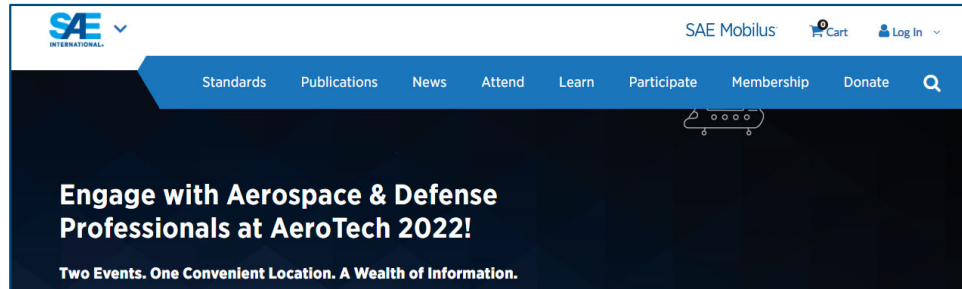
CARRIE SHARKEY
MANUFACTURING ENGINEERING PROGRAM MANAGER
ROLLS ROYCE

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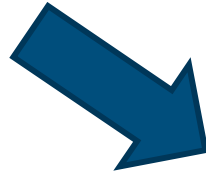
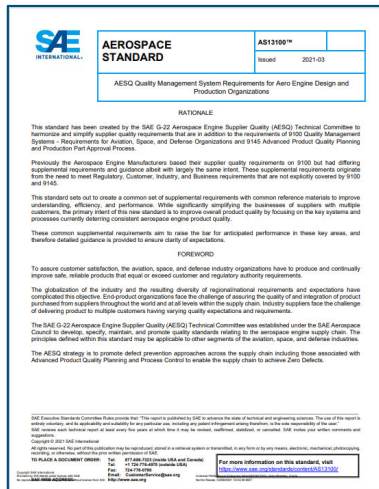
AS13100 Requirements-Section 8.5.1.6



- Where to find AS13100?
- www.sae.org
- Search for AS13100



- You will find the standard listed



STANDARD

AESQ Quality Management System Requirements for Aero Engine Design and Production Organizations

2021-03-01 **CURRENT** AS13100

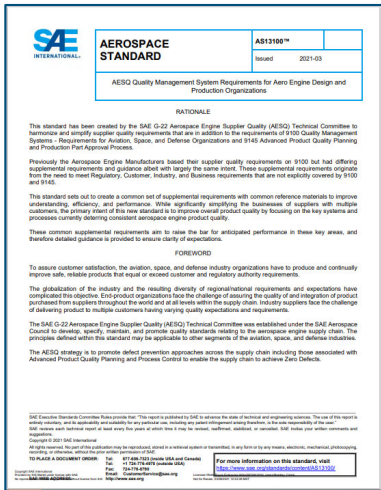
This standard establishes supplemental requirements for 9100 and 9145 and applies to any organization receiving it as part of a Purchase Order or other contractual document from a customer. **AS13100** also provides details of the Reference Materials (RM13xxx)...

Most organizations have subscriptions

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AS13100- AESQ Quality Management System Requirements for Aero Engine Design and Production Organization



This standard establishes supplemental requirements for 9100 and 9145 and applies to any organization receiving it as part of a Purchase Order or other contractual document from a customer.

AS13100 also provides details of the Reference Materials (RM13xxx) developed by the SAE G-22 AESQ committee and listed in Section 2 - Applicable Documents, that can also be used by organizations in conjunction with this standard.

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8.5.1.6 First Article Inspection (FAI) – Supplemental Requirements

Topic

AS9102

Applications

When to
perform a FAIR

The Organization shall:

- Perform FAI in compliance to 9102, see RM13102.
- In addition to the requirements of 9102 apply FAI to:
 - Unique single run production orders not intended for ongoing production (e.g., out-of-production spares). Use of a modified or an alternative approach to this requirement may be used if agreed with the customer. Does not apply to nonproduction applications (e.g., development, prototypes).
 - A Kit with a defined 'Bill of Parts', to provide evidence all parts in the 'Kit' have an approved FAIR.
- Perform FAI when:
 - The production source is not able to provide evidence of an approved 'Complete' FAI report. Where the product predates the requirement for FAI then an approved configuration or equivalent process that was agreed with the customer will be acceptable.
 - Product is to be resourced and the customer requires a FAIR prior to production ceasing in the existing source. [This can be referred to as Last Article Inspection (LAI) Report].
 - Requested by a customer.

