AUDIT DEFENSE PACK

AS9100D / ISO 9001:2015

Meridian Aerostructures

Wichita, Kansas

Scope: Design-to-print manufacture of aerostructure details and sub-assemblies

Audit Type: Registrar

Generated from data as of: 2026-10-29 16:57 UTC

Prepared by: Aegis AeroAssure (Recovery consultant)

SAMPLE REPORT

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1. Executive Summary

118 issues ranked for action from the records; 22 groups of them share one cause.

The AS9100D compliance score is 47.1. 144 findings open across audits, nonconformances and self-assessment; 7 CAPAs past their due date; 34 measuring instruments past calibration; 12 people with an expired qualification.

QMS Snapshot

Every number below is a key figure counted from the registers on 2026-10-29; the key figures table that follows says what each measures.

Headline Figures

Compliance score — Act
47.1
Aegis readiness assessment of your records. Not an audit result.

CAPAs open / past due — Act
24 / 7
24 opened more than 30 days ago; on-time closure 60.9%.

NCs open / aged — Act
58 / 58
Aged: detected more than 30 days ago; oldest 384 days.

Calibrations overdue — Act
34
14 more due within 30 days; 3 failed calibration.

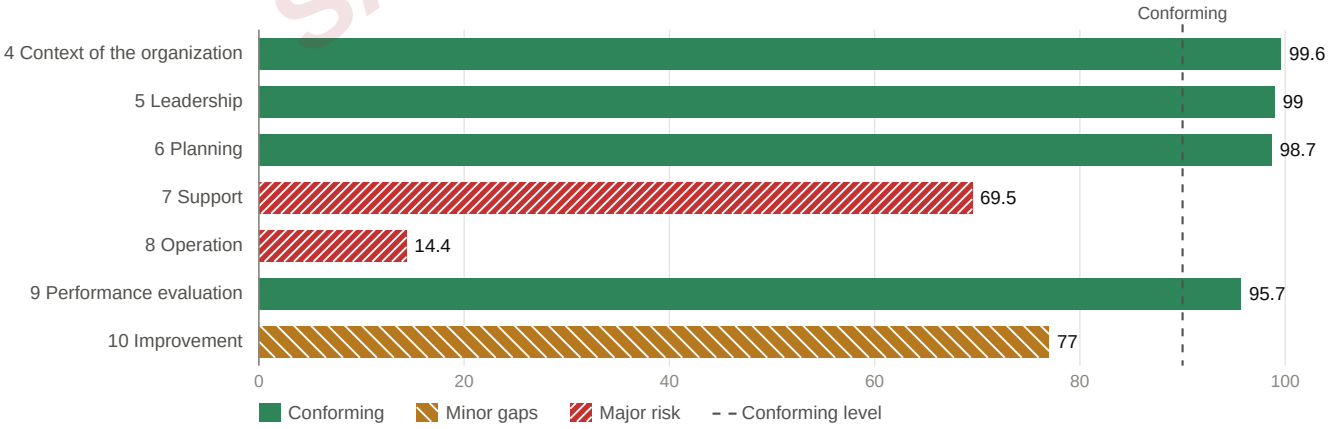
Training expired / due — Act
12 / 16
12 people hold an expired qualification; due: expires within 30 days.

Supplier reject PPM — Act
55,098
2,394 of 43,450 units rejected, 12 months; limit 500.

Sub-tier process gaps — Act
3
Sub-tier special processes without current NADCAP; own processes lapsed: 1.

Compliance score: 47.1 (act, Aegis readiness assessment of your records. Not an audit result.); CAPAs open / past due: 24 / 7 (act, 24 opened more than 30 days ago; on-time closure 60.9%.); NCs open / aged: 58 / 58 (act, Aged: detected more than 30 days ago; oldest 384 days.); Calibrations overdue: 34 (act, 14 more due within 30 days; 3 failed calibration.); Training expired / due: 12 / 16 (act, 12 people hold an expired qualification; due: expires within 30 days.); Supplier reject PPM: 55,098 (act, 2,394 of 43,450 units rejected, 12 months; limit 500.); Sub-tier process gaps: 3 (act, Sub-tier special processes without current NADCAP; own processes lapsed: 1.).

Clause Scores



Top-level AS9100D clause scores: Aegis's proprietary assessment of the findings the records raise against each clause, set against the records behind them. Not an audit result, and not a certification decision.

Clause scores: 4 99.6, 5 99, 6 98.7, 7 69.5, 8 14.4, 9 95.7, 10 77. Major risk: 7 (69.5), 8 (14.4).

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Every QMS Element at a Glance

	Current	Due in 30 days	Overdue	Missing
Documents	22	3	6	7
Records	115	n/a	n/a	11
Training	32	16	24	0
Calibration	73	14	34	0
CAPA	1	16	7	0
Nonconformances	1	11	46	0
Suppliers	12	0	12	1
Sub-tier and special processes	14	0	2	2
First article (AS9102)	0	0	15	3
Internal audits	8	0	0	0
Risk and PFMEA	0	8	2	15
Management review	2	0	0	0

Count: 0 1 to 115, darker is more

Each QMS element's records by state on the report date. Current: in date, or not yet due. n/a: the state does not apply to that element, or its records were not read.

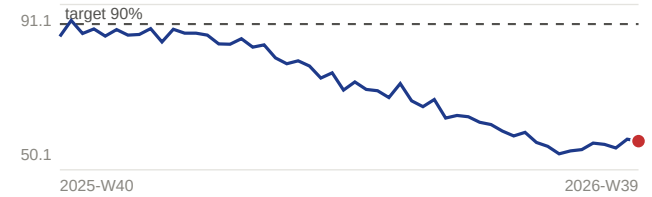
Documents: 22 current, 3 due in 30 days, 6 overdue, 7 missing; Records: 115 current, 11 missing; Training: 32 current, 16 due in 30 days, 24 overdue, 0 missing; Calibration: 73 current, 14 due in 30 days, 34 overdue, 0 missing; CAPA: 1 current, 16 due in 30 days, 7 overdue, 0 missing; Nonconformances: 1 current, 11 due in 30 days, 46 overdue, 0 missing; Suppliers: 12 current, 0 due in 30 days, 12 overdue, 1 missing; Sub-tier and special processes: 14 current, 0 due in 30 days, 2 overdue, 2 missing; First article (AS9102): 0 current, 0 due in 30 days, 15 overdue, 3 missing; Internal audits: 8 current, 0 due in 30 days, 0 overdue, 0 missing; Risk and PFMEA: 0 current, 8 due in 30 days, 2 overdue, 15 missing; Management review: 2 current, 0 due in 30 days, 0 overdue, 0 missing.

Documents: In force and approved, review date more than 30 days off; review due within 30 days; review date past; not approved or no review date. Records: Closed records naming where their evidence is kept; those naming none are missing. Training: Qualifications current; expiring within 30 days; expired; assigned and not started. Calibration: Gauges in service due after 30 days; due within 30; past due; no due date. CAPA: Open CAPAs by due date: more than 30 days off; within 30; past due; no due date. Nonconformances: Open nonconformances by due date, as CAPAs. Suppliers: Re-audited within a year; re-audit due within 30 days; past due or under watch (probation, conditional, suspended); never audited. Sub-tier and special processes: Own processes and sub-tier scope: current; approval expiring within 30 days; expired or lapsed; no NADCAP accreditation. First article (AS9102): Signed, or not yet due; unsigned and due within 30 days; unsigned past due; recorded Accepted with no signatory. Internal audits: Internal audits completed or scheduled more than 30 days off; scheduled within 30 days; scheduled date past, not completed; no date. Risk and PFMEA: Open risks by due date; missing counts high-priority failure modes no control plan names. Management review: Reviews held in the last year; scheduled within 30 days; one missing when none was held in the year.

