



AS9102 FAI Report Guideline

FAI STD-001 Rev. G 01/26/2018

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AS9102 FAI Guideline- Source Inspection

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FAI STD-001 and FAI APP-001 Applies to all LMI locations and Suppliers

Objective of the FAI Guideline

Provide objective evidence of compliance to **AS9102Rev B** and customer requirements.

Strive for a more consistent FAI process across all LMI facilities and their Suppliers

Reduce questions and confusion relative to completing FAI documentation.

Eliminate Customer rejections/returns of FAI packages.

Standard FAI Guidelines – Form 1

The most basic guide for the completion of a FAI is: *the FAI is about* **“TRACEABILITY”**

FAI shall provide proof of compliance to specific Standardized and Customer requirements.

All information should be documented in order to provide a level of confidence that the requirements have been fully enacted.

Form 1 is utilized to capture the details of an assembly, or an assembly.

Do not combine detail and assembly requirements on one FAI, even if it is built on the same router.

Detail and Assembly FAIs must be completed independently, with their own complete individual FAI package.

Standard FAI Guidelines – Form 1 (continued)

Only “Modified” standard catalog items/COTS is to be placed on Form 1.

“Modified” standard catalog items/COTS will have it’s own relative FAI package to account for the change.

Standard catalog items/COTS (non-modified) is to be placed on Form 2

NOTE: Customer (OEM) exceptions may specifically override this deviation from Rev B; see FAI APP-001

All FAI packages shall be submitted through Net-Inspect.

NOTE: uploading documents in pdf format provide best security; other formats, such as excel, do not prevent editing by other viewers (internal or external).

It is acceptable to complete Form 1 in Net Inspect, in its entirety, and upload (attach) the complete FAI package (FAI Forms 1, 2, 3, certs, engineering, supporting documentation, etc. . .) into Net-Inspect.

NOTE: Customer (OEM) exceptions may override this allowance; see FAI APP-001

AS9102 FAI Guideline – Form 1

Box 1: Part Number

Part Number of the Detail, Assembly or Kit per PO line item.

Box 2: Part Name

Name of the Part as shown on the Drawing or PO line item.

NOTE: Program Box (for Net Inspect) – If the correct program is not listed, **No Program Assigned** is acceptable to use with the understanding that the Super Administrator will be contacted to add the program for the next FAI.

Box 3: Serial Number

Serial Number of the part, as assigned by the Customer or Organization if applicable. **NOTE:** “N/A if not applicable.”

Box 4: FAI Report Number

Unique FAI Report Number required on all forms in Box 4 (This is auto-generated in Net Inspect)

AS/EN/SJAC9102 Rev B First Article Inspection

Form 1 - Part Number Accountability

1. Part Number	2. Part Name	3. Serial Number	4. FAI Number Customer FAI # Internal FAI Number: <input type="text"/> 400 <input type="checkbox"/> FAI Approved <input type="checkbox"/>
5. Part Revision Level	6. Drawing Number	7. Drawing revision level	8. Additional Changes
9. Manufacturing Process Reference	10. Organization Name LMI AEROSPACE ST. CHARLES	11. Supplier Code	12. P.O. Number
13. Detail Part <input type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part number including revision level	
Program: List of Programs	Reason for Partial FAI	Customer Part Number	

a) If above part number is a detail part only, go to Field 19
b) If above part number is an assembly, go to the "INDEX" section below.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

15. Part Number	16. Part Name	17. Part Serial Number	Supplier	FAI Number
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X
Delete row <input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X	<input type="text"/> X

1) Signature indicates that all characteristics are accounted for per drawing requirements or are properly documented for disposition.
2) Also indicate if the FAI is complete per Section 4.c: FAI Complete FAI not Complete Void Pass/Fail: Select

Customer: LMI AEROSPACE

19. Signature: Signature

20. Date:

21. Reviewed By: Save and close the FAI Close

22. Date:

23. Customer Approval:

24. Date:

List Comments:

SAVE

AS9102 FAI Guideline – Form 1 (continued)

Box 5: Part Revision Level

Parts List Revision – Revision should be recorded as listed on Engineering Parts List. (See FAI APP-001 for specific Customer Requirements)

Box 6: Drawing Number

Record the basic drawing number and/or authority dataset file name associated with the FAI part. There may be multiple base drawings (part and spray dot) list all that apply. Include any build-to standard drawing(s). Include any DL, MPL, etc.

Box 7: Drawing Revision Level

Record drawing sheet number and revision, authority dataset revision level, engineering doc revisions, etc. There may be multiple base dwgs. (part and spray dot) list all that apply.

Box 8: Additional Changes

Record supplemental Engineering document no. and revision or condition of Supply Document and revision that are incorporated in the product but not reflected in referenced Drawing/Part Revision level.