8.5.1.6 First Article Inspection (FAI) – Supplemental Requirements



Topic

Assessment to determine verification

Inspection

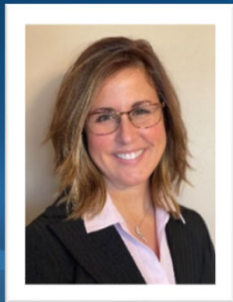
- equipment
- final product measurements

Submission System

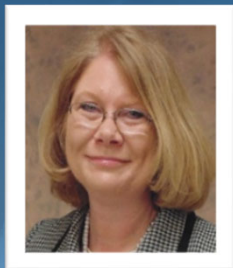
Cascade

- Conduct an assessment, carried out by a competent person, to determine the required verification when changes occur that can invalidate a previous FAI. The assessment is to consider:
 - The impact of the change on the ability of the production method to meet product design characteristics.
 - Equipment and associated software programs, personnel, and environment.
 - The accumulation of changes covered by partial FAI or Dimensional/Non-dimensional Reports which may warrant a repeat full FAI being performed.
- Retain a formal record of the assessment for audit purposes, (8.5.6).
- Verify characteristics in the final product, i.e., after all production activities have been completed (unless otherwise instructed by the Product Definition), including:
 - Ensuring Inspection equipment is:
 - Traceably calibrated, within its valid calibration period, and measurement systems to be assessed are in accordance with 7.1.5.1.1 and Table 3.
 - Independent of production inspection equipment. Except when the production inspection process is automated and cannot be influenced by Production Staff, or FAI results are obtained by personnel that only carry out product verification, e.g., Inspectors. Where independent inspection measurement is not practicable, then the use of production inspection equipment may be acceptable if approved by the customer.
 - Ensuring characteristics not accessible in the final product are measured during the production process.
 - When subsequent production activities can affect the characteristics, ensuring they are verified by destructive means, unless it can be shown (with evidence included in the FAIR) that the characteristic in the final product is not different (is equivalent) to the characteristic verified during the production process, this does not apply when the Product Definition instructs the characteristics to be verified prior to the Production Activity, e.g., coating, painting, shot peening).
- Compile and submit a FAIR using the customer electronic system for FAIR submittal (e-FAIR), ensuring:
 - The submission follows the purchase order cascade, e.g., Tier-2 to Tier-1 to OEM Customer, unless otherwise instructed.
 - When a supplier does not have access to e-FAIR, that the forms in 9102 are used, in conjunction with any Customer specific forms (e.g., Customer Checklist).
- Only release product into customer against a 'Complete' or 'Not Complete' FAIR, as defined within 9102.

FAIR REFERENCE MANUAL RM13102



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MANUFACTURING ENGINEERING PROGRAM MANAGER
ROLLS ROYCE



MICHELE ALTHOFF
MANAGER, QUALITY ASSURANCE CUSTOMER SUPPORT
PRATT AND WHITNEY

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FAIR Reference Manual RM 13102

