SAE The Engineering Society For Advancing Mobility Land Sea Air and Space®
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

SAE AS7106/2 REV A

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Submitted for recognition as an American National Standard

NATIONAL AEROSPACE AND DEFENSE CONTRACTORS ACCREDITATION PROGRAM REQUIREMENTS FOR CORRECTIVE ACTION AND DISPOSITION SYSTEM FOR NONCONFORMING MATERIAL

FOREWORD

This revision contains only editorial changes necessary to clarify the scope.

1. SCOPE:

1.1 This Aerospace Standard is to be used as a supplement to either SAE AS7106 or SAE AS7107. This Standard is required for all suppliers seeking NADCAP General Quality Systems accreditation who have Material Review Board (MRB) authority. Suppliers seeking NADCAP General Quality Systems accreditation who are authorized by contract to conduct final MRB decisions shall comply with all of the requirements contained herein.

2. APPLICABLE DOCUMENTS

The following publications form a part of this specification to the extent specified herein.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15086-0001.

AS7106 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Quality Program Requirements

AS7107 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Inspection System Requirements

2.2 PRI Publications:

Available from Performance Review Institute, 163 Thornhill Road, Warrendale, PA 15086-7527.

AC7106 NADCAP - Quality Program Requirements
AC7107 NADCAP - Inspection System Requirements

2.3 U.S. Government Publications:

Available from DODSSP Subscription Services Desk, Building 4D, 700 Robins Avenue, Philadelphia, PA 19111-5094.

MIL-Q-9858 Quality Program Requirements
MIL-I-45208 Inspection System Requirements
MIL-STD-1520 Corrective Action and Disposition System for Nonconforming Material

3. REQUIREMENTS

3.1 Corrective Action and Disposition System:

3.1.1 The Quality System shall provide for analysis of scrap, rework, and repair costs. Results of analysis shall be used to evaluate methods to reduce these costs. Evidence of cost reductions shall be available.

3.1.2 Corrective action documentation shall be maintained and positive action shall be taken to identify and reduce costs associated with nonconforming materials.

3.2 Statistical Process Control (SPC):

3.2.1 There shall be provisions for ensuring that when process control techniques are appropriate, that control limits are established statistically or by other agreed upon methods.

3.2.2 Control limits shall be based on the documented history of the process capability.

3.2.3 Control Limit Standards

3.2.3.1 There shall be provisions for developing and recommending to the customer the use of standards applicable to minor nonconformances not requiring individual corrective action.

3.2.3.2 Supplier recommended standards shall specify the control limits at which corrective action must be taken, describe criteria for determining the control limits, and provide for the accumulation and maintenance of data for monitoring processes and obtaining corrective actions as dictated by collective analyses, trend reviews, or other acceptable means.

3.3 Quality Improvement:

3.3.1 The supplier shall have a documented quality improvement program throughout his organization

3.3.2 The supplier shall assign organization elements, teams, or individuals to investigate technology, methods, and procedures to increase efficiency and conformance to requirements.

3.3.3 The supplier Corrective Action Board (CAB) or other group senior to the CAB shall monitor the QIP for progress towards established goals at regular intervals.

3.4 Contractor's Written Procedures:

3.4.1 The requirements for full MRB shall be implemented through the preparation, publication, and maintenance of detailed written procedures.

3.5 Material Review Board (MRB):

3.5.1 The supplier MRB shall be chaired by a supplier appointed representative, and the MRB shall include personnel representing other supplier organizations necessary to determine the disposition of nonconformances.

3.5.2 The supplier shall maintain a current list showing qualified MRB members including a representative of the Engineering Organization responsible for product design.

3.5.3 MRB members shall be selected on the basis of their documented technical competence.

3.5.4 The supplier MRB shall investigate in a timely manner all nonconforming material that has not been dispositioned by preliminary review.

3.5.5 Supplier MRB dispositions shall be made available to the government/customer when required by contract.

3.6 Corrective Action Board (CAB):

3.6.1 The Quality System shall provide for the establishment of a Corrective Action Board(s) with well defined responsibility authority, and organizational freedom to identify causes of nonconformances and carry out required corrective actions.

3.6.2 The supplier CAB shall maintain records of cases, trends, and individual causes it acted upon and prepare summaries of actions taken.

3.6.3 The CAB shall have the authority to:

a. Ensure that an effective corrective action system is functioning throughout the organization.

b. Require investigations and studies by other organizations necessary to define essential corrective actions which will result in reducing the number and cost of nonconformances.

c. Ensure maintenance of applicable documentation.

d. Ensure that summary data of nonconformances and associated costs are analyzed and areas of high potential payoff, adverse trends, exceeding control limits, or out-of-control recurrence of nonconformances are thoroughly investigated to identify appropriate corrective actions and to identify potential QIPs.

e. Ensure the adequacy of follow-up systems.

f. Ensure that reviews of nonconformance data and PR and MRB disposition decisions are conducted periodically to determine that PR and MRB (if authorized) actions are effective and in compliance with applicable standards.

g. Ensure that process evaluation is accomplished and that specific corrective actions are taken when indicated by control limit techniques and analysis of cumulative data.

h. Ensure that nonconformances are documented and that the processes are monitored until effectiveness of corrective action is demonstrated.

i. Initiate and monitor QIPs unless this function is assigned to a senior group.

3.7 Customer/Government Rights:

3.7.1 The supplier shall understand that the customer/government has the right to review and disapprove all procedures if they do not accomplish their objective; observe PR, MRB, CAB, and QIP activities; and accept or reject all nonconforming material presented.

4. DETAILED REQUIREMENTS

4.1 Use-As-Is Dispositions:

4.1.1 The supplier shall submit all use-as-is disposition to the government or customer for approval, as required by contract.

4.1.2 All use-as-is disposition materials, awaiting government or customer authorization, shall be segregated and withheld from further processing.

4.1.3 All use-as-is dispositions shall include a determination of the appropriateness of a documentation change.

4.2 Repair Dispositions:

4.2.1 The supplier shall submit standard repair procedures and propose repair methods to the government or customer for approval prior to accomplishing repair action.

4.2.2 The supplier shall understand that approval by the government or customer of repair techniques does not compromise customer's/government's rights to reject the material after completion of the repair.

4.3 Nonconforming Material Documentation:

4.3.1 The supplier's documentation of all nonconformance data shall include:

a. Contract number.
b. Initiator of the document.
c. Date of initiation.
d. Identification of the document for traceability purposes.
e. Specific identification (e.g., part number, name, National Stock Number) of the nonconforming material.
f. Quantity of items involved.
g. Number of occurrences.