AS/EN/SJAC9102 Rev B First Article Inspection

Form 1 - Part Number Accountability

1. Part Number	2. Part Name	3. Serial Number	4. FAI Number Customer FAI # Internal FAI Number: <input type="text"/> 400 <input type="checkbox"/> FAI Approved <input type="checkbox"/>	
5. Part Revision Level	6. Drawing Number	7. Drawing revision level	8. Additional Changes	
9. Manufacturing Process Reference	10. Organization name LMI AEROSPACE ST. CHARLES	11. Supplier Code	12. P.O. Number	
13. Detail Part # <input type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part Number including revision level		Customer Part Number
Program: Lot of Programs	Reason for Partial FAI			
a) If above part number is a detail part only, go to Field 19 b) If above part number is an assembly, go to the "INDEX" section below.				
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.				
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.				
15. Part Number	16. Part Name	17. Part Serial Number	Supplier	18. FAI Number
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
Delete row <input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>	<input type="text"/> <input type="checkbox"/>
1) Signature indicates that all characteristics are accounted for per drawing requirements or are properly documented for disposition. 2) Also indicate if the FAI is complete per Section 4.c: <input type="checkbox"/> FAI Complete <input type="checkbox"/> FAI not Complete <input type="checkbox"/> Void <input type="checkbox"/> Pass/Fail: Select				
Customer: LMI AEROSPACE	19. Signature: <input type="text"/> Signature		20. Date: <input type="text"/>	
21. Reviewed By: <input type="text"/>	<input type="checkbox"/> Save and close the FAI <input type="button" value="Close"/>		22. Date: <input type="text"/>	
23. Customer Approval: <input type="text"/>			24. Date: <input type="text"/>	
User Comments: <input type="text"/>				

AS9102 FAI Guideline – Form 1 (continued)

Box 9: Manufacturing Process Reference: The work order number (release/work order number or router number) shall be entered here. See FAI APP-001 for Customer Requirements

Box 10: Organization Name

Name of company/organization performing the FAI.
Note: Net Inspect auto-populates this field

Box 11: Supplier Code

Supplier Code is a unique number assigned by the Customer. It is sometimes referred to as Vendor Code, Vendor Identification Number, Supplier Number, etc.

LMI assigns a 6-character Supplier Code to their suppliers; which can be seen on the LMI PO, below the supplier name and address.

Box 12: P.O. Number

Customer Purchase Order Number, PO Revisions (if any) PO Line Item Number and if applicable, the contract no.

AS/EN/SJAC9102 Rev B First Article Inspection

Form 1 - Part Number Accountability

1. Part Number	2. Part Name	3. Serial Number	4. FAI # Customer FAI # Internal FAI Number: <input type="text"/> 400 <input type="checkbox"/> FAI Approved <input type="checkbox"/>
5. Part Revision Level	6. Drawing Number	7. Drawing revision level	8. Additional Changes
9. Manufacturing Process Reference	10. Organization name LMI AEROSPACE ST. CHARLES	11. Supplier Code	12. P.O. Number
13. Detail Part # <input type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part Number including revision level	Customer Part Number
Program: <input type="text"/>	Reason for Partial FAI: <input type="text"/>		

If above part number is a detail part only, go to Field 19
 If above part number is an assembly, go to the "INDEX" section below.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

15. Part Number	16. Part Name	17. Part Serial Number	Supplier	18. FAI Number
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.
 2) Also indicate if the FAI is complete per Section 4.c: FAI Complete FAI not Complete Void Pass/Fail:

Customer:

19. Signature:

20. Date:

21. Reviewed By: Save and close the FAI

22. Date:

23. Customer Approval:

24. Date:

List Comments:

AS9102 FAI Guideline – Form 1 (continued)

Box 13: Detail Part or Assembly FAI: Check as appropriate

Box 14: Full FAI or Partial FAI:

Mark as applicable – For a partial FAI list original FAI Part Number and Previous Revision. List the Reason for the Partial FAI

Baseline Part Number Including Revision Level

When completing a Partial (Delta)FAI, the Baseline Part Number and Revision Level **MUST** be filled in for previously accepted FAI.

BOX 15, 16, 17, 18

These sections are required **ONLY** if Assembly FAI is checked in Field 13. **NOTE:** Net-Inspect will not allow you enter anything in these boxes if *Detail FAI* is checked.

AS/EN/SJAC9102 Rev B First Article Inspection

Form 1 - Part Number Accountability

1. Part Number	2. Part Name	3. Serial Number	4. FAI Number Customer FAI # Internal FAI Number: <input type="text"/> 400 <input type="checkbox"/> FAI Approved <input type="checkbox"/>	
5. Part Revision Level	6. Drawing Number	7. Drawing revision level	8. Additional Changes	
9. Manufacturing Process Reference	10. Organization Name LMI AEROSPACE ST. CHARLES	11. Supplier Code	12. P.O. Number	
13. Detail Part <input checked="" type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input checked="" type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part Number including revision level		Customer Part Number
Program: Lot of Programs	Reason for Partial FAI	[Buttons]		

a) If above part number is a detail part only, go to Field 19
b) If above part number is an assembly, go to the "INDEX" section below.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

15. Part Number	16. Part Name	17. Part Serial Number	Supplier	18. FAI Number
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.
2) Also indicate if the FAI is complete per Section 4.c: FAI Complete FAI not Complete Void Pass/Fail: Select

Customer: LMI AEROSPACE

19. Signature: [Signature] Structure [Buttons]
20. Date:

21. Reviewed By: Save and close the FAI [Buttons]
22. Date:

23. Customer Approval:
24. Date:

User Comments:

[SAVE]

AS9102 FAI Guideline – Form 1 (continued)

Customer:

LMI – select LMI customer

Suppliers – customer selection is based on the LMI facility’s location that the product will be delivered to (LMI name and address on the PO), except for “Drop Ship” locations. The LMI facility authorizing the “Drop Ship” is the customer.

Box 19, 20, 21, and 22

Net-Inspect will automatically fill in these boxes when you sign and submit the FAI to the customer. Creator Signature and Reviewed by Signature may be the same. These must be completed in order for Net Inspect to activate the submittal.