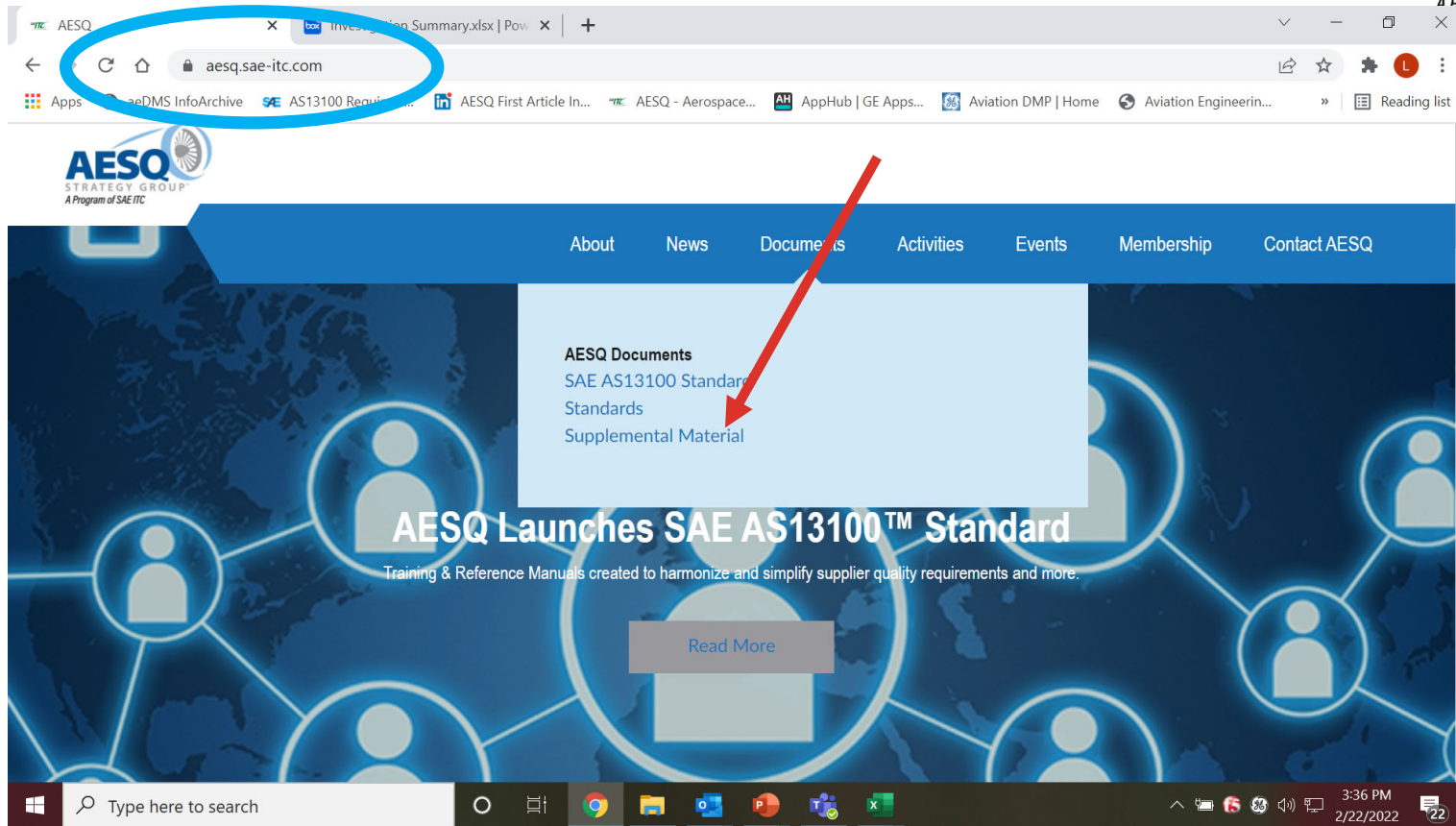
- How to find
- Summary of sections



FAIR-First Article Inspection Report

FAIR Reference Manual RM 13102

How to find



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FAIR Reference Manual RM 13102 How to find



RM#	Reference Manual and Forms	Issue Date
RM13102	First Article Inspection	March 15, 2021

FAIR Reference Manual RM 13102 **Summary of sections**

Section 1.0 – Relationship Between FAI and PPAP (Production Part Approval Process)

- Explains the purpose of both documents
- Explains the differences between the two documents
- Explains the relationship between the two documents



FAIR Reference Manual RM 13102 Summary of sections

Section 2.0 – Scope of First Article Inspection



- FAI requirements are aligned to AS9102 for elements that are common across Aero Engine Original Equipment Manufacturers.
- Requirements that are not common, but specific to an OEM, are defined in that companies 'Supplier Management System Requirements'.

FAIR Reference Manual RM 13102 Summary of sections



Section 3.0 – Application of First Article Inspection

FAI applies to:

- Assemblies, sub-assemblies and detail parts, including castings, forgings and modifications to standard catalogue or Commercial-Off-the-Shelf (COTS) items. (AS9102 1.3)
- Unique single run production orders not intended for ongoing production (e.g., out-of-production spares)
- When all forged surfaces on a forging are subsequently machined, the requirement for a FAIR is at the discretion of the customer;
- When an operation in a production method e.g., machining, special process, is contracted to a sub-tier source and FAI is required, the contracting party is responsible for compiling the FAIR.

