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- Jennifer Walker

October 2005

From the Chair

The Nadcap program in general, and the NDT Task Group specifically, is experiencing a disturbing trend. The number of eligible suppliers achieving merit is on the decline. While looking for causes for this decline; it was discovered that during the 2nd quarter of 2005 19% of the audits conducted failed the compliance section. We are talking suppliers who have been through at least 3 Nadcap audits, not suppliers who are uninitiated to this program. The NDT Task Group, along with the NDT Supplier Technical Support Task Group (NDTSTSTG) is working to try to establish reasons for this negative trending.

The main cause of the compliance failures, at least in NDT, deals with processing issues. Without regard to the method, adhering to customer requirements is the main reason for failures. Again, for suppliers well acquainted with the requirements of the program, the focus of compliance to customer requirements, it is baffling that the number of failures is on the rise. This metric will be getting a great deal of focus, program wide, in the coming months. It is imperative that we reinforce the need for compliance with customer requirements.

Another initiative undertaken by the NDT Task Group is to focus on suppliers who are exceeding the limits established in NOP-011, Audit Failure Process, in number of cycles and total number of days to closure. During the bi-weekly Task Group teleconference meetings, we discuss the reasons for the delays and, where necessary, the Task Group look to offer the appropriate support to resolve issues. If the supplier is having difficulties understanding requirements, then Prime representatives familiar with the supplier will be tasked with joining the Staff Engineer to talk with the supplier to determine what help is needed to move toward closure. If, as the program grows internationally, there are language issues, primes in the local area will be asked to work with the supplier to build their understanding and help with the resolution of difficult issues.

The Task Group is looking to employ whatever measures are needed to help build a strong supplier base. But it is important for everyone to understand that the Task Group, and the Staff Engineers, are looking to work with the suppliers to resolve issues, not work to oppose the resolution of issues. As always, suppliers are not only invited, but encouraged to attend meetings to discuss issues, understand the program, and work toward a more productive program for all involved.

Phil Keown – Chairman NDT Task Group

Nadcap Meeting Schedule

Nadcap Meetings until 2007 updated as of 6/9/2005

| | 2005 | 2006 | 2007 |
|---------|--|--|--|
| January | — | Crowne Plaza Redondo Beach Los Angeles, CA 23-27 | TBD Phoenix, AZ 22-26 |
| April | — | Beijing, China 24-28 | Europe TBD 16-20 |
| July | — | Madrid, Spain 17-21 | Asia TBD 16-20 |
| Oct | Marriott Downtown Pittsburgh, PA 14-20 | Marriott Downtown Pittsburgh, PA 13-20 | Marriott Downtown Pittsburgh, PA 19-26 |

NDT Newsletter – News to you?

Are you a new reader of the NDT newsletter? If so, here is some information:

The NDT newsletter is published four times a year, prior to the quarterly Task Group meetings. The newsletters are read by the subscribing Primes, Suppliers, Auditors and anybody that happens to click on the latest NDT newsletter on the PRI website (www.pri-network.org).

The aim of the newsletter is to communicate information relating to NDT within the Nadcap program to improve our process and to promote the sharing of best practices at all levels. If you have any articles that you feel would benefit the program, feel free to forward these to one of the NDT staff engineers (contact details at the end of the newsletter) for future inclusions.

Jim Bennett – NDT Staff Engineer

NDT Supplier Symposium

The Nondestructive Testing Task Group is offering a one-day symposium on October 18, 2005 at the Pittsburgh Marriott City Center, Pittsburgh, PA. This is being held prior to the Nadcap NDT meeting October 19-21, 2005, which is being held at the same location. This symposium is free of charge. Presenters include PRI Staff Engineers, Prime representatives, as well as Supplier representatives, to the Nondestructive Testing Task Group.

Thorough preparation prior to the audit is a critical factor for success. This symposium will focus on assisting Nadcap NDT Suppliers in preparing for their audit and understanding the response expectations of the Task Group. The main focus will be on identifying the most frequent nonconformances found for each method during a Nadcap NDT audit. The end result should yield fewer findings; fewer rounds of responses required for closure of the audit and less time required to obtain accreditation.

P Michael Gutridge – NDT / Weld Senior Staff Engineer

The NDT Top Ten Findings – AC7114/1

This is our second newsletter article in which NDT staff will reveal the Top Ten findings in an NDT accreditation audit, which we hope will help the suppliers in preparation for their initial or re-accreditation audit. These findings have been taken from eAuditNet and cover initial and re-accreditation audits from across the world.

