



# Retaining Ring Production / 08 Apr 2019 / Jean Rojas

First Article Inspection (FAI) Report Conducted on 8th Apr, 2019 By SafetyCulture Staff

Complete

|                  |              |                 |
|------------------|--------------|-----------------|
| Inspection score | Failed items | Created actions |
| <b>92.86%</b>    | <b>1</b>     | <b>1</b>        |
| Site<br>Sydney   |              |                 |

## General Information

|  |
|--|
| Manufacturing Process<br>Retaining Ring Production   |
| Manufacturer<br>Laundry Machinery Inc.               |
| Location<br>4649 Fidler Drive, San Antonio, TX 78221 |
| Quality Inspector<br>Jean Rojas                      |
| Conducted on<br>📅 8th Apr, 2019 ⌚ 10:25 AM +08       |

## Failed items

1 Failed

Inspection / Design Characteristics / Design Characteristics 3

Is the characteristic non-conforming?

Yes

Notes

Burrs and sharp edges still present

Photos



Photo 5



Photo 6



Photo 7

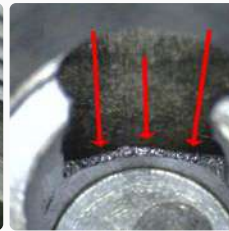


Photo 8

Actions

Done

Consider maintaining automated demurring and edge rounding machine

## Actions

1 Actions

SafetyCulture Staff created a High priority action

Done

📅 14th Apr, 2019 8:00 AM +08

### Remove burrs and sharp edges

Consider maintaining automated demurring and edge rounding machine

Inspection / Design Characteristics / Design Characteristics 3

Is the characteristic non-conforming?

# Inspection

1 Failed 1 Actions 92.86%

## First Article Inspection

|                       |                         |
|-----------------------|-------------------------|
| Type of First Article | Assembly                |
| Notes                 | Retaining Ring Assembly |

## Index of Parts

### Index of Parts 1

|             |                |
|-------------|----------------|
| Part Number | 77445565       |
| Part Name   | Retaining Ring |

|             |          |
|-------------|----------|
| Type of FAI | Complete |
|-------------|----------|

## Raw Materials & Processes

### Material/Process

#### Material/Process 1

|                           |                                    |
|---------------------------|------------------------------------|
| Material or Process Name  | Rivet Solid CS 1000                |
| Specification Number      | MS20426L                           |
| Supplier Name and Address | ABC Rivets 10 Elm St., Boston, Ma. |

#### Material/Process 2

|                           |                                       |
|---------------------------|---------------------------------------|
| Material or Process Name  | Sealant                               |
| Specification Number      | MIL-PRF-2333777D                      |
| Supplier Name and Address | Sam's Sealants 43rd St. San Jose, Ca. |

## Special Processes

|                                |     |
|--------------------------------|-----|
| Is a special process involved? | Yes |
|--------------------------------|-----|

**Special Process**

**Special Process 1**

|   |     |
|---|-----|
| Special Process Supplier Code<br>LM0000       |     |
| Is the Special Process Supplier approved?     | Yes |
| Notes<br>Chemical Filming                     |     |
| Certificate of Conformance Number<br>PO 98765 |     |

**Special Process 2**

|  |     |
|--|-----|
| Special Process Supplier Code<br>LM1212    |     |
| Is the Special Process Supplier approved?  | Yes |
| Notes<br>Anodizing                         |     |
| Certificate of Conformance Number<br>98765 |     |

**Functional Tests**

|                                       |    |
|---------------------------------------|----|
| Is a functional test to be performed? | No |
|---------------------------------------|----|




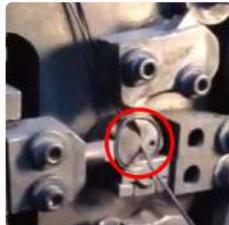
**Manufacturing Process Verification**





**Design Characteristics**

**Design Characteristics 1**

|  |          |
|--|----------|
| Reference Location<br>Note 1   |          |
| <b>Characteristic Designator</b>   | Critical |
| Requirement<br>ANSI Y14.5 1982 applies and dimensions were taken after all special processes |          |
| Inspection Result<br>Accept  |          |
| Designed Tooling<br>Chemical Film and Anodizing  |          |
| <b>Is the characteristic non-conforming?</b>   | No       |