Unless contractually required, FAI does not apply to:

- Product designed to be temporarily fitted to an engine for protection during transportation, e.g. engine intake cover, fabric covers for exposed ducting and may be identified with 'For Transportation Only' or similar wording.
- Product released by the customer to a supplier.
- Product designed or modified specifically for an instrumentation application.

FAIR Reference Manual RM 13102 Summary of sections



Section 4.0 – Partial or Re-Accomplishment of FAIR

AS9102 4.6. f. refers to the effect or potential effect on fit, form or function of a change as a driver for performing full or partial FAI for affected characteristics.

- Fit and form are discernible by the manufacturer from the Product Definition.
- Function would be identified by the application of Fixed Process or the assigning of characteristic as a KPC.

FAIR Reference Manual RM 13102 Summary of sections



Section 5.0 – Plan First Article Inspection

FAI planning should include:

- Determination of design characteristics required for product realization and assigning of a unique identifier.
- Defining the construct of FAIRs for an Assembly, its Sub-Assemblies, Assy Details, Detail parts and material. This may be achieved through a Cascade Diagram (Figure 7 Example)
- Identifying supporting documents to be included in a FAIR (Reference Table 1 – list of elements and alignment with their requirement in AS9102).

FAIR Reference Manual RM 13102 Summary of sections



Section 6.0 – Execute First Article Inspection

- The organization shall use a representative item from the first production run
- When a conventional machining operation is carried out by a sub-tier, this could be captured in Form 2 e.g., put ‘Op30 - subcon machining’ under process name and identify the source and their release document in subsequent columns.
- AS9102 Forms
 - Full FAIR - Forms 1, 2 and 3 to be populated.
 - Partial FAIR - Form 1 to be populated; Forms 2 and 3 only when required by the ‘Reason for a Partial FAIR’. (i.e., only data fields where data is changed from a previous FAIR).
 - Data fields to be completed IAW instructions in AS9102
 - (R) Required
 - (CR) Conditionally Require
 - (O) Optional

FAIR Reference Manual RM 13102 Summary of sections



Section 7.0 – Approve First Article Inspection Report

To confirm conformance with design characteristics and ensure the requirements of AS9102 4.5 have been met, the following guidance should be used when reviewing a FAIR:

- a) Guidance on reviewing Form 1 - Product content
- b) Guidance on reviewing Form 2 - Material content
- c) Guidance on reviewing Form 2 - Special Process content
- d) Guidance on reviewing Form 2 - Functional Test content
- e) Guidance on reviewing Form 2 - Sub-tier Conventional Machining content
- f) Guidance on reviewing Form 3 - Characteristic Accountability content
- g) Guidance on reviewing Form 3 - Part Marking content
- h) Dispositioning of a First Article Inspection Report
- i) Customer approval of a First Article Inspection Report
- j) When is a First Article Inspection Report 'Complete' scenarios

FAIR Reference Manual RM 13102 Summary of sections



RM13102 - First Article Inspection

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FAIR Reference Manual RM 13102 Summary of sections



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SMIG PURPOSE & ACCOUNTABILITIES



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MANAGER, QUALITY ASSURANCE CUSTOMER SUPPORT
PRATT AND WHITNEY

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Purpose of First Article Inspection (FAI) Subject Matter Interest Group (SMIG)



- It is accountable for the AS13100 related Requirements (8.5.1.6) and associated Reference Manual (RM13102) content, ensuring that it is up to date and reflects current knowledge and best practice.
- It shall promote the effective deployment of the Reference Manual using Communities of Practice (CoP). The CoP is open to any subject matter expert from the AESQ Member Companies and the wider AESQ supply chain. Activities may include webinars, best practice sharing, development of shared training materials, conferences and published papers.

Accountabilities of Subject Matter Interest Group (SMIG)



- The SMIG is responsible for ensuring that the AS13100 associated requirements (8.5.1.6) and RM13102 represent the best practices for the subject and that the requirement is clear, concise and understood. The group will respond to feedback from users regarding the RM13102 related content. Any feedback from users on AS13100 (8.5.1.6) shall be directed to the writing team (using link located in the AS13100 standard).
- The SMIG is accountable for the content of the associated Reference Manual (RM13102) ensuring that it reflects the latest thinking, best practice examples and that it remains aligned to the intent of the AS13100 standard. It will update the Reference Manual (RM13102) when necessary to ensure that it is up to date. Updates to the manual will go through a review before publication.
- The SMIG shall ensure that there is suitable information available globally to support the deployment of the Reference Manual. The information sharing may be provided through Webinars and events to provide the supply chain access to our subject matter experts.