This newsletter will deal with the checklist AC7114/1 and the findings, which cover the year of 2004.

So in reverse order;

In tenth place, paragraph 5.11 d with 53 votes

In joint ninth place, paragraphs 6.3 a, 6.7 d and 5.13 f with 57 votes

In eighth place, paragraph 7.11.1 with 58 votes

In seventh place paragraph 4.1.1 with 59 votes

In sixth place paragraph 5.7 d with 66 votes

In fifth place paragraph 4.1.3 m with 71 votes
In joint fourth place paragraphs 5.11 c and 7.1 with 76 votes

In third place paragraph 5.8 a with 79 votes

In second place, paragraph 5.7 h with 110 votes

And in first place with 112 votes paragraph 4.1.1 t

The relevant paragraphs are:

- 5.11 d List the date of the current and next scheduled calibration of the thermostat?
- 6.3 a Are components, penetrant, and ambient temperatures maintained between 40 °F (4 °C) and 120 °F (49 °C)?
- 6.7 d Are measuring devices traceable to NIST?
- 5.13 f Is this check being performed weekly?
- 7.11.1 Was all penetrant inspection equipment calibrated and properly tagged with current calibration, as applicable?
- 4.1.1 Is there a statement in the procedure or quality manual stating that, as a minimum, MIL-STD-6866 and/or ASTM-E-1417 are being met?
- 5.7 d List the type of known defect standard and the acceptance criteria for each level or group?
- 4.1.3 m Evaluation procedure including black light intensity, white light intensity, inspection booth ambient white light intensity, dark adaptation time, prohibition of photo chromic lenses, acceptance criteria, and controls for mechanical evaluation and solvent cleaning evaluation?

- 5.11 c Is the calibration current?
- 7.1 Was the compliance job compliant?
- 5.8 a Is the sensitivity of in-use penetrants compared at least monthly against unused penetrants in accordance with MIL-STD-6866, Para 5.8.4.1.4?
- 5.7 h Are there maintenance procedures in place that assure that cleaning of the known defect standards, between usages, is adequate and that physical changes in the standard, that make it unsuitable for use, can be detected?
- 4.1.1 t Provisions for process control tests and checks to be performed?

So the NCR's covered supplier's procedures, process controls, process area controls and the compliance section. The main cause of the NCR's is the supplier not following customer requirements and specifications, which has a tendency to be due to poor specification review, incorrect interpretation of their customer's specifications and contract review. The list below gives typical reasons for the NCR's being raised.

- Failing to meet customer requirements with regards to calibration frequency.
- Using an extension to the calibration frequency, when not permitted by the customer.
- Extending calibration frequencies without any objective evidence of reviewing the calibration data for the purpose of extending the calibration frequency. Another aspect associated with extending calibration frequencies is the procedures not reflecting the practice applied i.e. extending temperature gauges as allowed per ASTM E1417.
- Suppliers state compliance to the ASTM E1417 and do not address the requirements of paragraph 7.2.1 for penetrant dwell time if the temperature falls between 40 & 50 degrees F (4.4 & 10 degrees C).
- Measuring devices are not calibrated or they are using devices not approved by their customer for example not using pin / feeler gauges for GE Transportation.
- Suppliers state compliance to the ASTM E1417 and do not carry out the ambient white light check on a daily basis.

- Compliance jobs performed using equipment not calibrated or calibrated correctly.
- The procedure used to control the penetrant process did not state that it complied with the ASTM E1417 (when mandated by the customer), MIL-STD-6866 (when mandated by the customer) or the customer's specification.
- Incorrect known defect standards being used for example TESCO panels used when the customer states TAM panels.
- Incorrect acceptance criteria use for the known defect standard. For example they detect 5 stars on the initial calibration of the TAM panel yet accept 4 stars based on customers specification requiring a minimum number of 4 stars for a specific sensitivity level.
- The known defect standard, when processed, does not meet the suppliers own procedural requirements and is not picked up by the operator who continues to process parts.
- The supplier's procedure does not address the dark adaptation time, evaluation process or the prohibition of photo chromic lenses.
- Drying oven calibration not current.
- Supplier states compliance to ASTM E1417, however performs the sensitivity test on a monthly basis (instead of weekly) or the test is carried out incorrectly, for example not utilizing unused developer or emulsifier for effective comparison.
- No maintenance of the known defect standard performed or a procedure in existence to address how to maintain panels per ASTM E1417.
- Failing to meet customer requirements or specifications specifically for process and process control checks.

Note: The revision status of ASTM E1417 referenced above is ASTM E1417-99.