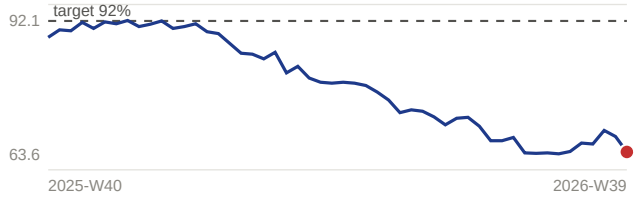
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KPI Trend

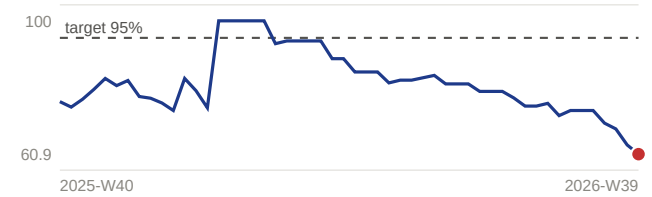
On-time delivery — off target **54%**



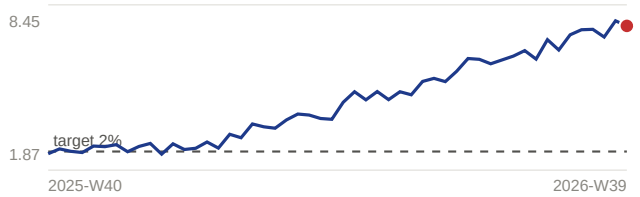
First-pass yield — off target **64%**



CAPA closure — off target **60.9%**



Scrap — off target **8.2%**



Weekly value – – Target

Weekly KPI trend, each on its own scale. Dashed: the scorecard target. The latest week is printed and called on or off target.

On-time delivery 54% in 2026-W39 against a target of 90%, off target; First-pass yield 64% in 2026-W39 against a target of 92%, off target; CAPA closure 60.9% in 2026-W39 against a target of 95%, off target; Scrap 8.2% in 2026-W39 against a target of 2%, off target.

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Key Figures

Measure	Value	What it measures
AS9100D compliance score	**47.1**	Aegis readiness score: a proprietary assessment of the findings your records raise against each AS9100D clause, set against the records behind them. Not an audit result, and not a certification decision.
Open findings, all sources	**144 (12 audit findings, 58 nonconformances, 74 assessment nonconformities)**	Open audit findings, open nonconformances and nonconforming self-assessment answers, together.
Open nonconformances	**58**	Nonconformances not yet closed, at any stage from open to verification.
Oldest open nonconformance (days since detected)	**384**	Days from the detected date of the oldest open nonconformance to the report date.
Open CAPAs	**24**	CAPAs not closed or canceled.
Open CAPAs past their due date	**7**	Open CAPAs whose due date is before the report date.
Closed CAPAs	**46 (37 effectiveness verified, 9 effectiveness not yet verified)**	CAPAs closed, with or without effectiveness verified.
CAPA on-time closure (%)	**60.9**	28 of 46 closed CAPAs with a due date were closed on or before it.
Measuring equipment past calibration due date	**34**	Equipment whose next calibration date is past.
Equipment that failed calibration	**3**	Calibration failures with an impact evaluation raised.
People with an expired qualification	**12**	Distinct people holding at least one expired qualification.
Training assignment completion (%)	**65.3**	47 of 72 training assignments completed.
First article reports lacking signatures	**18 (15 unsigned, 3 recorded Accepted with no signatory)**	AS9102 reports without a reviewer and an approver signature recorded: those not signed, and those the client's log records as Accepted with no signatory.
Part submission warrants not signed	**6**	PPAP submissions whose warrant is not signed.
Own special processes without a current approval	**1**	The organization's own Nadcap-accredited processes whose accreditation is not current, and customer-approved processes whose approval has expired. Sub-tier suppliers' processes are counted separately.
Sub-tier special processes without a current NADCAP accreditation	**3**	Special processes a supplier's sub-tier performs with an expired NADCAP accreditation or none for that process, from the sub-tier map.
Customer requirements not flowed down	**9**	Accepted customer requirements with nothing recorded as flowed to the supplier or the internal process they apply to (no mapping, or only a gap).
Customer requirements only partly flowed down	**4**	Accepted customer requirements recorded as partly flowed: started, not complete. Counted apart from those flowed down and those not flowed down at all.
Open counterfeit-part cases	**3**	Counterfeit or suspect-part cases not closed.
Suppliers on probation, conditional or disqualified	**12**	Suppliers whose status is probation, conditional, disqualified or suspended.

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Priority Actions

Most pressing first, in the order of Aegis's proprietary prioritization of your findings. The same records always give the same order.

#	Action	Why now	Owner	Clause
1	**Supplier Great Plains Titanium (11 findings)** • Quarantine the material in counterfeit case CF-MER-003, trace where it went, and notify the customers whose parts share the route • Require Great Plains Titanium to send nondestructive testing to a NADCAP-accredited source instead of Wichita Heat Treating Inc, or show Wichita Heat Treating Inc's current accreditation, before accepting more parts • Confirm containment of customer escape BOEING-QN-2291 (Great Plains Titanium) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Confirm containment of customer escape BOEING-SCAR-D1-4426-003 (Great Plains Titanium) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Stop accepting deliveries from Great Plains Titanium (SUP-MER-01) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-01 (Boeing) to Great Plains Titanium, and record the supplier's acknowledgment • Confirm with Great Plains Titanium that Central NDT Services renews NADCAP NAD-NDT-11042 for nondestructive testing before 2026-10-15 • For Great Plains Titanium (SUP-MER-01): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-01 (lot LOT-26-009) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-02 (lot LOT-26-011) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-03 (lot LOT-26-014) before releasing the lot, or disposition the material	Supplier Great Plains Titanium appears in 11 separate findings across flow-down, receiving inspection, special processes, supplier control and traceability. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking all 11 up with the supplier in one action lets each be checked against the others.	Not assigned	8.1.4, 8.4.1, 8.4.2, 8.4.3, 8.5.2, 8.7.1

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#	Action	Why now	Owner	Clause
2	**Part MER-3101 (5 findings)** • Complete the open PPAP elements and sign the part submission warrant for MER-3101 (PPAP-MER-3101) • Qualify the measurement system (Gage R&R) before relying on the capability result: Bore diameter on MER-3101 measured with BG-14 • Qualify the measurement system (Gage R&R) before relying on the capability result: Flange thickness on MER-3101 measured with MIC-7015 • Add the High-priority failure modes on MER-3101 (FM-3101-03, FM-3101-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3101 (FAI-MER-101)	Part MER-3101 carries 5 findings across APQP, capability and first article inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 5 independent lapses.	Not assigned	7.1.5.2, 8.1.1, 8.5.1.3
3	**Supplier Aero Fastener Brokers (4 findings)** • Quarantine the material in counterfeit case CF-MER-001, trace where it went, and notify the customers whose parts share the route • Quarantine the material in counterfeit case CF-MER-002, trace where it went, and notify the customers whose parts share the route • Complete the flow-down of FLD-MER-16 (Boeing) to Aero Fastener Brokers, and record the evidence • Obtain a conforming certificate for TRC-MER-35 (lot LOT-26-135) before releasing the lot, or disposition the material	Supplier Aero Fastener Brokers appears in 4 separate findings across flow-down, receiving inspection and traceability. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking all 4 up with the supplier in one action lets each be checked against the others.	Not assigned	8.1.4, 8.4.3, 8.5.2
4	**Part MER-3102 (6 findings)** • Complete the open PPAP elements and sign the part submission warrant for MER-3102 (PPAP-MER-3102) • Add the High-priority failure modes on MER-3102 (FM-3102-01, FM-3102-02, FM-3102-03, FM-3102-04, FM-3102-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3102 (FAI-MER-102) • Obtain a conforming certificate for TRC-MER-01 (lot LOT-26-009) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-02 (lot LOT-26-011) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-03 (lot LOT-26-014) before releasing the lot, or disposition the material	Part MER-3102 carries 6 findings across APQP, first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 6 independent lapses.	Not assigned	8.1.1, 8.5.1.3, 8.5.2