Accountabilities of Subject Matter Interest Group (SMIG)



- The SMIG is responsible for the promotion of the subject to show what benefits can be delivered. It will document best practice and case studies and publicize these (e.g., websites, supplier events, articles, webinars).
- The SMIG shall establish a Community of Practice to engage the group with the users from across the supply chain. These forums will be used to gain user feedback, share successes and best practice for use in updating the Reference Manuals and the AS13100 standard.
- The SMIG team leader shall provide updates to the AESQ deployment strategy team.

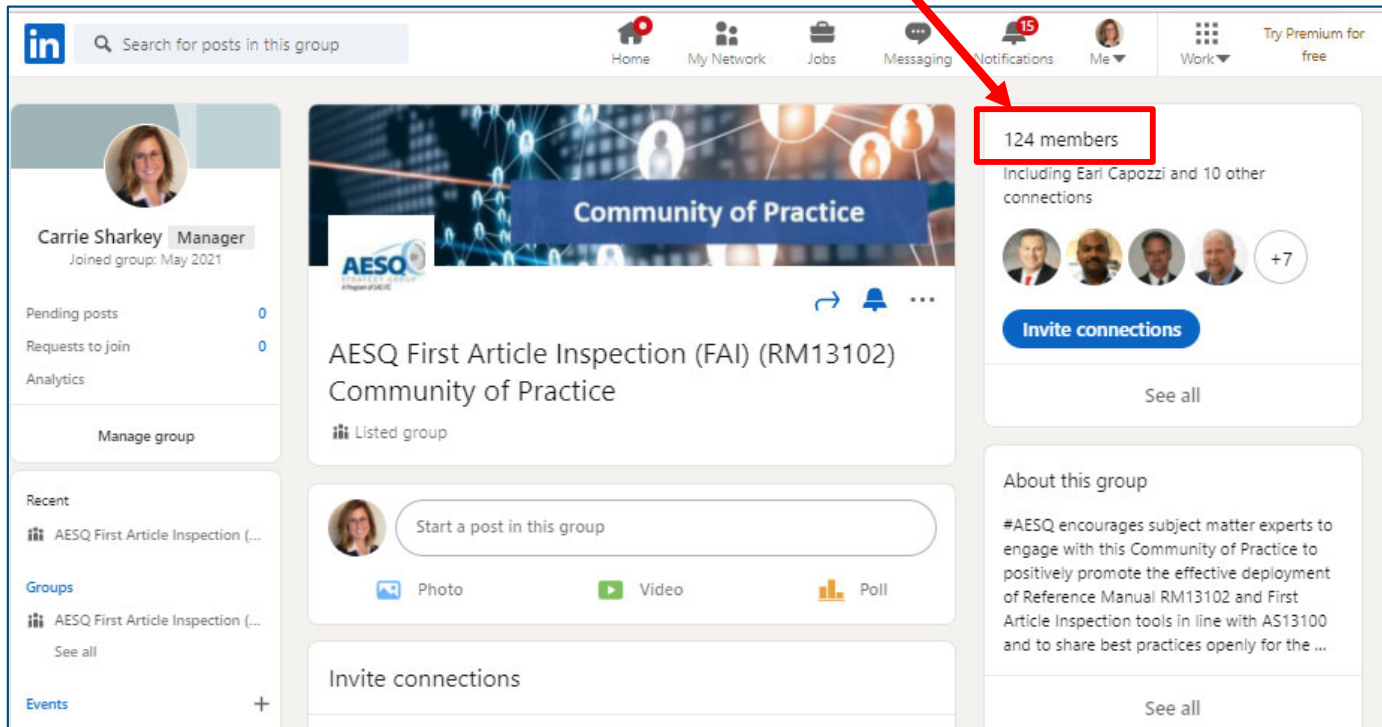
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GARY MARET
QUALITY MANAGER
CONSOLIDATED PRECISION PRODUCTS

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Community of Practice (CoP)