Phil Ford – NDT Staff Engineer

Changes to Nadcap Procedures

As everyone is aware, some time ago Nadcap went to an all electronic version of the Special Process Audit; eAuditNet. Some time after that when hard copy audits became more and more scarce, it became apparent that we needed to modify our procedures to be more in line with our process, that is, our electronic process.

So please be aware that we have re-vamped, revised and restructured the Nadcap Internal Procedures, that is, the NIP's, to better represent the current Nadcap process. These are posted on eAuditNet under "User Documents", so please take a few minutes and familiarize yourselves with them. Whether you are a supplier, auditor or prime, these procedures are at the core of what we do. Happy reading

Mark D Aubele – NDT Senior Staff Engineer

Baseline Update

When last we left you on the Baseline effort, we had balloted those documents to Aerospace Committee "K". The result of that ballot, unfortunately, was that we did not get enough responders to make an official ballot and secondly, we had several disapprovals that we have yet to fully resolve.

At about the same time, we had begun to compare our current baseline with the "Supplemental Checklists" that will go along with them. To refresh your memory, the supplemental checklists are provided by each prime who does not feel that the baseline goes far enough, or is "tight" enough to meet their requirements. Therefore, these supplemental checklists would contain requirements that go beyond the baseline. The concept is that if there are too many of these supplemental checklists, then our baseline has been set too low. At the current time, the Task group is beginning to make a line by line comparison between the baseline and the supplements and will "adjust" the baseline respective of that comparison. This is a big effort, but is simply the next step in creating the best possible Checklist and Standard. It is in the best interest of all, the Primes, the Suppliers, the Auditors and the Staff Engineers to standardize as many of the requirements as possible and minimize the number and the size of the Supplements. This is a key driver for the Baseline initiative and we are doing our best to get there.

Mark D Aubele – NDT Senior Staff Engineer

Auditor Perspective - The Contracted Level 3

In the world of down-sizing, leaning operations and out-sourcing, sub-contracting level 3's is becoming more common. Because this trend appears to be increasing in the aerospace industry, I thought it beneficial to share my experiences and personal advice on the matter.

Often an organization employs an external level 3 to train or test personnel, consult, perform audits, etc. It is important to know what you need to address in a contract when employing such a person. I have had a number of audit findings related to inadequate use of external level 3's. It is my opinion that most root causes for these findings stem from lack of knowledge of what a contracted level 3 needs to be able to do, inadequate qualification of outside level 3's, and insufficient support for outside level 3's.

Contracting a level 3 (outside agency) may seem like a hard thing to do, especially if you do not have an internal level 3, have limited or no technical knowledge of requirements and are counting on the services of an external individual. However, it is a key to a successful relationship between your contracted level 3, your customers and your company.

Following are six steps outlined to increase your confidence in contracting level 3 services and in assuring your contracted level 3 will adequately meet you and your customers needs:

Step 1 – Identify and list the NDT processes you have where services are needed. This will help you identify candidate requirements. For example, if your organization uses fluorescent dye penetrant exclusively you should look for the candidate to have experience with fluorescent dye. Likewise, if your company is manufacturing aerospace parts, you would want a candidate to have experience with aerospace applications.

Step 2 – Identify your customer requirements. Make a list of Nadcap primes and other customers you do work for and what specifications you must meet. This list can be used to qualify your potential contracted level 3. You can share this list with your candidates to find out what they are familiar with and what they will be expected to have or gain knowledge in.

Step 3 – Understand qualification requirements for an external level 3 ("Outside Agency").

It's most important to remember an external level 3 must meet specification NAS 410 requirements for an "Outside Agency" as a minimum for most all Nadcap primes. NAS 410 Revision 2 states an "Outside Agency" is an independent or national body providing training and examination of NDT personnel, or any other NDT services to the requirements of this standard. Consultants and self-employed individuals are included in this definition."

NAS 410 further gives the following general requirements for an outside agency. "An employer (that's you) may utilize an outside agency to develop a certification program, train and examine NDT personnel and perform any other Level 3 function. An outside agency may qualify, but not certify personnel. The employer shall document the suitability of any outside source selected to perform any function to meet the requirements of this standard. This documentation shall be of sufficient detail to justify the outside agency's ability to perform the required Level 3 function(s).

Training and experience requirements for outside agencies per NAS 410 are as follows: "When an outside agency is used, the outside agency shall provide the cognizant NDT organization..." (that's you again) "...with the names, qualifications and, if applicable, the certifications held by the instructors and test administrators employed in the training and examination process. Supporting evidence shall be made available to the prime contractor, its auditors, or to applicable regulatory agencies upon request."