Box 23 and 24

These boxes will remain open until the customer Approves and Signs the FAI electronically on their end.

AS/EN/SJAC9102 Rev B First Article Inspection

Form 1 - Part Number Accountability

1. Part Number	2. Part Name	3. Serial Number	4. FAI Number Customer FAI # Internal FAI Number: <input type="text"/>	
5. Part Revision Level	6. Drawing Number	7. Drawing revision level	8. Additional Changes	
9. Manufacturing Process Reference	10. Organization Name LMI AEROSPACE ST. CHARLES	11. Supplier Code	12. P.O. Number	
13. Detail Part <input type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part Number including revision level		15. Customer Part Number
Program: List of Programs	Reason for Partial FAI	Maximize		

a) If above part number is a detail part only, go to Field 19
b) If above part number is an assembly, go to the "INDEX" section below.

INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.

15. Part Number	16. Part Name	17. Part Serial Number	Supplier	18. FAI Number
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Delete row	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.
2) Also indicate if the FAI is complete per section 4.c: FAI Complete FAI not Complete Void Pass/Fail:

Customer:

19. Signature	<input type="text"/>	20. Date	<input type="text"/>
21. Signature	<input type="text"/>	22. Date	<input type="text"/>
23. Customer Approval	<input type="text"/>	24. Date	<input type="text"/>

User Comments:

SAVE

Standard FAI Guidelines – Form 2

Form 2 will capture materials (Including Standard Catalog hardware), processes and functional testing applicable to the First Article part or assembly. These processes shall be listed in chronological order as they appear in the manufacturing process.

Form 2 shall address all materials, processes and specifications where the resulting output cannot be verified by subsequent monitoring or measurement.

Processing Certifications shall reference relative part number; if not, a copy of the referenced work order/traveler must be attached to show traceability.

Process Codes are NOT the same as Finish Codes. Column 7 of Form 2 is for the Codes associated to “Special Processes”.

Example: Boeing’s “Finish Code” F-18.05 is for “Sealed” Chromic Acid Anodize Finish, in accordance with BAC5019. The “Process” code for “Sealed” Chromic Acid Anodize is 304 per Boeing’s D1-4426.

The code “304” is the what should be entered in Column 7 of Form 2.

NOTE: the engineering notes depicting the Finish Codes shall be bubbled and recorded on Form 3.

Standard FAI Guidelines – Form 2 (continued)

If a substitution material and/or process is used per customer substitution documentation, that substitution **MUST** be recorded on Form 2.

Evidence of traceability between the material cert and work order / traveler should be maintained and furnished.

Material requirements contained in the Engineering definition should be reflected on the material certification.

- **EXAMPLE:** .200” sheet AMS-QQ-A-250/12

When Engineering requires Heat Treatment and / or Aging

Both Heat Treat and Age condition(s) are to be recorded on Form 2 as a “Special Process” in accordance with the Customer Approved Supplier Processor List (ASPL). A reference to the certification shall be included on Form 3.

Hardness and Conductivity Requirements

If hardness and conductivity is listed as a Special Process, it shall be listed on Form 2, with the requirements and results posted on Form 3.

AS9102 FAI Guideline – Form 2

Box 1, 2, 3 & 4 and Sheet Number(s):

Net-Inspect will automatically fill in these boxes for Form 2.

Column 5: Material or Process

Enter the name of the materials used and the “special” processes performed. For metallic material, include alloy (2014, 2024, 7075, etc.) temper, or condition of the material (ex: “7075-T3511 Aluminum”)

Include all materials that are incorporated into the FAI part, (e.g. weld / braze filler, sealant, etc.) and Standard Catalog Hardware (e.g. AN, MS Fasteners) do not include processing material such as acid etchants.

NOTE: All MODIFIED Standard Catalog Hardware/COTS goes on Form 1.

AS/ENS/JAC9102 Rev B First Article Inspection

Go to [View Mode](#) [Form 1](#) [Form 3](#)

Form 2 - Product Accountability - Materials, Special Processes, and Functional Testing

1. Part Number Test	2. Part Name Test Part	3. Serial Number 007	Product Code	4. FAIR Number 4748	9. Customer Approval Verification	10. Certificate of Conformance number	Data Card Reference Work Instruction
Material							
				N/A *			
				N/A *			
				N/A *			
				N/A *			
				N/A *			
				N/A *			
Process							
				N/A *			
				N/A *			
				N/A *			
				N/A *			
				N/A *			
				N/A *			
Inspection							
				N/A *			
				N/A *			
				N/A *			
				N/A *			
				N/A *			
11. Functional Test Procedure Number							
12. Acceptance report number							
+ Add New Row							
13. Comments							
14. Signature				Signature		15. Date	

Documents:
(Remove)

[Print Report](#)

[Go to View Mode](#) [Form 1](#) [Form 3](#)

SAVE

AS9102 FAI Guideline – Form 2 (continued)

Column 8: Supplier

Customer given **supplier code** (found in the customer ASL) and the **name and address** of the organization supplying the material to your facility, or performing the special process.

Column 9: Customer Approval Verification

Indicate YES if the special process or material source requires to be approved by the customer. Enter “N/A” if customer approval is not required. **NOTE:** DO NOT enter NO.

Column 10: Certificate of Conformance Number

Number of the Certificate (e.g. heat lot number, raw material test report number, special process Certificate of Compliance number, standard catalog hardware Certificate of Compliance number, PO number, traceability number, etc ...).

