

**Raytheon Quality Note**  
**DX****Revision - Date**  
**18 – 09/15/21**

## **FIRST ARTICLE INSPECTION**

### **REVISION HISTORY**

- Revision 18 replaces revision 17 dated 06/15/21.
  - This revision updates Requirement 5 to allow material to ship with written approval from Raytheon, and
  - Adds Requirement 2.3, which was removed from revision 13 of the Q-Note.
- The applicable revision of this document is determined by:
  - The revision specified on the purchase order, or
  - The revision in effect at the time of the purchase order if no revision is listed on the purchase order.

### **REQUIREMENTS**

1. Seller shall use the online tool, Net-Inspect, to submit First Article Inspections (FAI) for review and approval unless the Seller is located outside of the United States or the FAI is in support of a classified Program.
  - 1.1. Information regarding access to Net-Inspect is located on the Quality Note website (<https://qnotes.raytheon.com>) in the Supporting Documents column after searching for this Quality Note.
  - 1.2. Seller shall enter their supplier code into Form 1, Field 11.
    - 1.2.1. The supplier code is listed as the Ordering Address (OA) number on the first page of the PO.
  - 1.3. Seller shall enter the Purchase Order (PO) Number and PO line item number into Form 1, Field 12. (Ex. 0123456789 / 0010).
  - 1.4. If the Seller is outside the United States, the Seller shall contact the Source Coordinator for direction utilizing the Supplier Request form attached to this Quality Note under the Supporting Documents column.
2. For all Raytheon Technical Data Package design characteristics, the Seller shall perform a First Article Inspection (FAI) that conforms to the requirements of AS9102 Revision B, Aerospace First Article Inspection Requirement with the following exceptions:
  - 2.1. For Castings/Forgings, Seller shall perform the FAI on one piece per cavity for product of a die or mold, fully heat treated and inspected to the requirements of the Drawing and/or CAD Model, and shall be accompanied by:
    - Certifications, Chemical Composition, and Mechanical Property Test Reports.
    - 100% Dimensional Layout Report or, when approved in advance, a non-

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contact scanning dimensional report. Prior to shipment, Seller shall send an additional copy of the dimensional report to the Raytheon Buyer.

- Magnetic Particle, Liquid Penetrant, and/or Ultrasonic Inspection Report, whichever is applicable.
- Radiographic Inspection Report, Radiographic Films/Images, and Radiographic Shooting Sketch for castings. Foundry control x-rays shall be submitted for AMS2175 Class 4 castings.

2.2. Seller shall provide objective evidence (job travelers, packing slips, etc.) for deliveries from old stock to justify FAI validity from last production run if an FAI is not performed.

2.3. Seller shall perform a partial FAI for revision changes of the Raytheon Technical Data Package. If there are no affected characteristics from the change, Seller shall notate “No Affected Characteristics” in Reason for Partial FAI block.

3. For all Seller design characteristics, the Seller shall use a representative item from the first production run of a new part or assembly to verify that the production processes, production documentation, and tooling are able to produce parts and assemblies that meet requirements. This activity shall be repeated when changes occur that invalidate the original results (e.g., engineering changes, production process changes, tooling changes) to ensure conformance with all design characteristics.

3.1. Seller shall document and maintain records of this verification. These records shall be retained in accordance with the record retention requirements of the PO.

4. If Raytheon Source or Designated Quality Representative (DQR) Inspection is required, the Seller shall have the FAI, including partial or re-accomplishment FAIs, approved prior to Source or DQR Inspection.

4.1. Requirements for Source or DQR Inspection are located within the Source Inspection or DQR Inspection Quality Notes that may be assigned to the PO.

5. Seller shall not ship material until the FAI is approved, unless authorized in writing by Raytheon.

5.1. Authorization through email is not an approved means of authorization.

6. Seller shall include all supporting FAI data (sub-assembly and detail reports, bubbled drawing with bubbles directly correlating to AS9102 Form 3 Field 5 (Character Number), objective evidence, certifications, etc.) with the FAI submission in Net-Inspect.

**DATA SUBMISSION SUMMARY**

- Seller to deliver the following data to Raytheon for Raytheon Approval
  - Seller shall submit the FAI, including partial and re-accomplishment FAIs, in Net-Inspect.

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- Unless specifically authorized, any parts fabricated prior to receipt of written First Article Approval by Raytheon will be at the Seller's risk.
- Seller to deliver the following data to Raytheon for information as required by this document
  - Seller shall provide objective evidence (job travelers, packing slips, etc.) for deliveries from old stock to justify FAI validity from last production run if an FAI is not performed.
- There is no recurring deliverable data to Raytheon required by this document once the Seller's initial FAI has been approved by Raytheon unless a partial FAI or full FAI is required per AS9102 or specifically requested by Raytheon (this Quality Note being assigned on the PO does not constitute a specific request).

**NOTES**

- AS9102 specifies when to perform a new full FAI or partial FAI in section 4.6 (f).
- Raytheon reserves the right to witness and/or participate in the FAI.
- Raytheon reserves the right to delegate first article verification to a third party.
- Raytheon reserves the right to review and approve Seller's and Seller's sub-tier supplier's FAI documentation package.
- When Raytheon Source Inspection is not required, the Seller may ship material per the terms of the PO once the FAI has been approved.