The following aerospace primes require employed level 3's (even if your level 3 is contracted), to be qualified / approved / recognized by them:

- Honeywell (certificate issued)
- Pratt & Whitney (approval letter issued)
- Rolls Royce plc (approval letter issued)
- Roll Royce Corporation (approval letter issued)
- Airbus UK (approval letter agreeing with appointment of level 3)

Boeing requires external level 3 sources to be on their approved D1-4426 list. (This may be listed by individual or business name)

If you need someone who is approved by a prime aerospace customer, you will need to verify that qualification as well and the prime should be contacted to see if the approval could be used for your facility. A prime may be able to extend an approval for your facility. You need to get this in writing from the prime of which level 3 approval is needed.

Once you know what type of person you need, you can then know what to look for in qualification documentation from the candidate.

Step 4 – Identify the services you need.

Do you need examinations, review and approval of procedures, auditing of processes, training of personnel, etc.? You need to know what all your needs are for the contracted outside agency. Here is one thing to keep in mind if you're going to depend on an outside level 3 to be your level 3. It is strongly suggested you have your outside level 3 out on the floor with trainees and certified level 1's and 2's enough to assure they have adequate understanding of what is going on in the NDT area and to have good understanding of the knowledge and skill levels of those technicians on the floor. This will help assure adequate on-going training can be accomplished and procedures are adequately maintained. As you add other aerospace customers, the level 3 should be aware of it so the NDT system can be maintained to assure continued compliance with those customer requirements. Many audit findings have been found for inadequacies in this area.

Step 5 – Document the contract requirements.

In documenting your requirements, you can use the documentation for contract agreement between you and the outside agency. Some organizations have contracted with a level 3 resource company, but give little thought as to the qualification of the individual who may be sent or assigned to your contract. If you use such a company, you need to be specific as to what you require by way of qualifications and services in the contract.

I once had a finding where a procedure was submitted months before the audit for review and approval and the procedure had not been returned as approved or otherwise at the time of the audit. When asked about what they had in their contract for the services, the individual replied, "We have no contract. They are doing it as a courtesy for us." You can understand why it is important to have a documented agreement with your outside agency. Placing a time frame for the delivery of services should be negotiated and kept to assure you don't have a lapse in meeting customer requirements.

Following are specifics as they apply you should specify in your contract with an outside agency for Level 3 services:

Level 3 Qualifications Requirements

Qualification documentation to be sent to you for file

What level 3 services are required

Specified time frame to complete an assigned task

Any other specifics you need to assure your objectives are met.

Step 6 – Obtain qualification documentation for any external level 3 employed.

Verifying a person's qualifications can be as simple as obtaining a copy of the candidate's resume and approval documentation. Remember, your P.O. should have a right of entry clause in it to give you and/or your customers the authority to review these qualification records as well. The right of entry clause is also an AS9100 and AC7004 requirement.

You can download a free contract form for your use when contracting an outside agency (level 3) at my website: <http://www.donet.com/~edfisher/ndt/>

Ed Fisher – Nadcap NDT Lead Auditor & Trainer

Nadcap Special Process Auditor – CHEM, COMP, HT, NDT & NMSE

Does the role of a Nadcap Special Process Auditor appeal to you? The Performance Review Institute (PRI) is seeking Aerospace industry consultant auditors for the following Nadcap Special Process programs – Chemical Processing, Composites, Heat Treating, Non-Destructive Testing and Nonconventional Machining & Surface Enhancement.

PRI offers the Nadcap Auditors:

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The ideal candidate will have:

- Bachelor's Degree in a technical field
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- Computer skills
- Desire to travel
- Strong interpersonal skills
- Additional qualifications for each special process
- Foreign language skills a plus

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For more information on PRI, visit our website, www.pri-network.org

Note: PRI, an equal opportunity employer, values the diversity of our work force and the knowledge of our people.



NDT Newsletter Archives

Want to review previous NDT Newsletters? Use the following address to direct you to the NDT Commodity web page:
<http://www.pri-network.org/Nadcap/supplier/commodities/NDTesting.htm>

Jim Bennett – NDT Staff Engineer

Nadcap NDT Auditor – What does it take?

Ever wondered what it takes to be a Nadcap NDT Auditor? Below outlines the process:

Step 1 (Electronic Screening)

Prospective auditor completes details on www.eauditstaff.com. Depending on the information completed, the system will screen the candidate and score them accordingly. If the candidate achieves the required scoring, they move on to the next level.