AS/ENS/JAC9102 Rev B First Article Inspection

Go to [View Mode](#) [Form 1](#) [Form 3](#)

Form 2 - Product Accountability - Materials, Special Processes, and Functional Testing

1. Part Number Text	2. Part Name Text Part	3. Serial Number 007	Product Code	4. FAIR Number 4748	Data Card Reference Work Instruction
5. Material or Process Name	6. Specification Number	7. Code	9. Supplier	9. Customer Approval Verification	10. Certificate of Conformance number
Material				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
Process				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
Inspection				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
				N/A *	
11. Functional Test Procedure Number	12. Acceptance report number				
+ Add New Row					
13. Comments					
14. Signature		15. Date			

Documents:
[\(Remove\)](#)

Print Report

[Go to View Mode](#) [Form 1](#) [Form 3](#)

SAVE

Standard FAI Guidelines – Form 3

Stock Material Thickness shall be included on Form 3

Stock Material Temper shall be included on Form 3

Grain Direction (where specified in Engineering) shall be included on Form 3

All dimensions shown on drawing face must be bubbled and reported on Form 3. Referenced Dimensions are NOT required, but may be bubbled – see FAI APP-001 for Customer Requirements (ex: Sikorsky's SSQR)

Unless verified by CMM, Romer Arm, Scanner, etc.; un-dimensioned features from Customer supplied models will be supported by Conventional Inspection Sheet/Model Based Drawing showing dimensions and tolerance and must show evidence of QA validation.

All GD&T controls will be bubbled on drawings and reported on Form 3. This also applies to the supporting BASIC dimension, UNLESS it is reported via the CMM report attached to the FAI.

Standard FAI Guidelines – Form 3 (continued)

Engineering established Datum Systems and/or targets must be demonstrated in CMM alignment reporting.

Be aware of restraining requirements for datum.

CMM report coordinate data must be reported in the same format as the coordinate system established by the Model as required.

Non-modified features of extrusion drawings shall also be recorded on Form 3.

The Part Mark specification/requirement will be bubbled and recorded on Form 3

When attaching a nut plate to a detail, bubble and record:

- Hole to Hole dimensions (as required in the nut-plate spec)
- All reportable dimensions for installed rivet (requirements are found in the installation spec).
- For Detail parts, record Rivet attach hole diameter & countersink size
- For Assemblies, record the Flushness requirement and actual.

AS9102 FAI Guideline - Form 3

Box 1, 2, 3 & 4 and Sheet Number(s):

Net-Inspect will automatically fill in these

Column 5: Characteristic Number

Unique assigned number for each Design Characteristic. Must correlate with the “bubbled” engineering characteristics.

Column 6: Reference Location

Location of the Design Characteristic (e.g. drawing zone, page number and section, specification, etc. If the Eng. Is divided into zones, it is required by all our customers to list the sheet and zone that the characteristic falls within. It is also required to provide the cutout view label when applicable.

[See next sheet for Column 6 Examples]

AS/EN/SJAC9102 Rev B First Article Inspection

Sheet 1 of 1

Sheet Or Char No.

Go to View Mode [Form 1](#)
[Form 2](#)

Form 3 - Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number		2. Part Name		3. Serial Number		4. FAIR Number	
Test		Test Part		007		4748	
Characteristic Accountability				Inspection / Test Results			
5. Char. No.	6. Reference Location	7. Characteristic Designator	8. Requirement *	9. Results Bulk Entry See notes	10. Designed / Qualified Tolerancing	11. Nonconformance Number	14. Additional Data/Comments Add/Edt
1*	Bubble N.		GDT Callout Actual Requirement Units ()	Variable *			
Op#				add more results			
Comments:							
2*	Bubble N.		GDT Callout Actual Requirement Units ()	Variable *			
Op#				add more results			
Comments:							
3*	Bubble N.		GDT Callout Actual Requirement Units ()	Variable *			
Op#				add more results			
Comments:							
The Signature indicates that all characteristics are accounted for: meet drawing requirements or are properly documented for disposition.							
12. Signature <input type="text"/>				Signature		13. Date <input type="text"/>	

Documents:

[\(Remove\)](#)

[Print Report](#)

Go to View Mode [Form 1](#)
[Form 2](#)

*The field 8, "Requirement" should be in either of the following formats:

1. FeatureDescription (specification +/-Tolerance) Ex: Turning (10 +/-0.01) OR (10 +/-0.01)
2. FeatureDescription (specification +HighTolerance/-LowTolerance) Ex: Turning (10 +0.01,-0.02) OR (10 +0.01,-0.02)
3. FeatureDescription (specification +HighTolerance/LevelTolerance) Ex: Turning (10 +0.01/0.02) OR (10 +0.01/0.02)
4. FeatureDescription (Lever specification - Upper specification) Ex: Turning (10.01 - 10.02) OR (10.01 - 10.02)
5. Description (= Specification) Ex: Profile of a Surface (= 0.02)
6. Description (> Specification) Ex: Profile of a Surface (> 0.02)
7. Description (< Specification) Ex: Profile of a Surface (< 0.02)
8. Description (≠ Specification) Ex: Profile of a Surface (≠ 0.02)
9. Unit of measurement can be specified after
*FeatureDescription (specification +/-HighTolerance/) in the Actual Requirement field. Ex: Turning (10 +/-0.01/0.02) UNITS=IN OR (10 +/-0.01/0.02) UNITS=IN

[SAVE](#)

AS9102 FAI Guideline – Form 3 (continued)

Column 6: Reference Location - Examples

If the engineering is divided into zones, it is required by all of our customers to list the sheet and zone that characteristic falls in. It is also required to provide the cutout view label when applicable.