The screenshot displays the LinkedIn interface for a group. At the top, navigation icons for Home, My Network, Jobs, Messaging, Notifications (15), Me, and Work are visible. The group profile shows Carrie Sharkey as the Manager, joined in May 2021. The group name is 'AESQ First Article Inspection (FAI) (RM13102) Community of Practice', a listed group. A red box highlights '124 members', with a red arrow pointing to it from the title above. Below this, it says 'Including Earl Capozzi and 10 other connections' and shows profile pictures of several members with a '+7' icon. A blue 'Invite connections' button is present. The 'About this group' section states: '#AESQ encourages subject matter experts to engage with this Community of Practice to positively promote the effective deployment of Reference Manual RM13102 and First Article Inspection tools in line with AS13100 and to share best practices openly for the ...'. A 'Start a post in this group' section offers options for Photo, Video, and Poll. An 'Invite connections' section is also visible at the bottom.

- LinkedIn Page but want to function like a CoP
- Request an Invite to join the CoP
- Encourage comments or questions through postings
- Encourage suggestions on 'what's next' through postings
- SMIG to review monthly at a minimum
- **Get Involved!**

FAIR CHALLENGES



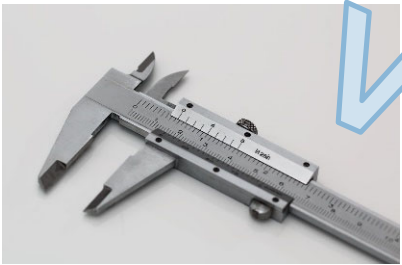
JASON SINK

SENIOR QUALITY MANAGER-BUSINESS PROCESS MGMT
GE AVIATION

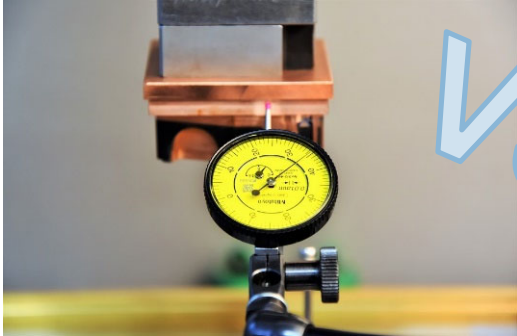
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FAIR - Challenges