Step 2 (Manual Screening)

The NDT staff engineer will review the information provided, typically the candidate will have a number of years experience which includes both hands on practical NDT and auditing experience, NDT Level 3 qualifications in the relevant disciplines, a sound knowledge of the industry standards and not to mention Aerospace experience. If satisfied with the level of experience documented, the staff engineer will contact the candidate for an informal discussion regarding the submission. If both the candidate and the staff engineer are happy to pursue, PRI will schedule an interview.

Step 3 (Interview)

PRI administers the program for the Nadcap Subscribing Primes, it is at this stage that the Primes get involved with the auditor hiring process. The candidate will be interviewed by the NDT Task Group and asked various questions regarding anything and everything associated with NDT. In addition, the candidate will be given typical scenarios to understand the action taken that a Nadcap NDT Auditor would typically encounter. If the Primes are satisfied with the candidate, the reins are handed over to PRI to arrange the on-site training class and audits.

Step 4 (Initial Auditor Training)

The candidate undergoes classroom training (3-5 days) at PRI Headquarters (Warrendale, PA, USA) or at the PRI European Office (London, England). Training class involves reviewing of the Nadcap NDT checklists, Industry Standards, Nadcap Subscribing Prime unique requirements, Non Conformance Report writing, using eAuditNet as an auditor and not to mention performing the audit. As with all training classes in the NDT Industry there are exams, at PRI there are no exceptions for NDT auditors! The candidate will be administered general and specific examinations for each of the applicable NDT disciplines and also a basic examination (also general & specific) which addresses the main NDT Quality Systems. If the candidate passes the examinations (minimum of 70%) and achieves a composite score of 80%, PRI will begin to schedule the training audits.

Step 5 (Training Audits)

This is the practical part. The candidate will attend two Nadcap NDT audits, the first audit comprises of the candidate witnessing our extremely well experienced trainer auditors perform an audit, the second audit is the candidates turn. Our trainer auditors will review the candidate and make the appropriate recommendations to the staff engineer and the NDT task group. Once the audit package is completed by the candidate and submitted onto eAuditNet, the NDT task group will review the audit report package and comment accordingly. If acceptable, the candidate obtains approval.

General:

The NDT Commodity for the year of 2005 is looking at approx 715 Nadcap NDT audits. PRI has a total of 34 qualified NDT auditors for the globe and is summarized below:

12 US Auditors - Capability: 12 PT, MT & RT. 10 UT (83%)

17 European Auditors (including 5 AECMA PRO) - Capability: 17 PT, 16 MT (94%), 14 RT (82%), 16 UT (94%)

1 Asia Auditor - Capability 100%

4 Staff Engineer Auditors

Jim Bennett – NDT Staff Engineer

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NCR'S 'Accepted on-site' by the auditor

Ever had an audit where minor NCRs have been issued and before the audit has been completed you have presented the auditor with the corrective action? The auditor reviews and accepts your information and annotates on the NCR 'Accepted on Site', but then you access the eAuditNet system to review your NCRs and find they are still in the open status? The answer to that is a simple one. The auditor at the time of the audit is able to verify that the objective evidence is good enough to close the NCR but the Delegated Staff Engineer / NDT Task Group is the only one that can give the NCR a status of CLOSED. This is done at the time that your audit is reviewed by the Staff Engineer.

Louise Belak – NDT / Weld CSR

In Step with the CSR

Name: Louise Belak

Title: Committee Service Representative (CSR) for NDT and Welding

Duties: Assist the Staff Engineer in a professional and efficient manner providing administrative support and acting as an information focal point. Coordinate the processing of NDT & Welding audit report packages. Provide secretarial services / administrative support for workshops, committees and the NDT & Welding Task Groups. The most strenuous part of being a CSR in the NDT corner (which Sam is learning very quickly) is keeping Mark and Jim on the straight and narrow, which is an achievement in itself!

Background: I joined PRI / Nadcap in April 1994 as a clerk and today I am a CSR both for the NDT Department. There have been a great many changes since I started and the primary one is the new eAuditNet Electronic System. Going from hard copy paper audits to the new electronic system has made a world of difference in the way that the audits are handled. Recently the NDT CSRs have also taken on the responsibility of the Welding Task Group. It does get kind of hectic at times!

Personal: My husband and I have been married for 37 years. We have a married son and 2 of the most fabulous grandsons ever. My greatest joy is spending time with them.

I enjoy reading, mostly detective stories. I also enjoy knitting, making baby blankets is my specialty.



Editors Note: The attached photograph was taken only a few weeks ago when Louise was celebrating her birthday.

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