

Kaman Designated Inspection Representative Report

(Note: One Report Per Part Number)

Supplier Name:		Supplier Code:		Date:	
Part Number:		Part Revision:	V.I. Revision:	DIR#	
E.O., E.C.:					
P.O.#	P.O. Supplement #:	Line Item:	In Process:	Final:	FAIR:
P.O.#	P.O. Supplement #:	Line Item:	In Process:	Final:	FAIR:
P.O.#	P.O. Supplement #:	Line Item:	In Process:	Final:	FAIR:
VRV#:	VRV- UAI Qty.:	VRV Ship Qty.:	VRV Balance:	Note#:	
Job/Lot#:	Lot Qty.:	Sample Size:	Acc. Qty.:	Rej. Qty.:	Note#:
Supplier Inventory Quantity:		Ship to Kaman Quantity:		Ship Date:	

Item	Description	Yes	No	N/A
1.0	Does the supplier have an AS9102 (latest revision) FAIR for the part number/revisions completed on file? Enter the date of the last completed/submitted FAIR:			
2.0	Are material and processing certifications complete, with current revision levels and, without any noted exceptions?			
3.0	Are suppliers or sub-tier suppliers used for special processing approved on Kaman's QPSL?			
4.0	Is test data, logs, documentation available (as applicable) and acceptable?			
5.0	Have you stamped, signed and dated all applicable documents/certifications to indicate your review/acceptance?			
6.0	Is product marking in accordance with applicable drawing and Vendor Instructions or VRV?			
7.0	If required: Is special marking (functional, Inspection, Test, NDT, VRV, etc.) marking compliant?			
8.0	Are lot numbers, Serial Numbers applied to the product in accordance with drawing/instructions?			
9.0	Does the supplier have a Detailed Inspection Plan (DIP) or Inspection Report (IR) with all drawing characteristics and, you have stamped off characteristics you validated?			
10.0	100% Visual Verification performed of the product to include marking, traceability, rejections documentation or any special purchase order requirements?			
11.0	Was measurement equipment used for Source Inspection noted with calibration status and, within stated dates?			
12.0	In reviewing supplier's manufacturing router: All operations documented as complete and, any non-conformances noted with supplier's non-conforming material controls/segregation?			
13.0	KSD0408 (Critical) parts only:			
13.1	If KSD 0408 noted on drawing, PO or Vendor Instruction; Supplier listed as approved on Kaman Listing (ask supplier to show evidence of approved K922)?			
13.2	Have any changes been made to approved processes/processors as defined on K922 and are they documented on Kaman form K927?			

2.0 Conducting lot Source Inspection

2.1 Source Inspection Sampling Plan Instructions

- Determination of which of the characteristics to inspect shall be in accordance with 2.2 and 2.3.
- Table 2.2 is utilized to determine the number of characteristics to be sampled based on the number of dimensional characteristics for the product.
- Table 2.3 is utilized to set an order of precedence in the selection of the characteristics to be sampled. Table 2.3 determines dimensional sampling requirements.
- Table 2.4 is number of parts/assemblies as determined by lot size.

2.2 Number of dimensional characteristics to be audited

Number of Inspection Plan Characteristics	Minimum Number of Characteristics to inspect
1-35	8*
36-100	10
101-150	15
151-200	20
201-And Up	25

*If less than 8 characteristics, inspect all

2.3 Order of Sampling Precedence

To be utilized in conjunction with Table 2.2

Characteristic Type	Number of Characteristics to be Inspected
Critical / Key	100% **
Tolerance .0000-.0004	4
Tolerance .0005-.015	4
Tolerance .0151 - over	4
Class 2 or 3 thread	1
Surface Finish 32 or less	1
Angles	1

**This value overrides table 2.2 if it exceeds the minimum number required

2.4 Part(s) Sample Size for Source Inspection Audit

Lot Size	Sample Size	Lot Size	Sample Size
1	1	27 to 33	11
2	2	34 to 41	12
3 to 4	3	42 to 52	13
5	4	53 to 67	14
6 to 8	5	68 to 87	15
9 to 10	6	88 to 118	16
11 to 13	7	119 to 173	17
14 to 17	8	174 to 286	18
18 to 21	9	287 to 643	19
22 to 26	10	644 & up	20