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5	**Supplier Prairie Composites LLC (5 findings)** • Confirm containment of customer escape SPIRIT-CAR-7712 (Prairie Composites LLC) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Stop accepting deliveries from Prairie Composites LLC (SUP-MER-03) until approval is restored, or record the added verification applied to each receipt while not approved • For Prairie Composites LLC (SUP-MER-03): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-05 (lot LOT-26-018) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-25 (lot LOT-26-125) before releasing the lot, or disposition the material	Supplier Prairie Composites LLC appears in 5 separate findings across receiving inspection and supplier control. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking all 5 up with the supplier in one action lets each be checked against the others.	Not assigned	8.4.1, 8.4.2, 8.5.2, 8.7.1
6	**Supplier Great Bend Machining (4 findings)** • Require Great Bend Machining to send coatings to a NADCAP-accredited source instead of Plains Surface Technologies, or show Plains Surface Technologies's current accreditation, before accepting more parts • Flow down FLD-MER-13 (Spirit) to Great Bend Machining, and record the supplier's acknowledgment • For Great Bend Machining (SUP-MER-14): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-38 (lot LOT-26-138) before releasing the lot, or disposition the material	Supplier Great Bend Machining appears in 4 separate findings across flow-down, receiving inspection, special processes and supplier control. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking all 4 up with the supplier in one action lets each be checked against the others.	Not assigned	8.4.1, 8.4.2, 8.4.3, 8.5.2
7	**Part MER-3107 (4 findings)** • Qualify the measurement system (Gage R&R) before relying on the capability result: Hardness HRC on MER-3107 measured with HT-2205 • Improve or replace the measurement system HT-2205 (GRR-HT2205) and repeat the Gage R&R before accepting product measured with it • Contain and improve the process, with 100% inspection until it is capable: Hardness HRC on MER-3107 (SPC-3107-HARD) • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3107 (FAI-MER-107)	Part MER-3107 carries 4 findings across capability, first article inspection and measurement systems. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 4 independent lapses.	Not assigned	7.1.5.1, 7.1.5.2, 8.5.1, 8.5.1.3

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8	**Supplier Emporia Anodizing Co (4 findings)** • Stop accepting deliveries from Emporia Anodizing Co (SUP-MER-17) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-15 (GE) to Emporia Anodizing Co, and record the supplier's acknowledgment • For Emporia Anodizing Co (SUP-MER-17): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-22 (lot LOT-26-122) before releasing the lot, or disposition the material	Supplier Emporia Anodizing Co appears in 4 separate findings across flow-down, receiving inspection and supplier control. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking all 4 up with the supplier in one action lets each be checked against the others.	Not assigned	8.4.1, 8.4.2, 8.4.3, 8.5.2
9	**Part MER-3103 (4 findings)** • Complete the open PPAP elements and sign the part submission warrant for MER-3103 (PPAP-MER-3103) • Add the High-priority failure modes on MER-3103 (FM-3103-03, FM-3103-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3103 (FAI-MER-103) • Obtain a conforming certificate for TRC-MER-38 (lot LOT-26-138) before releasing the lot, or disposition the material	Part MER-3103 carries 4 findings across APQP, first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 4 independent lapses.	Not assigned	8.1.1, 8.5.1.3, 8.5.2
10	**Part MER-3106 (5 findings)** • Add the High-priority failure modes on MER-3106 (FM-3106-03, FM-3106-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3106 (FAI-MER-106) • Complete the open PPAP elements and sign the part submission warrant for MER-3106 (PPAP-MER-3106) • Obtain a conforming certificate for TRC-MER-05 (lot LOT-26-018) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-36 (lot LOT-26-136) before releasing the lot, or disposition the material	Part MER-3106 carries 5 findings across APQP, first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 5 independent lapses.	Not assigned	8.1.1, 8.5.1.3, 8.5.2
11	**Gauge HT-2205 (3 findings)** • Qualify the measurement system (Gage R&R) before relying on the capability result: Hardness HRC on MER-3107 measured with HT-2205 • Improve or replace the measurement system HT-2205 (GRR-HT2205) and repeat the Gage R&R before accepting product measured with it • Contain and improve the process, with 100% inspection until it is capable: Hardness HRC on MER-3107 (SPC-3107-HARD)	Every measurement taken with HT-2205 is implicated in 3 findings across capability and measurement systems. Until the measurement system is qualified, each capability and acceptance decision resting on it is unsupported — so this is one gauge action, not 3 separate quality problems.	Not assigned	7.1.5.1, 7.1.5.2, 8.5.1

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12	**Owner R. Vasquez (3 findings)** • Complete or re-plan ACT-MER-005: past its due date and not done • Re-plan or escalate CAPA-MER-019: past due and still open • Re-plan or escalate CAPA-MER-042: past due and still open	R. Vasquez owns 3 of the overdue items, across recovery actions and corrective action. Plan them with R. Vasquez as one piece of work, and reassign what cannot be closed on time.	R. Vasquez	10.2
13	**Supplier Heartland Aluminum Corp (2 findings)** • Require Heartland Aluminum Corp to send chemical processing to a NADCAP-accredited source instead of Flint Chemical Processing, or show Flint Chemical Processing's current accreditation, before accepting more parts • Stop accepting deliveries from Heartland Aluminum Corp (SUP-MER-02) until approval is restored, or record the added verification applied to each receipt while not approved	Supplier Heartland Aluminum Corp appears in 2 separate findings across special processes and supplier control. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking both up with the supplier in one action lets each be checked against the others.	Not assigned	8.4.2
14	**Owner T. Nakamura (3 findings)** • Complete or re-plan ACT-MER-013: past its due date and not done • Re-plan or escalate CAPA-MER-029: past due and still open • Complete or re-plan ACT-MER-009: past its due date and not done	T. Nakamura owns 3 of the overdue items, across recovery actions and corrective action. Plan them with T. Nakamura as one piece of work, and reassign what cannot be closed on time.	T. Nakamura	10.2
15	**Part MER-3104 (3 findings)** • Complete the open PPAP elements and sign the part submission warrant for MER-3104 (PPAP-MER-3104) • Add the High-priority failure modes on MER-3104 (FM-3104-03, FM-3104-07) to the control plan, each with a control method and reaction plan • Record who reviewed and approved the accepted first article report for MER-3104 (FAI-MER-104)	Part MER-3104 carries 3 findings across APQP and first article inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 3 independent lapses.	Not assigned	8.1.1, 8.5.1.3
16	**Part MER-3105 (3 findings)** • Complete the open PPAP elements and sign the part submission warrant for MER-3105 (PPAP-MER-3105) • Add the High-priority failure modes on MER-3105 (FM-3105-03, FM-3105-07) to the control plan, each with a control method and reaction plan • Record who reviewed and approved the accepted first article report for MER-3105 (FAI-MER-105)	Part MER-3105 carries 3 findings across APQP and first article inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 3 independent lapses.	Not assigned	8.1.1, 8.5.1.3

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17	**Part MER-3113 (4 findings)** • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3113 (FAI-MER-113) • Obtain a conforming certificate for TRC-MER-15 (lot LOT-26-115) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-19 (lot LOT-26-119) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-35 (lot LOT-26-135) before releasing the lot, or disposition the material	Part MER-3113 carries 4 findings across first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 4 independent lapses.	Not assigned	8.5.1.3, 8.5.2
18	**Supplier Titan Bar & Billet (2 findings)** • Stop accepting deliveries from Titan Bar & Billet (SUP-MER-12) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-11 (Airbus) to Titan Bar & Billet, and record the supplier's acknowledgment	Supplier Titan Bar & Billet appears in 2 separate findings across flow-down and supplier control. They sit in different registers and can read as unrelated; the records show the same supplier in each, not that they share a cause. Taking both up with the supplier in one action lets each be checked against the others.	Not assigned	8.4.2, 8.4.3
19	**Owner G. Hoffman (2 findings)** • Complete or re-plan ACT-MER-010: past its due date and not done • Re-plan or escalate CAPA-MER-002: past due and still open	G. Hoffman owns 2 of the overdue items, across recovery actions and corrective action. Plan them with G. Hoffman as one piece of work, and reassign what cannot be closed on time.	G. Hoffman	10.2
20	**Owner L. Tran (2 findings)** • Complete or re-plan ACT-MER-003: past its due date and not done • Re-plan or escalate CAPA-MER-007: past due and still open	L. Tran owns 2 of the overdue items, across recovery actions and corrective action. Plan them with L. Tran as one piece of work, and reassign what cannot be closed on time.	L. Tran	10.2
21	**Part MER-3114 (2 findings)** • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3114 (FAI-MER-114) • Obtain a conforming certificate for TRC-MER-25 (lot LOT-26-125) before releasing the lot, or disposition the material	Part MER-3114 carries 2 findings across first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 2 independent lapses.	Not assigned	8.5.1.3, 8.5.2
22	**Part MER-3118 (2 findings)** • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3118 (FAI-MER-118) • Obtain a conforming certificate for TRC-MER-22 (lot LOT-26-122) before releasing the lot, or disposition the material	Part MER-3118 carries 2 findings across first article inspection and receiving inspection. A single part accumulating issues in several controls usually means the process was released before it was ready, rather than 2 independent lapses.	Not assigned	8.5.1.3, 8.5.2
23	Stop releasing work through NDT — Radiographic Inspection until approval is current, or move the work to an approved source	NDT — Radiographic Inspection is performed without current NADCAP accreditation (PRI, expiry 2026-09-14). A special process is one whose result cannot be verified by inspection afterwards, which is precisely why the approval is the control.	Not assigned	8.5.1.2