- **EX:** Sheet 2, Zone B3 would be listed as “**2B3**”
- **EX:** Sheet 4, Zone E2, Cutout View would be listed as “**4E2A-A**”

Specification controlled features like lightening holes or heads should list the specification that controls the feature.

- **EX:** A hole called out as “**SS5100-4**” on Sheet 1 zone C5 should list “**SS5100-4**” for the dimensions specific to the spec and for location of the hole itself note “**1C5**”

For characteristics that extend past one particular zone, list the range on the drawing.

- **EX:** Sheet 2, Zone B3 and B4 could be listed as “**2B3-4**” or “**2B3/B4**”, etc.

If the engineering is not divided into zones, at least provide the sheet number on which the part is shown.

For characteristics defined by designed tooling, try to list the drawing zone if possible. Be sure to list the designed tool used to inspect that feature in Column 10.

For characteristics that originate from the PO, list “PO”.

AS9102 FAI Guideline - Form 3 (continued)

Column 7: Characteristic Designator

Key Characteristics, Flight Safety, Critical, etc ...

NOTE: "N/A" is preferred, for features not specifically defined by the customer or organization.

Column 8: Requirement

Specified requirement for the Design Characteristic (e.g. drawing dimensional characteristics with nominal and tolerances included, drawing notes, specification requirements, etc.

[See next sheet for Column 8 Examples]

AS/ENS/JAC9102 Rev B First Article Inspection

Sheet 1 of 1

Sheet Or Char No.

Go to [View Mode](#) [Form 1](#) [Form 2](#)

Form 3 - Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number		2. Part Name		3. Serial Number		4. FAIR Number	
Test		Test Part		007		4740	
Characteristic Accountability				Inspection / Test Results			
5. Char. No.	6. Reference Location	7. Characteristic Designator	8. Requirement *	9. Results Bulk Entry Template	10. Designed / Qualified Tooling	11. Manufacture Number	14. Additional Data/Comments Add/Edits
1*	Bubble No.		GDT Callout Actual Requirement Units	Variable *			
Op?	<input type="checkbox"/>		()	add more results			
Comments:							
2*	Bubble No.		GDT Callout Actual Requirement Units	Variable *			
Op?	<input type="checkbox"/>		()	add more results			
Comments:							
3*	Bubble No.		GDT Callout Actual Requirement Units	Variable *			
Op?	<input type="checkbox"/>		()	add more results			
Comments:							

The Signator indicates that all characteristics are accounted for: meet drawing requirements or are properly documented for disposition.

12. Signature Signature

13. Date

Documents:

[\(Remove\)](#)

[Print Report](#)

Go to [View Mode](#) [Form 1](#) [Form 2](#)

*The field 8. "Requirement" should be in either of the following formats:

- FeatureDescription (specification +/-HighTolerance) Ex: Tuming (10 +/-0.01) OR (10 +/-0.01)
- FeatureDescription (specification +HighTolerance/-LowTolerance) Ex: Tuming (10 +0.01,-0.02) OR (10 +0.01,-0.02)
- FeatureDescription (specification +HighTolerance/-LowTolerance) Ex: Tuming (10 +0.01-0.02) OR (10 +0.01-0.02)
- FeatureDescription (Lower specification - Upper specification) Ex: Tuming (10.01 - 10.02) OR (10.01 - 10.02)
- Description (= Specification) Ex: Profile of a Surface (= 0.02)
- Description (> Specification) Ex: Profile of a Surface (> 0.02)
- Description (< Specification) Ex: Profile of a Surface (< 0.02)
- Description (<= Specification) Ex: Profile of a Surface (<= 0.02)
- Unit of measurement can be specified after

*FeatureDescription (specification +/-HighTolerance) is the Actual Requirement field. Ex: Tuming (10 +0.01-0.02) UNITS+IN OR (10 +0.01-0.02) UNITS+IN

SAVE

AS9102 FAI Guideline – Form 3 (continued)

Column 8: Requirement - Examples

A flag note in the PL states that flange heights should be within +/- .01 The flange height S/B .75; The requirement in the FAI should then be written as “.75 +/- .01

For tooling controlled features (MTX, form block, set-back router jig, etc.), list the tool used to inspect and list the tolerance afterwards. **Ex: “Contour per HPB ± .03”**

A general design feature that applies to multiple locations may be recorded as one characteristic number.

5X .098 - .103

.25R TYP

R .50 4Places

NOTE:. Any general notes or flag notes for a specific dimension or feature shall be listed on Form 3. It is acceptable to reference back to Form 2 for special process results. Notes that do not apply to the FAI part should be listed on Form 3 as N/A and may be grouped on one line.

AS9102 FAI Guideline - Form 3 (continued)

Column 9: Results

List measurement(s) obtained for the Design Characteristics. All measurements shall be listed in the same units of measure as indicated on the drawing.

For Multiple Characteristics, list each characteristic as individual values or list once with the minimum and maximum of measured values attained. You can click the “add more results” button in Net-Inspect on Form 3.