Variable Results



VS

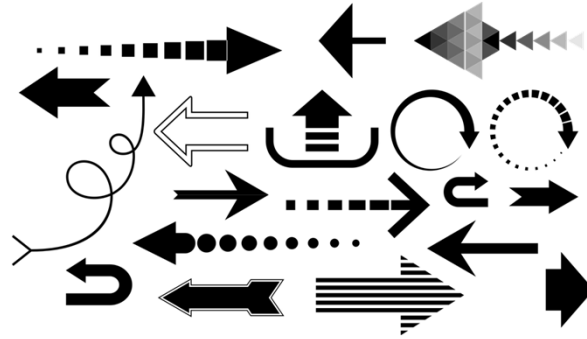


VS



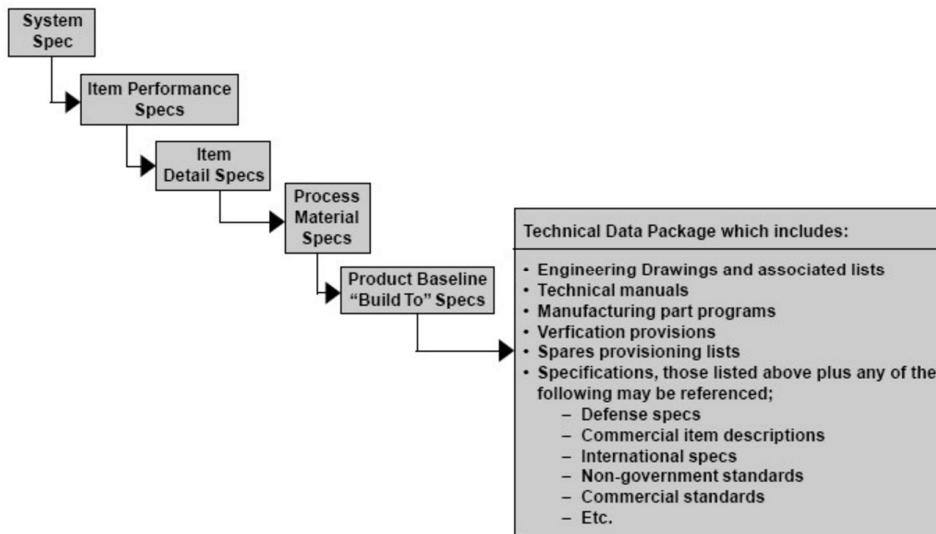
Part Marking

Simple Act : Complex Requirements



FAIR - Challenges

Accountable Characteristics within Specifications



When to Start a FAIR



FAIR - Challenges

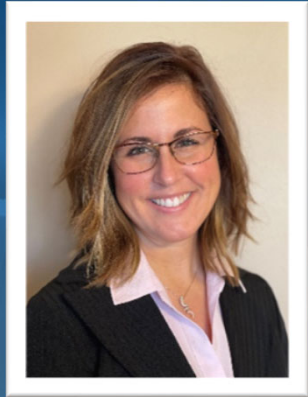
Critical Steps to Developing a Good FAIR



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FUTURE PLANS FOR SMIG



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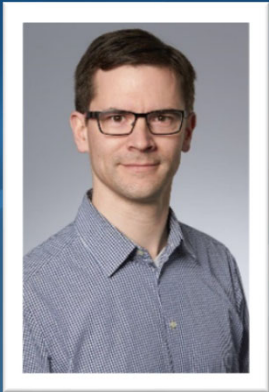
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SMIG Future Plans



- Continue to develop and interact through the LinkedIn CoP
 - Use postings to drive next actions
- Review AS9102 Rev C coming soon and determine the impact to RM13102
 - AS9102 Rev C out on ballot
- Roll out update to RM13102
- Hold future event to promote any updates

QUESTIONS AND ANSWERS



KLAUS DIETERSHAGEN
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MTU AERO ENGINES

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Questions & Answers



**We have several suppliers who work with different older issues of the Form 1-3.
Are we responsible to suppress this and force the use of the latest issue?**

Answer:

- Depends on the customer's requirements; most customers default to the latest revision of AS9102 forms
- AS9102 4.7.1:
“Use of forms from a previous 9102 standard revision (e.g., AS9102A) is acceptable, provided the current form instructions are utilized.”

„Forms other than those depicted in Appendix B may be used; however, they shall contain all “Required” and “Conditionally Required” information and have the same field reference numbers”

Questions & Answers



Regarding FAI inspection equipment: What is the requirement for “Independent of production inspection equipment” as in AS13100 8.5.1.6?

Answer:

Example for independence: Pin gage in **production** and CMM for **FAIR**

AS13100 8.5.1.6

Ensuring Inspection equipment is:

Independent of production inspection equipment. Except when the production inspection process is automated and cannot be influenced by Production Staff, or FAI results are obtained by personnel that only carry out product verification, e.g., Inspectors. Where independent inspection measurement is not practicable, then the use of production inspection equipment may be acceptable if approved by the customer.

Questions & Answers



We want to start the FAI Form 3 as early as possible.

What is the minimum requirement for this?

Answer:

- FAIR should be performed to an approved drawing definition
- inspection planning should be finalized

AS13100 8.5.1.6:

- Verify characteristics in the final product, i.e., after all production activities have been completed (unless otherwise instructed by the Product Definition), including:

Questions & Answers



**Is there an influence on my FAI for machining when the casting supplier changes?
If yes, how do I display this? And what are my actions?**

Answer:

- Partial FAIR is required per AS9102 per the below.

AS9102 4.6 Partial or Re-accomplishment of First Article Inspection:

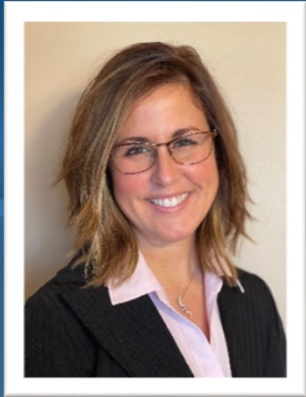
f. The organization shall perform a full FAI or a partial FAI for affected characteristics, when any of the following occurs:

[...]

- 2. A change in manufacturing source(s), process(es), inspection method(s), location of manufacture, tooling, or materials that can potentially affect fit, form, or function.*

c. When a partial FAI is performed, the organization shall, as a minimum, complete the affected fields in the FAI forms.

SUMMARY



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Summary

SUMMARY



- CoP LinkedIn Page
- Get Involved!

AESQ Thanks You for Participating!



Stay in Touch: aesq.sae-itc.com

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