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#	Action	Why now	Owner	Clause
24	Finish the impact evaluation for Wilson Rockwell Hardness Tester (CAL-MER-02), Fluke 1586A Super-DAQ Pyrometer (CAL-MER-03), Bore Gauge 12mm (cell 4) (CAL-MER-121): identify product accepted on its measurements since the last good calibration and disposition it	3 records; for example: Wilson Rockwell Hardness Tester (CAL-MER-02) failed calibration and the impact evaluation is not complete. Every measurement taken with it since its last good calibration is in doubt. Product accepted on those measurements has not been dispositioned.	Not assigned	7.1.5.2
25	Confirm containment of customer escape GE-QN-0448 (Wichita Heat Treating Inc) at the customer and in stock, and hold the supplier to a corrective action that closes the route	GE-QN-0448 records nonconforming product from Wichita Heat Treating Inc (SUP-MER-04) that reached the customer on 2026-07-11: Engine mount bracket hardness below spec at GE. An escape is the failure receiving and source inspection exist to prevent; until its cause at the supplier is corrected, the same route is still open.	Not assigned	8.7.1
26	Implement FLD-MER-02 (Boeing) in Receiving Inspection, FLD-MER-03 (Airbus) in Heat Treat, FLD-MER-04 (Airbus) in Inspection, FLD-MER-05 (GE) in Heat Treat + Inspection, FLD-MER-12 (Airbus) in FAI, and record the evidence	5 records; for example: Boeing requirement FLD-MER-02 — Material identification & heat lot traceability — is not recorded as in place in Receiving Inspection; your flow-down register notes "Checklist does not include heat lot cross-reference step". Nothing on record shows the requirement is in place, so nothing shows it is being met.	Not assigned	7.1.5.1, 8.5.1, 8.5.2, 8.6
27	Complete or re-plan ACT-MER-001, ACT-MER-004, ACT-MER-002, ACT-MER-012, ACT-MER-014, ACT-MER-007, ACT-MER-015, ACT-MER-008: past its due date and not done	8 records; the most overdue of these: Establish daily recovery war room — 7 AM standup with all lane owners (ACT-MER-001) was due 2026-09-26 and is 33 days past it, still in progress. A recovery plan whose actions slip without being re-planned no longer says when the problem ends.	Recovery Lead, M. Okonkwo, V. Singh (QD), D. Kowalski, A. Chen	10.2
28	Re-plan or escalate CAPA-MER-052, CAPA-MER-006: past due and still open	2 records; the most overdue of these: CAPA-MER-052 (Bore oversize — MER-3107) is 113 days past its due date and still open. An overdue corrective action is a finding an auditor may use to question whether the system corrects what it finds.	P. Green, J. Reeves	10.2
29	Take decision ACT-MER-011, ACT-MER-006, or record why it is deferred and to when	2 records; the most overdue of these: ACT-MER-011 (Continue or stop composite layup pending autoclave thermocouple recalibration) was due 2026-09-27 and is still pending, 32 days later. The actions waiting on it cannot start.	S. Petrov, V. Singh (QD)	10.2
30	For Wichita Heat Treating Inc (SUP-MER-04), Central NDT Services (SUP-MER-05): carry out the overdue audit, or record why it moved and its new date	2 records; the most overdue of these: An audit of Wichita Heat Treating Inc (SUP-MER-04) (Re-audit) was scheduled for 2026-10-08 and is 21 days past it with no record that it took place. Re-evaluation is what keeps a supplier's status current; until the audit is on record, that status rests on an evaluation past its date.	Not assigned	8.4.1
31	Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3108 (FAI-MER-108), MER-3110 (FAI-MER-110), MER-3111 (FAI-MER-111), MER-3112 (FAI-MER-112), MER-3115 (FAI-MER-115), MER-3116 (FAI-MER-116), MER-3117 (FAI-MER-117)	7 records; for example: The FAIR FAI-MER-108 for MER-3108 has no completed reviewer and approver signature; its log records: Awaiting calibrated CMM data — CMM overdue. Production process verification is not complete until both signatures are recorded, and they cannot be the same person.	Not assigned	8.5.1.3

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#	Action	Why now	Owner	Clause
32	Complete the flow-down of FLD-MER-09 (Airbus) in Heat Treat, FLD-MER-10 (GE) in All special processes, FLD-MER-18 (Airbus) in Calibration, and record the evidence	3 records; for example: Airbus requirement FLD-MER-09 — NADCAP heat treatment checklist compliance — is recorded as only partly flowed in Heat Treat. The rest of it is not recorded as flowed down, so nothing on record shows that part is being met.	Not assigned	8.1
33	Review DOC-MER-006, DOC-MER-018, DOC-MER-002, DOC-MER-034, DOC-MER-030, DOC-MER-029, DOC-MER-017, DOC-MER-004, DOC-MER-035, DOC-MER-012, DOC-MER-009 and record the outcome, or record the reason and an approved new review date	11 records; the most overdue of these: DOC-MER-006 CAL-500 Calibration Control Procedure was due for review on 2026-08-16 and is 74 days past it (last reviewed 2026-02-13). It is still in use on the strength of a review that has lapsed.	Not assigned	7.5.3
34	Record who reviewed and approved the accepted first article report for MER-3109 (FAI-MER-109)	The FAIR FAI-MER-109 for MER-3109 is recorded as accepted, but no reviewer or approver is recorded against it. An auditor will ask who signed it.	Not assigned	8.5.1.3

Appendix D turns these into the auditor's own questions: 119 questions across the 17 clauses where your records show a gap, with the evidence to have ready for each.

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What These Have in Common

Shared cause	What closes it	Areas
Supplier Great Plains Titanium (11 findings)	• Quarantine the material in counterfeit case CF-MER-003, trace where it went, and notify the customers whose parts share the route • Require Great Plains Titanium to send nondestructive testing to a NADCAP-accredited source instead of Wichita Heat Treating Inc, or show Wichita Heat Treating Inc's current accreditation, before accepting more parts • Confirm containment of customer escape BOEING-QN-2291 (Great Plains Titanium) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Confirm containment of customer escape BOEING-SCAR-D1-4426-003 (Great Plains Titanium) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Stop accepting deliveries from Great Plains Titanium (SUP-MER-01) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-01 (Boeing) to Great Plains Titanium, and record the supplier's acknowledgment • Confirm with Great Plains Titanium that Central NDT Services renews NADCAP NAD-NDT-11042 for nondestructive testing before 2026-10-15 • For Great Plains Titanium (SUP-MER-01): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-01 (lot LOT-26-009) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-02 (lot LOT-26-011) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-03 (lot LOT-26-014) before releasing the lot, or disposition the material	Flow-down, receiving inspection, special processes, supplier control, traceability
Part MER-3101 (5 findings)	• Complete the open PPAP elements and sign the part submission warrant for MER-3101 (PPAP-MER-3101) • Qualify the measurement system (Gage R&R) before relying on the capability result: Bore diameter on MER-3101 measured with BG-14 • Qualify the measurement system (Gage R&R) before relying on the capability result: Flange thickness on MER-3101 measured with MIC-7015 • Add the High-priority failure modes on MER-3101 (FM-3101-03, FM-3101-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3101 (FAI-MER-101)	APQP, capability, first article inspection
Supplier Aero Fastener Brokers (4 findings)	• Quarantine the material in counterfeit case CF-MER-001, trace where it went, and notify the customers whose parts share the route • Quarantine the material in counterfeit case CF-MER-002, trace where it went, and notify the customers whose parts share the route • Complete the flow-down of FLD-MER-16 (Boeing) to Aero Fastener Brokers, and record the evidence • Obtain a conforming certificate for TRC-MER-35 (lot LOT-26-135) before releasing the lot, or disposition the material	Flow-down, receiving inspection, traceability