GDT Callout		Attribute <input type="text" value="VISUAL"/>
Actual Requirement	Units	PASS
(NA)		
		Last Updated by add more results

If one of the multiple characteristics is found to be non-conforming, then that specific characteristic must be listed separately with the measured value noted.

[See next sheet for Column 9 continuation]

AS/EN/SJAC9102 Rev B First Article Inspection

Sheet 1 of 1

Sheet Of Char No.

Go to View Mode [Form 3](#) [Form 2](#)

Form 3 - Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number	2. Part Name	3. Serial Number	4. FAIR Number
Test	Test Part	007	4740
Characteristic Accountability			Inspection / Test Results
5. Char. No.	6. Reference Location	7. Characteristic Designer	8. Requirement *
9. Results Bulk Entry Template	10. Designed / Qualified Tooling	11. Manufacture Number	14. Additional Data/Comments Add/Edits
1*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			
2*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			
3*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			
The signature indicates that all characteristics are accounted for, meet drawing requirements or are properly documented for dispensation.			
12. Signature	Signature	13. Date	

Documents:

[\(Remove\)](#)

[Print Report](#)

Go to View Mode [Form 3](#) [Form 2](#)

*The field 8. "Requirement" should be in either of the following formats:

1. Feature/Description (specification +/-HighTolerance) Ex: Tuning (10 +/-0.01) OR (10 +/-0.01)
2. Feature/Description (specification +HighTolerance/-LowTolerance) Ex: Tuning (10 +0.01,-0.02) OR (10 +0.01,-0.02)
3. Feature/Description (specification +HighTolerance/±LowTolerance) Ex: Tuning (10 +0.01-0.02) OR (10 +0.01-0.02)
4. Feature/Description (Lower specification - Upper specification) Ex: Tuning (10.01 - 10.02) OR (10.01 - 10.02)
5. Description (>= Specification) Ex: Profile of a Surface (>= 0.02)
6. Description (> Specification) Ex: Profile of a Surface (> 0.02)
7. Description (< Specification) Ex: Profile of a Surface (< 0.02)
8. Description (<= Specification) Ex: Profile of a Surface (<= 0.02)
9. Unit of measurement can be specified after

*Feature/Description (specification +/-HighTolerance) is the Actual Requirement field. Ex: Tuning (10 +0.01-0.02) UNITS>IN OR (10 +0.01-0.02) UNITS>IN

SAVE

AS9102 FAI Guideline – Form 3 (continued)

Column 9: Results - continuation

Example of a result with a range: A .75 flange running .72 at bottom and .76 at top should be listed as “.72 to .76”.

All resulting measurements shall be listed in the same units of measure as indicated on the drawing.

For metallurgical characteristics with visual verification requirement that are rated against standard photographs, color chip or surface chip, list the photo number of the closest comparison. A statement of conformance is acceptable (record the reference number in this field).

For processes that require verification per Designed/Qualified Tooling, results shall be accept or a range of value relative to the method of verification.

Ex: For verification with Qualified Tooling such as a Check-fixtured vs. gap/profile req't, Block 9 should depict the range of measurement (such as, “.010 to .015”).

*Ex: For verification with Designed Tooling such as a ¼-28 UNJF Thread Gage, Block 9 should be **PASS**.*

NOTE: be sure to post the Gage or Tool in Column 10

AS9102 FAI Guideline – Form 3 (continued)

Column 9: Results - continuation

For part marking, ensure that marking is legible, correct in content and size and properly located, per applicable specification.

For attribute data, use the verbiage “PASS” or “FAIL” to record the result.

If a Design Requirement requires verification testing, then the actual results will be recorded on form 3. If a laboratory report or certificate of test is included in the FAIR, then these results need not be written on the form, record PASS OR FAIL in Box 9 and add “See Form 2” in the Comments Block. The laboratory report or certificate of test must show specific values for requirements and actual results.

AS9102 FAI Guideline - Form 3 (continued)

Column 10: Designed/Qualified Tooling

If a specially designed tool (including NC programming) is used as a media of inspection, record the tool identification number. When Qualified Tooling (e.g. go/no go gages, thread gages, radius gages) is used for attribute acceptance, record the gage value or range (e.g. minimum/maximum value), as applicable, and its tool identification number.

NOTE: This does not include standard measurement hand tools

Box 11: Non-conformance Number

Record both the customer and internal LMI non-conformance document reference number if the characteristic is found to be non-conforming. A delta FAI for the non-conforming characteristic(s) will be required on the next run of parts.

Box 12, 13: Signature / Date

These will be auto generated when signed and submitted

AS/ENS/JAC9102 Rev B First Article Inspection

Sheet 1 of 1

Sheet Or Char No.

Go to [View Mode](#) [Form 1](#) [Form 2](#)

Form 3 - Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number		2. Part Name		3. Serial Number		4. FAIR Number	
Test		Test Part		007		4740	
Characteristic Accountability				Inspection / Test Results			
5. Char. No.	6. Reference Location	7. Characteristic Designator	8. Requirement *	9. Results Bulk Entry Template	10. Designed / Qualified Tooling	11. Nonconformance Number	14. Additional Data/Comments Add/Edits
1*	Bubble No.		GDT Callout Actual Requirement Units ()	Variable *			
2*	Bubble No.		GDT Callout Actual Requirement Units ()	Variable *			
3*	Bubble No.		GDT Callout Actual Requirement Units ()	Variable *			

The Signator indicates that all characteristics are accounted for: meet drawing requirements or are properly documented for disposition.