**Design Characteristics 2**

|   |   |   |  |
|---|---|---|--|
| Reference Location<br>Sheet 2 Zone J5   |   |   |  |
| <b>Characteristic Designator</b>  | Key   |   |  |
| Requirement<br>IAW 79P070000 marked in the designated area                          |   |   |  |
| Inspection Result<br>Accept   |   |   |  |
| Designed Tooling<br>Visual Inspection   |   |   |  |
| <b>Is the characteristic non-conforming?</b>  | No  |   |  |
| Photos  |   |   |  |
|  |  |  |  |
| Photo 1   | Photo 2   | Photo 3   | Photo 4  |

|  |  |  |   |
|--|--|--|---|
| Reference Location<br><b>Note 3</b>  |  |  |   |
| <b>Characteristic Designator</b>   | N/A  |  |   |
| Requirement<br>Removed burrs and sharp edges                                       |  |  |   |
| Inspection Result<br><b>Reject</b>   |  |  |   |
| Designed Tooling<br>Visual Inspection  |  |  |   |
| <b>Is the characteristic non-conforming?</b>                                       | <b>Yes</b>   |  |   |
| Notes<br>Burrs and sharp edges still present                                       |  |  |   |
| Photos   |  |  |   |
|  |  |  |  |
| Photo 5  | Photo 6  | Photo 7  | Photo 8   |
| Actions  |  |  |   |
| <b>Done</b> Consider maintaining automated demurring and edge rounding machine     |  |  |   |
| Non-conformance Number<br><b>NC6984</b>  |  |  |   |

#### Design Characteristics 4

|   |            |
|---|------------|
| Reference Location<br>Sheet 2 Zone G9               |            |
| <b>Characteristic Designator</b>                    | <b>Key</b> |
| Requirement<br>All machined surfaces exhibit 125.03 |            |
| Inspection Result<br>Surface Finish 32              |            |
| Designed Tooling<br>Profilometer                    |            |
| <b>Is the characteristic non-conforming?</b>        | <b>No</b>  |

#### Completion



|   |   |
|---|---|
| Additional Comments<br>Perform Delta FAI for retaining ring assembly after maintenance of automated deburring and edge rounding machine   |   |
| The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition. |   |
| Quality Inspector   |   |
|    | <b>Jean Rojas</b><br>8th Apr, 2019 11:33 AM +08     |
| Production Manager  |   |
|    | <b>Isabel Quinlan</b><br>8th Apr, 2019 11:33 AM +08 |





Photo 1



Photo 2



Photo 3



Photo 4



Photo 5

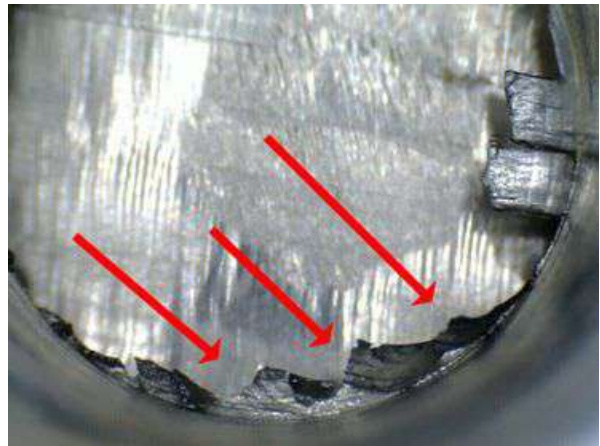


Photo 6



Photo 7

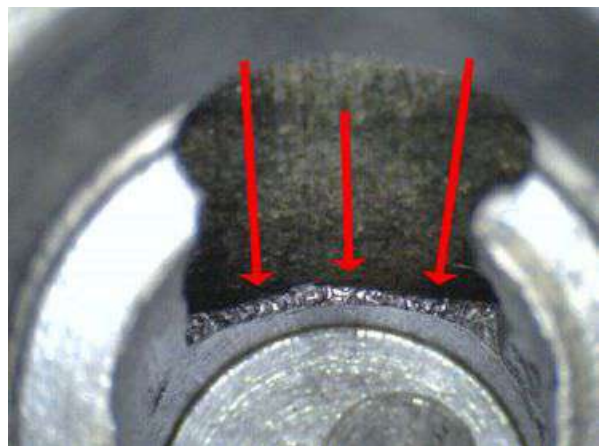


Photo 8