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Shared cause	What closes it	Areas
Part MER-3102 (6 findings)	• Complete the open PPAP elements and sign the part submission warrant for MER-3102 (PPAP-MER-3102) • Add the High-priority failure modes on MER-3102 (FM-3102-01, FM-3102-02, FM-3102-03, FM-3102-04, FM-3102-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3102 (FAI-MER-102) • Obtain a conforming certificate for TRC-MER-01 (lot LOT-26-009) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-02 (lot LOT-26-011) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-03 (lot LOT-26-014) before releasing the lot, or disposition the material	APQP, first article inspection, receiving inspection
Supplier Prairie Composites LLC (5 findings)	• Confirm containment of customer escape SPIRIT-CAR-7712 (Prairie Composites LLC) at the customer and in stock, and hold the supplier to a corrective action that closes the route • Stop accepting deliveries from Prairie Composites LLC (SUP-MER-03) until approval is restored, or record the added verification applied to each receipt while not approved • For Prairie Composites LLC (SUP-MER-03): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-05 (lot LOT-26-018) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-25 (lot LOT-26-125) before releasing the lot, or disposition the material	Receiving inspection, supplier control
Supplier Great Bend Machining (4 findings)	• Require Great Bend Machining to send coatings to a NADCAP-accredited source instead of Plains Surface Technologies, or show Plains Surface Technologies's current accreditation, before accepting more parts • Flow down FLD-MER-13 (Spirit) to Great Bend Machining, and record the supplier's acknowledgment • For Great Bend Machining (SUP-MER-14): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-38 (lot LOT-26-138) before releasing the lot, or disposition the material	Flow-down, receiving inspection, special processes, supplier control
Part MER-3107 (4 findings)	• Qualify the measurement system (Gage R&R) before relying on the capability result: Hardness HRC on MER-3107 measured with HT-2205 • Improve or replace the measurement system HT-2205 (GRR-HT2205) and repeat the Gage R&R before accepting product measured with it • Contain and improve the process, with 100% inspection until it is capable: Hardness HRC on MER-3107 (SPC-3107-HARD) • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3107 (FAI-MER-107)	Capability, first article inspection, measurement systems
Supplier Emporia Anodizing Co (4 findings)	• Stop accepting deliveries from Emporia Anodizing Co (SUP-MER-17) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-15 (GE) to Emporia Anodizing Co, and record the supplier's acknowledgment • For Emporia Anodizing Co (SUP-MER-17): carry out the overdue audit, or record why it moved and its new date • Obtain a conforming certificate for TRC-MER-22 (lot LOT-26-122) before releasing the lot, or disposition the material	Flow-down, receiving inspection, supplier control

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Shared cause	What closes it	Areas
Part MER-3103 (4 findings)	• Complete the open PPAP elements and sign the part submission warrant for MER-3103 (PPAP-MER-3103) • Add the High-priority failure modes on MER-3103 (FM-3103-03, FM-3103-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3103 (FAI-MER-103) • Obtain a conforming certificate for TRC-MER-38 (lot LOT-26-138) before releasing the lot, or disposition the material	APQP, first article inspection, receiving inspection
Part MER-3106 (5 findings)	• Add the High-priority failure modes on MER-3106 (FM-3106-03, FM-3106-07) to the control plan, each with a control method and reaction plan • Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3106 (FAI-MER-106) • Complete the open PPAP elements and sign the part submission warrant for MER-3106 (PPAP-MER-3106) • Obtain a conforming certificate for TRC-MER-05 (lot LOT-26-018) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-36 (lot LOT-26-136) before releasing the lot, or disposition the material	APQP, first article inspection, receiving inspection
Gauge HT-2205 (3 findings)	• Qualify the measurement system (Gage R&R) before relying on the capability result: Hardness HRC on MER-3107 measured with HT-2205 • Improve or replace the measurement system HT-2205 (GRR-HT2205) and repeat the Gage R&R before accepting product measured with it • Contain and improve the process, with 100% inspection until it is capable: Hardness HRC on MER-3107 (SPC-3107-HARD)	Capability, measurement systems
Owner R. Vasquez (3 findings)	• Complete or re-plan ACT-MER-005: past its due date and not done • Re-plan or escalate CAPA-MER-019: past due and still open • Re-plan or escalate CAPA-MER-042: past due and still open	Recovery actions, corrective action
Supplier Heartland Aluminum Corp (2 findings)	• Require Heartland Aluminum Corp to send chemical processing to a NADCAP-accredited source instead of Flint Chemical Processing, or show Flint Chemical Processing's current accreditation, before accepting more parts • Stop accepting deliveries from Heartland Aluminum Corp (SUP-MER-02) until approval is restored, or record the added verification applied to each receipt while not approved	Special processes, supplier control
Owner T. Nakamura (3 findings)	• Complete or re-plan ACT-MER-013: past its due date and not done • Re-plan or escalate CAPA-MER-029: past due and still open • Complete or re-plan ACT-MER-009: past its due date and not done	Recovery actions, corrective action
Part MER-3104 (3 findings)	• Complete the open PPAP elements and sign the part submission warrant for MER-3104 (PPAP-MER-3104) • Add the High-priority failure modes on MER-3104 (FM-3104-03, FM-3104-07) to the control plan, each with a control method and reaction plan • Record who reviewed and approved the accepted first article report for MER-3104 (FAI-MER-104)	APQP, first article inspection

SAMPLE REPORT

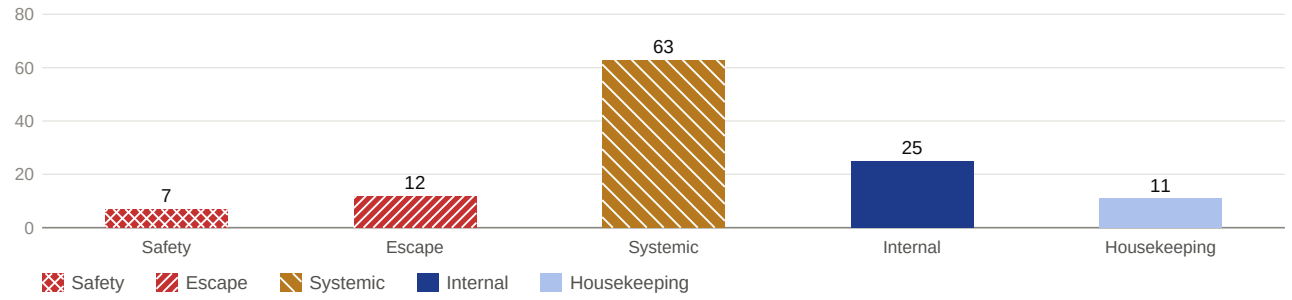
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Shared cause	What closes it	Areas
Part MER-3105 (3 findings)	• Complete the open PPAP elements and sign the part submission warrant for MER-3105 (PPAP-MER-3105) • Add the High-priority failure modes on MER-3105 (FM-3105-03, FM-3105-07) to the control plan, each with a control method and reaction plan • Record who reviewed and approved the accepted first article report for MER-3105 (FAI-MER-105)	APQP, first article inspection
Part MER-3113 (4 findings)	• Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3113 (FAI-MER-113) • Obtain a conforming certificate for TRC-MER-15 (lot LOT-26-115) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-19 (lot LOT-26-119) before releasing the lot, or disposition the material • Obtain a conforming certificate for TRC-MER-35 (lot LOT-26-135) before releasing the lot, or disposition the material	First article inspection, receiving inspection
Supplier Titan Bar & Billet (2 findings)	• Stop accepting deliveries from Titan Bar & Billet (SUP-MER-12) until approval is restored, or record the added verification applied to each receipt while not approved • Flow down FLD-MER-11 (Airbus) to Titan Bar & Billet, and record the supplier's acknowledgment	Flow-down, supplier control
Owner G. Hoffman (2 findings)	• Complete or re-plan ACT-MER-010: past its due date and not done • Re-plan or escalate CAPA-MER-002: past due and still open	Recovery actions, corrective action
Owner L. Tran (2 findings)	• Complete or re-plan ACT-MER-003: past its due date and not done • Re-plan or escalate CAPA-MER-007: past due and still open	Recovery actions, corrective action
Part MER-3114 (2 findings)	• Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3114 (FAI-MER-114) • Obtain a conforming certificate for TRC-MER-25 (lot LOT-26-125) before releasing the lot, or disposition the material	First article inspection, receiving inspection
Part MER-3118 (2 findings)	• Close the findings the log records, then complete the reviewer and approver signatures on the first article report for MER-3118 (FAI-MER-118) • Obtain a conforming certificate for TRC-MER-22 (lot LOT-26-122) before releasing the lot, or disposition the material	First article inspection, receiving inspection