12. Signature Signature 13. Date

[Documents:](#)

[\(Remove\)](#)

[Print Report](#)

Go to [View Mode](#) [Form 1](#) [Form 2](#)

*The field 8. "Requirement" should be in either of the following formats:

1. Feature/Description (specification +/-) (tolerance) Ex: Tunting (10 +/-0.01) OR (10 +/-0.01)
2. Feature/Description (specification +High Tolerance /LowTolerance) Ex: Tunting (10 +0.01,-0.02) OR (10 +0.01,-0.02)
3. Feature/Description (specification +High Tolerance /LowTolerance) Ex: Tunting (10 +0.01/0.02) OR (10 +0.01/0.02)
4. Feature/Description (Lower specification / Upper specification) Ex: Tunting (10.01 - 10.02) OR (10.01 - 10.02)
5. Description (= Specification) Ex: Profile of a Surface (= 0.02)
6. Description (= Specification) Ex: Profile of a Surface (= 0.02)
7. Description (= Specification) Ex: Profile of a Surface (= 0.02)
8. Description (= Specification) Ex: Profile of a Surface (= 0.02)
9. Unit of measurement can be specified after

*Feature/Description (specification +/-High Tolerance?) is the Actual Requirement field. Ex: Tunting (10 +0.01/-0.02) UNITS=IN OR (10 +0.01/-0.02) UNITS=MM

[SAVE](#)

AS9102 FAI Guideline - Form 3 (continued)

Column 14: Additional Data / Comments

This field area is reserved for optional fields as deemed necessary by the organization. Add additional columns as required by the Organization or Customer. (See FAI APP-001 for additional customer requirements)

Preferred Method is to list Standard Gage name (with serialization if applicable) in Column 14

9. Results Bulk Entry Template	10. Designed / Qualified Tooling	11. Nonconformance Number	14. Additional Data/Comments
Bulk upload Variable ▾ .7989 Last Updated By add more results	N/A		Gage Used CALIPERS 0000654

AS/ENS/JAC9102 Rev B First Article Inspection

Sheet 1 of 1

Sheet Or Char No.

Go to View Mode [Form 1](#) [Form 2](#)

Form 3 - Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number	2. Part Name	3. Serial Number	4. FAIR Number
Test	Test Part	007	4740
Characteristic Accountability			Inspection / Test Results
5. Char. No.	6. Reference Location	7. Characteristic Designer	8. Requirement *
9. Results Bulk Entry Template	10. Designed / Qualified Tooling	11. Nonconformance Number	14. Additional Data/Comments Add/Edits
1*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			
2*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			
3*	Bubble No.	GDT Callout	Variable *
Op#		Actual Requirement Units	add more results
Comments:			

The Signator indicates that all characteristics are accounted for: meet drawing requirements or are properly documented for disposition.

12. Signature Signature 13. Date

Documents:

[\(Remove\)](#)

[Print Report](#)

Go to View Mode [Form 1](#) [Form 2](#)

*The field 8. "Requirement" should be in either of the following formats:

1. Feature/Description (specification +/-HighTolerance) Ex: Tuning (10 +/-0.01) OR (10 +/-0.01)
2. Feature/Description (specification +HighTolerance/-LowTolerance) Ex: Tuning (10 +0.01,-0.02) OR (10 +0.01,-0.02)
3. Feature/Description (specification +HighTolerance/-LowTolerance) Ex: Tuning (10 +0.01/0.02) OR (10 +0.01/0.02)
4. Feature/Description (Lower specification - Upper specification) Ex: Tuning (10.01 - 10.02) OR (10.01 - 10.02)
5. Description (= Specification) Ex: Profile of a Surface (= 0.02)
6. Description (> Specification) Ex: Profile of a Surface (> 0.02)
7. Description (< Specification) Ex: Profile of a Surface (< 0.02)
8. Description (≠ Specification) Ex: Profile of a Surface (≠ 0.02)
9. Unit of measurement can be specified after
 *Feature/Description (specification +/-HighTolerance) is the Actual Requirement field. Ex: Tuning (10 +0.01/0.02) UNITS=IN OR (10 +0.01/0.02) UNITS=MM

[SAVE](#)

AS9102 FAI Guideline – CMM Reports

Identify CMM reports to reflect the FAI Report Number, Drawing Number, Revision, Model Release and Manufacturing Process Reference.

Create report headers that clearly identify each point group targeting a specific part feature or characteristic including Datum or targets used for alignment, all GD&T controls and supporting BASIC dimensions. Consider use of drawing identifiers as reflected on the Engineering to tie the maps and CMM reports back to the Engineering.

Provide specific Point Maps **if required** (See “Unique Customer Specific FAI Requirements”) – A sufficient number of mapped views should be provided to illustrate point placement for features and surfaces inspected. Maps are to be clearly labeled including alignment points to the drawing established Datum System.

Datum or target origin X, Y & Z values identified on Engineering, must be clearly identifiable on report and alignment maps. Maps do not need to show or list every point taken in the report, but do need to visually demonstrate placement of point groups. Maps provide the reviewer with a visual perspective of the measurement process and features inspected.

AS9102 FAI Guideline- FAI Package

FAI PACKAGES SHALL INCLUDE THE FOLLOWING AS APPLICABLE AND BE TRACEABLE TO THE FAI

Bubble drawing, model screen shot or sketch denoting design characteristics / parts list showing all of the unique part characteristics including all drawing, general and flag notes. This must include your approval and traceability to the authority dataset.

