

Sampling Inspection

**Upon invocation of this clause, Supplier shall abide by following Century Fastener's Terms and Conditions on delegation from Parker Aerospace's behalf.*

For Parker Aerospace Suppliers, when statistical methods for product acceptance are planned, the supplier shall submit their proposed alternate inspection frequency plan to Parker Aerospace for review and concurrence prior to use. Statistical Product Acceptance Requirements shall conform to AS 13002 unless an alternate method is specified by contract.

Exceptions to AS13002:

In determining capability of the production measurement system, and when capability is demonstrated through the use of Gage R&R, the maximum acceptable R&R percentage is 10% (Ref. AS13002, section 5.1.5).

Note: A R&R percentage between 10 and 30 percent may be acceptable for some applications with Parker approval.

Sample inspection shall be suspended immediately following any non-conformance and until corrective action has been implemented and the process has once again demonstrated acceptable capability through statistical data and/or appropriate technical justification as approved by Parker (Ref. AS13002, section 5.6.3).

Any characteristic affected by process change and subject to a full or partial FAI, as defined in Parker First Article Inspection Requirements, shall be reviewed with Parker to determine what actions and/or re-approval may be required to continue with the alternate inspection frequency plan. As a minimum, all characteristics affected by the process change shall demonstrate acceptable capability through statistical data and/or appropriate technical justification, as approved by Parker, prior to continuing the alternate inspection frequency plan for those characteristics (Ref. AS13002, section 5.7.3).

A relevant capability analysis assessed against minimum acceptable criteria Ppk 1.65 for Key characteristics, 1.33 for Major characteristics or 1.0 for Minor characteristics is required as part of the Data Pack Contents (Ref. AS13002, section 7.1.1 Data Pack Contents Column).

The sampling tables per AS13002 shall be used for all characteristics, except classified characteristics (see AS13002). All characteristics with a total tolerance less than or equal to 0.005", plus those characteristics designated as Major on the engineering drawing, will be treated as a Major characteristic. All other characteristics will be treated as a Minor characteristic unless otherwise designated on the engineering drawing.

Parker Aerospace requires a minimum of 30 pieces (or 100% if order is less than 30) to be inspected initially to establish a reduced inspection to be performed for future inspections according to the tables in AS13002.

In addition to AS13002 Sampling Tables (Ref. Table 2 - Major characteristics sampling table and Sample Table 3 – Minor characteristic sampling table) the following sampling table shall be used for all characteristics designated by Parker as "Key" characteristics:

Key	Batch Size							
Ppk	Up to 10	11 to 20	21 to 30	31 to 45	46 to 60	61 to 90	91 to 120	121 to 150
2 and above	2	2	2	3	4	5	6	6
1.66 to 1.99	3	4	5	5	6	9	12	15
1.33 to 1.65	ALL	ALL	ALL	ALL	ALL	ALL	ALL	ALL
Less than 1.33	ALL	ALL	ALL	ALL	ALL	ALL	ALL	ALL

Key	Batch Size						
Ppk	151 to 200	210 to 250	251 to 300	310 to 500	501 to 750	751 to 1000	1001 to 2000
2 and above	8	10	12	20	30	40	50
1.66 to 1.99	20	20	20	25	38	40	50
1.33 to 1.65	ALL	ALL	ALL	ALL	ALL	ALL	ALL
Less than 1.33	ALL	ALL	ALL	ALL	ALL	ALL	ALL

NOTE: Batch sizes above 2000, sample size to be agreed upon with Parker.