SAMPLE REPORT

Issues Ranked, by Severity



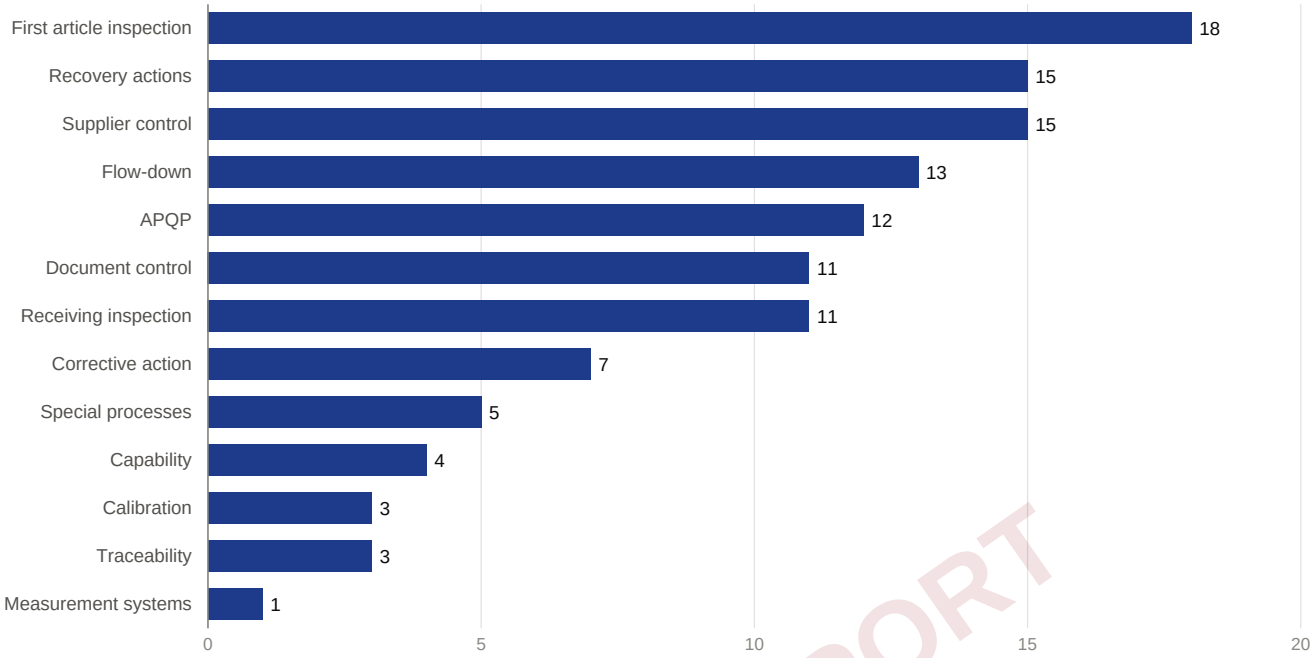
Issues ranked, by severity: the ranked findings this section lists, by the worst consequence each could have.

118 ranked issues: 7 safety, 12 escape, 63 systemic, 25 internal, 11 housekeeping.

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Issues Ranked, by Area



Issues ranked, by area of the quality system, most first.

By area: First article inspection 18, Recovery actions 15, Supplier control 15, Flow-down 13, APQP 12, Document control 11, Receiving inspection 11, Corrective action 7, Special processes 5, Capability 4, Calibration 3, Traceability 3, Measurement systems 1.

Every figure and citation is drawn from your records; the priority order is Aegis's assessment.

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2. Audit Scope & QMS Context

Scope Statement: Design-to-print manufacture of aerostructure details and sub-assemblies

Process Landscape

Clause 4: Context of the Organization
4.1 Understanding the organization and its context
4.2 Understanding the needs and expectations of interested parties
4.3 Determining the scope of the QMS
4.4 Quality management system and its processes

Clause 5: Leadership
5.1 Leadership and commitment
5.2 Policy
5.3 Organizational roles, responsibilities and authorities

Clause 6: Planning
6.1 Actions to address risks and opportunities
6.2 Quality objectives and planning to achieve them
6.3 Planning of changes

Clause 7: Support
7.1 Resources
7.1.5.2 Measurement traceability
7.2 Competence
7.3 Awareness
7.4 Communication
7.5 Documented information

Clause 8: Operation
8.1 Operational planning and control
8.1.1 Operational risk management
8.1.2 Configuration management
8.1.3 Product safety
8.1.4 Prevention of counterfeit parts
8.2 Requirements for products and services
8.3 Design and development
8.4 Control of externally provided processes, products and services
8.4.3 Information for external providers
8.5 Production and service provision
8.5.1.2 Validation and control of special processes
8.5.1.3 Production process verification (first article inspection)
8.5.2 Identification and traceability
8.6 Release of products and services
8.7 Control of nonconforming outputs

Clause 9: Performance Evaluation
9.1 Monitoring, measurement, analysis and evaluation
9.2 Internal audit
9.3 Management review

Clause 10: Improvement
10.1 General
10.2 Nonconformity and corrective action
10.3 Continual improvement

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3. Clause Compliance Posture

Aegis readiness score: a proprietary assessment of the findings your records raise against each AS9100D clause, set against the records behind them. Not an audit result, and not a certification decision. Each clause is shown as Conforming, Minor gaps or Major risk, with what is on record against it and what would close each gap.

Clause	Title	Score	Status	Sub-clauses met	With evidence	Lowest gap
4	Context of the Organization	99.6	Conforming	4 of 4	4 of 4	None
5	Leadership	99	Conforming	3 of 3	3 of 3	None
6	Planning	98.7	Conforming	3 of 3	3 of 3	None
7	Support	69.5	Major risk	2 of 5	5 of 5	7.1 Resources: scored 14.3
8	Operation	14.4	Major risk	3 of 7	7 of 7	8.1 Operational planning and control: scored 0
9	Performance Evaluation	95.7	Conforming	2 of 3	3 of 3	None
10	Improvement	77	Minor gaps	2 of 3	3 of 3	10.2 Nonconformity and corrective action: scored 24

"With evidence" counts the sub-clauses that have at least one approved document or evidence record; it is not a measure of whether that evidence is sufficient.

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Clause 4: Context of the Organization

Conforming, scored 99.6. Sub-clauses met: 4 of 4.

No sub-clause has a gap.

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Clause 5: Leadership

Conforming, scored 99. Sub-clauses met: 3 of 3.

No sub-clause has a gap.

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Clause 6: Planning

Conforming, scored 98.7. Sub-clauses met: 3 of 3.

No sub-clause has a gap.

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Clause 7: Support

Major risk, scored 69.5. Sub-clauses met: 2 of 5.