Unique characteristic accountability – must correspond with unique identifier on bubbled drawing / sketch / screen shot or link to CMM report.

- Material Certifications
- Process Certifications
- Completed FAI Forms
- Non-Conformance documents
- Test reports / results
- Casting / Forging approvals
- Completed Work Order and Re-Work Orders that represent the manufacturing process as required
- Copy of the Customer Condition of Supply (e.g. TSSP, etc.) as required
- Photos

AS9102 FAI Guideline- FAI Package (continued)

FAI PACKAGES SHALL INCLUDE THE FOLLOWING AS APPLICABLE AND BE TRACEABLE TO THE FAI

Customer Approval of Frozen planning

Outside Data Sheet (Outside Processor) or Manufactured Engineering Planning Instruction Control Number

Supplier Information Requests (SIR)

Other fabrication records as indicated

CMM Reports – point maps and set-up instructions as required

Along with the Part Number, a unique identifier should be logged on the supporting document(s), such as:

- FAI Report Number
- Manufacturing Process Reference Number

AS9102 FAI Guideline- FAI for “Pass-Through” parts @ LMI

Definition of “Pass-Through” product: *A LMI facility retains a contractual agreement for delivery of a product with a customer. The LMI facility has no role in its production. The product is manufactured completely at a source outside of the LMI facility. The LMI facility receives the product, creates a “cover” FAI, and delivers the product to the customer.*

As always, LMI Aerospace is responsible for providing a FAI Report to its customers. To facilitate that effort, with “Pass Through” product, the following information will assist in attaining a standard method that meets the customers’ and AS9102 requirements:

Step 1: the LMI facility that has been designated as the owner of the “Pass Through” product will initiate FAI Form 1, in Net Inspect. The difference in completing Form 1 is that the LMI PO number, associated with the Supplier, will be used in Field 9 (and Field 4, where applicable). A note is to be added, referencing the Supplier’s FAI number as well (see subsequent pages).
Step 2: attach a copy of the complete FAI package received from the Supplier (i.e. Form 1-2-3, material certs, process certs, CMM/Inspection reports, supporting documentation, etc...)



The purpose of the following two pages are to provide a guide as to how to complete Form 1, in Net Inspect, and what should be provided to ensure the customer that their FAI requirement and AS9102 is met.

A “hard copy” of Form 1 can also be generated and attached in Net Inspect, for customers that require the use of the standard AS9102 Form(s).

Note: This is being presented as a “best practice” for compliance to AS9102, in this scenario. The customer may mandate a different approach, which could override some or all this section.



AS9102 FAI Guideline- FAI for “Pass-Through” parts @ LMI (Continuation)

The following is the suggested method for the creation of the LMI FAI for “Pass-Through” product.

Field 4 : As with all FAIs, it is acceptable to also use the Manufacturing Process Reference number, in Field 9, as the Internal FAI Number (Field 4).

Field 9: With consideration of “Pass Through” parts, a work order/traveler is not generally issued. Therefore, it is acceptable to utilize the LMI Purchase Order, to the LMI Supplier, and Line Item number as the traceable number.

Field 14: Enter Select **Full FAI**

Field 11: Enter the Customer’s assigned Supplier Code for the appropriate LMI facility.

Field 12: Enter the Customer’s PO and Line Item number

User Comments Field: Add reference to Supplier and their FAI number in Form1 and Form 2 Comment sections.

NOTE: Net Inspect V.5 requires use of Form 2 Comment section

AS/EN/SJAC9102 Rev B First Article Inspection				
Form 1: Part Number Accountability				
1. Part Number Test	2. Part Name Test Part	3. Serial Number N/A	4. FAIR Number 4748 Internal FAI Number: Y00000/001	
5. Part Revision Level -	6. Drawing Number Test	7. Drawing revision level Test	8. Additional Changes Test	
9. Manufacturing Process Reference Y00000/001	10. Organization Name LMI AEROSPACE ST. CHARLES - FOUNTAIN LAKES	11. Supplier Code Hxxxxxx	12. P.O.Number 00000000/001/Rev00	
13. Detail Part <input checked="" type="checkbox"/> Assembly FAI <input type="checkbox"/>	14. Full FAI <input checked="" type="checkbox"/> Partial FAI <input type="checkbox"/>	Baseline Part Number including revision level		
Program: NO PROGRAM ASSIGNED		Reason for Partial FAI:		Customer Part Number
a) If above part number is a detail part only, go to Field 19 b) If above part number is an assembly, go to the "INDEX" section below.				
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.				
15. Part Number	16. Part Name	17. Part Serial Number	Supplier	8. FAIR Number
1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition. 2) Also indicate if the FAI is complete per Section 4.4: FAI not Completed				
Customer LMI AEROSPACE				
From Division- To Division -				
19. Signature		20. Date		
21. Reviewed By		22. Date		
23. Customer Approval		24. Date		
User Comments: NOTE: This is a Purchased Part from supplier "My Machine Center Inc" See attached FAI 000000				



Review of the FAIR

The FAI Report review will be performed in accordance with the requirements of FAI STD-001 (AS9102) and FAI APP-001.

Communicating with Source Inspector

When there is an interpretation of requirements that differs from FAI STD-001 (AS9102) and/or FAI APP-001, politely request that the source inspector provide the basis for the different of requirements. If needed, involve the Quality Manager and/or Quality Engineer in the discussion.

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