Sub-clause	Score	On record	To close it
7.1 Resources	14.3	Approved: DOC-MER-016, DOC-MER-032, DOC-MER-039 Awaiting approval: DOC-MER-006 Findings: Measuring equipment past its calibration date (34) Capability claim resting on an unqualified gauge (3) Measurements in doubt after a calibration failure (CAL-MER-02, CAL-MER-03, CAL-MER-121) Nonconforming self-assessment answer (3) Customer requirement not flowed down (FLD-MER-04) Measurement system not acceptable (GRR-HT2205) Open audit finding (FIND-MER-004) 20 audit or assessment evidence items	• Resolve: Measuring equipment past its calibration date (34) • Resolve: Capability claim resting on an unqualified gauge (3) • Resolve: Measurements in doubt after a calibration failure (CAL-MER-02, CAL-MER-03, CAL-MER-121) • Resolve: Nonconforming self-assessment answer (3) • Resolve: Customer requirement not flowed down (FLD-MER-04) • Resolve: Measurement system not acceptable (GRR-HT2205) • Resolve: Open audit finding (FIND-MER-004) • Approve DOC-MER-006 (awaiting approval)
7.2 Competence	60.8	Approved: DOC-MER-017 Findings: Qualification expired (12) Nonconforming self-assessment answer (4) Open audit finding (FIND-MER-005) 6 audit or assessment evidence items	• Resolve: Qualification expired (12) • Resolve: Nonconforming self-assessment answer (4) • Resolve: Open audit finding (FIND-MER-005)
7.5 Documented information	54.5	Approved: DOC-MER-018 Findings: Document past its review date (11) Nonconforming self-assessment answer (4) Open audit finding (FIND-MER-008) 2 audit or assessment evidence items	• Resolve: Document past its review date (11) • Resolve: Nonconforming self-assessment answer (4) • Resolve: Open audit finding (FIND-MER-008)

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Clause 8: Operation

Major risk, scored 14.4. Sub-clauses met: 3 of 7.

Sub-clause	Score	On record	To close it
8.1 Operational planning and control	0	Approved: DOC-MER-019 Findings: High-priority failure mode with no control (FM-3101-03,, FM-3102-01,, FM-3103-03,, FM-3104-03,, FM-3105-03,, FM-3106-03,) Nonconforming self-assessment answer (5) Counterfeit part case open (CF-MER-001, CF-MER-002, CF-MER-003) Customer requirement only partly flowed down (FLD-MER-09, FLD-MER-10, FLD-MER-18) 30 audit or assessment evidence items	• Resolve: High-priority failure mode with no control (FM-3101-03,, FM-3102-01,, FM-3103-03,, FM-3104-03,, FM-3105-03,, FM-3106-03,) • Resolve: Nonconforming self-assessment answer (5) • Resolve: Counterfeit part case open (CF-MER-001, CF-MER-002, CF-MER-003) • Resolve: Customer requirement only partly flowed down (FLD-MER-09, FLD-MER-10, FLD-MER-18)
8.4 Control of externally provided processes, products, and services	2.3	Approved: DOC-MER-031 Awaiting approval: DOC-MER-020 Findings: Nonconforming self-assessment answer (10) Supplier audit past its scheduled date (SUP-MER-01, SUP-MER-04, SUP-MER-05, SUP-MER-14, SUP-MER-17) Supplier on probation still delivering (SUP-MER-01, SUP-MER-02, SUP-MER-03, SUP-MER-12, SUP-MER-17) Customer requirement not flowed down (FLD-MER-01, FLD-MER-11, FLD-MER-13, FLD-MER-15) Sub-tier special process without NADCAP accreditation (3) Customer requirement only partly flowed down (FLD-MER-16) Open audit finding (FIND-MER-007) Sub-tier NADCAP accreditation expiring (1) 6 audit or assessment evidence items	• Resolve: Nonconforming self-assessment answer (10) • Resolve: Supplier audit past its scheduled date (SUP-MER-01, SUP-MER-04, SUP-MER-05, SUP-MER-14, SUP-MER-17) • Resolve: Supplier on probation still delivering (SUP-MER-01, SUP-MER-02, SUP-MER-03, SUP-MER-12, SUP-MER-17) • Resolve: Customer requirement not flowed down (FLD-MER-01, FLD-MER-11, FLD-MER-13, FLD-MER-15) • Resolve: Sub-tier special process without NADCAP accreditation (3) • Resolve: Customer requirement only partly flowed down (FLD-MER-16) • Resolve: Open audit finding (FIND-MER-007) • Resolve: Sub-tier NADCAP accreditation expiring (1) • Approve DOC-MER-020 (awaiting approval)

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Sub-clause	Score	On record	To close it
8.5 Production and service provision	0	Approved: DOC-MER-010, DOC-MER-021, DOC-MER-022, DOC-MER-029, DOC-MER-030, DOC-MER-033, DOC-MER-036, DOC-MER-038 Awaiting approval: DOC-MER-002, DOC-MER-009, DOC-MER-028 Findings: Nonconforming self-assessment answer (25) First article report not signed (15) Lot held with no conforming certificate (11) Part submission warrant unsigned (PPAP-MER-3101, PPAP-MER-3102, PPAP-MER-3103, PPAP-MER-3104, PPAP-MER-3105, PPAP-MER-3106) Open audit finding (FIND-MER-003, FIND-MER-011, FIND-MER-001, FIND-MER-006) Accepted first article report with no signatures on record (FAI-MER-104, FAI-MER-105, FAI-MER-109) Customer requirement not flowed down (FLD-MER-02, FLD-MER-03, FLD-MER-12) Process not capable of its tolerance (SPC-3107-HARD) Special process without current accreditation (SP-MER-05) 78 audit or assessment evidence items	• Resolve: Nonconforming self-assessment answer (25) • Resolve: First article report not signed (15) • Resolve: Lot held with no conforming certificate (11) • Resolve: Part submission warrant unsigned (PPAP-MER-3101, PPAP-MER-3102, PPAP-MER-3103, PPAP-MER-3104, PPAP-MER-3105, PPAP-MER-3106) • Resolve: Open audit finding (FIND-MER-003, FIND-MER-011, FIND-MER-001, FIND-MER-006) • Resolve: Accepted first article report with no signatures on record (FAI-MER-104, FAI-MER-105, FAI-MER-109) • Resolve: Customer requirement not flowed down (FLD-MER-02, FLD-MER-03, FLD-MER-12) • Resolve: Process not capable of its tolerance (SPC-3107-HARD) • Resolve: Special process without current accreditation (SP-MER-05) • Approve DOC-MER-002, DOC-MER-009, DOC-MER-028 (awaiting approval)
8.7 Control of nonconforming outputs	55.1	Approved: DOC-MER-007, DOC-MER-011, DOC-MER-023, DOC-MER-040 Findings: Nonconformance open more than 30 days (57) Customer escape caused by a supplier (BOEING-QN-2291, BOEING-SCAR-D1-4426-003, GE-QN-0448, SPIRIT-CAR-7712) Nonconforming self-assessment answer (3) 6 audit or assessment evidence items	• Resolve: Nonconformance open more than 30 days (57) • Resolve: Customer escape caused by a supplier (BOEING-QN-2291, BOEING-SCAR-D1-4426-003, GE-QN-0448, SPIRIT-CAR-7712) • Resolve: Nonconforming self-assessment answer (3)

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Clause 9: Performance Evaluation

Conforming, scored 95.7. Sub-clauses met: 2 of 3.

No sub-clause has a gap.

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Clause 10: Improvement

Minor gaps, scored 77. Sub-clauses met: 2 of 3.

Sub-clause	Score	On record	To close it
10.2 Nonconformity and corrective action	24	Approved: DOC-MER-027 Findings: Recovery action past its due date (13) Nonconforming self-assessment answer (7) Corrective action past due (CAPA-MER-019, CAPA-MER-029, CAPA-MER-042, CAPA-MER-052) Recovery decision still pending past its date (ACT-MER-006, ACT-MER-011) 4 audit or assessment evidence items	• Resolve: Recovery action past its due date (13) • Resolve: Nonconforming self-assessment answer (7) • Resolve: Corrective action past due (CAPA-MER-019, CAPA-MER-029, CAPA-MER-042, CAPA-MER-052) • Resolve: Recovery decision still pending past its date (ACT-MER-006, ACT-MER-011)

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4. Evidence Index

Each controlled document and audit evidence record, with the AS9100D clause it supports. Documents that are awaiting approval, in draft or withdrawn are listed because an auditor will ask about them; only approved documents are evidence.

No evidence records available.

Proof on File for Closed Records

The documents behind your records stay in your systems; the registers say where each is kept. Of 126 closed or held records, 115 name where the proof is kept (CAPA 43 of 46; FAI 2 of 3; MRB 27 of 30; Training 43 of 47). An auditor samples closed records and asks to see that proof, so before the audit pull a sample of the referenced documents and confirm each exists and says what the register records.

11 records closed or held with nowhere named for the proof. Find each before the audit and add its reference; the same list is 12_Evidence_Requests in the pack.

Register	Clause	Record	What	State	Owner
CAPA	10.2	CAPA-MER-022	Porosity at FPI — MER-3118	Closed	D. Reyes
CAPA	10.2	CAPA-MER-045	Cure cycle deviation — MER-3102	Closed	L. Tran
CAPA	10.2	CAPA-MER-060	Bore oversize — MER-3113	Closed	S. Brooks
FAI	8.5.1.3	FAI-MER-105	MER-3105 Floor Beam Support Clip	Approved	Not recorded
MRB	8.7	MRB-MER-313	Hardness below spec after heat treat — MER-3117	Closed	G. Hoffman
MRB	8.7	MRB-MER-324	Missing inspection stamp — MER-3103	Closed	V. Singh (QD)
MRB	8.7	MRB-MER-332	Delamination — MER-3108	Closed	V. Singh (QD)
Training	7.2	MER-E014	Taylor Haddad — AMS Material ID & CoC Verification	Held	Taylor Haddad
Training	7.2	MER-E039	Jamie Okafor — AS9102 FAI Documentation	Held	Jamie Okafor
Training	7.2	MER-E056	Kendall Lindqvist — Autoclave Cure Cycle Qualification	Held	Kendall Lindqvist
Training	7.2	MER-E067	Skyler Sato — AMS Material ID & CoC Verification	Held	Skyler Sato

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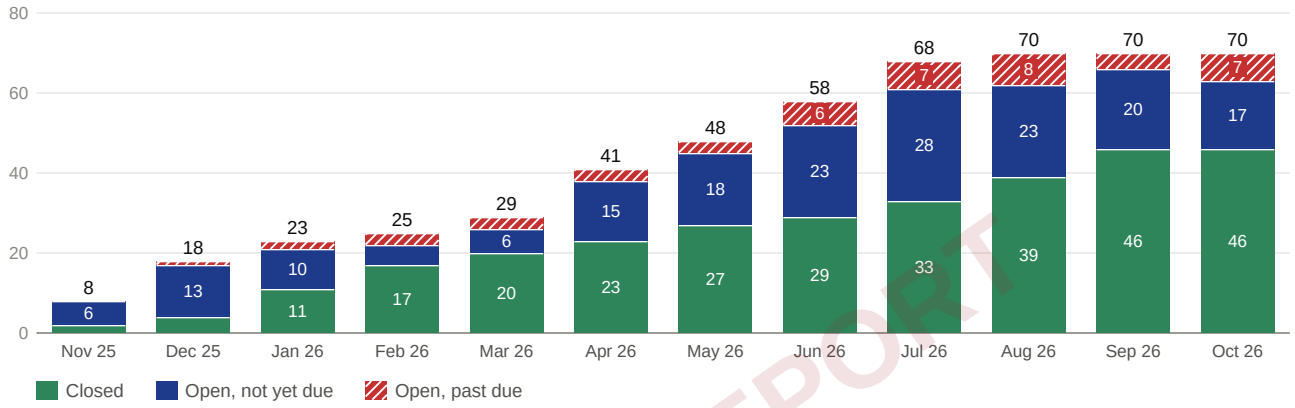
Sample report. Contains no export-controlled (ITAR/EAR) data.

5. Open Issues Package

Every open corrective action, audit finding and risk, with who holds it and when it is due. An item with no owner is shown as not assigned rather than left blank.

5.1 Open CAPAs

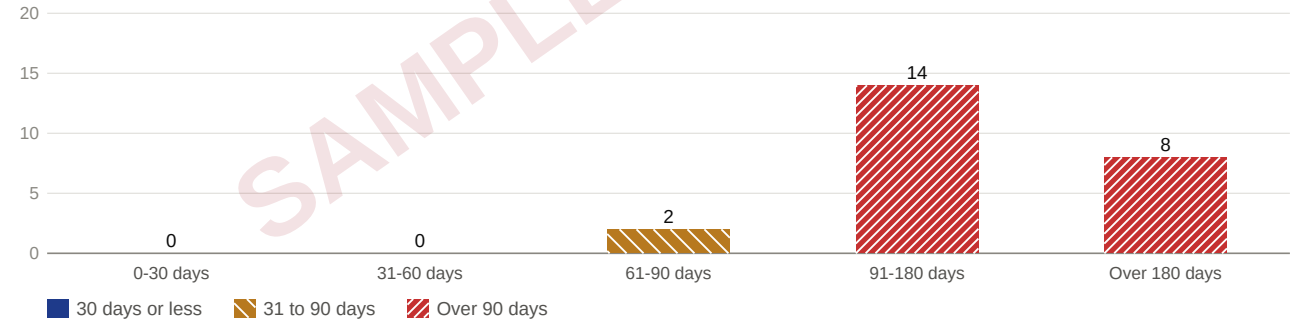
CAPAs Month by Month



The CAPA register at each month end, from its opened, closed and due dates; the last month ends on the report date.

CAPAs at Oct 26 (report date): 46 closed, 17 open and not yet due, 7 past due; at Nov 25: 2 closed, 6 open, 0 past due.

Open CAPAs by Age



Open CAPAs by days since opened.

24 open CAPAs by age: 0 0-30 days, 0 31-60 days, 2 61-90 days, 14 91-180 days, 8 Over 180 days.

24 open, 7 past their due date; 46 closed (37 with effectiveness verified, 9 awaiting the check); 60.9% of closures were on or before the due date.

CAPA	NCR	Title	Root cause	Effectiveness	Status	Owner	Due	Days past due
CAPA-MER-029	NCR-MER-018	Missing inspection stamp — MER-3105	Final inspection signed in batches at shift end	Pending — past due, re-plan not agreed	Implementation	T. Nakamura	2025-12-25	308

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CAPA	NCR	Title	Root cause	Effectiveness	Status	Owner	Due	Days past due
CAPA-MER-042	NCR-MER-031	Wrong revision program run — MER-3110	Programs pulled from a shared folder without revision check	Pending — past due, re-plan not agreed	Implementation	R. Vasquez	2026-03-01	242
CAPA-MER-052	NCR-MER-041	Bore oversize — MER-3107	Boring bar replaced on hours, not on measured wear; tool life exceeded	Pending — past due, re-plan not agreed	Implementation	P. Green	2026-07-08	113
CAPA-MER-019	NCR-MER-005	Edge distance violation — MER-3109	Not recorded	Pending — past due, re-plan not agreed	Root cause	R. Vasquez	2026-07-11	110
CAPA-MER-007	NCR-MER-207	Calibration overdue — 32 assets including CMM and hardness testers	Calibration recall run from a spreadsheet nobody owned during the QM vacancy; no escalation when an asset passed its due date	Pending — vendor scheduling started	Implementation	L. Tran	2026-10-23	6
CAPA-MER-002	NCR-MER-202	Pyrometry gap — 6-month hole in heat treat furnace #3 records	Not recorded	Pending — containment only	Initiated	G. Hoffman	2026-10-25	4
CAPA-MER-006	NCR-MER-206	CNC program revision control — obsolete G-code run on 5-axis center	CNC programs released from a shared folder with no revision lock; the controller ran the last file saved	Pending — interim manual verification in place	Action planning	J. Reeves	2026-10-27	2
CAPA-MER-008	NCR-MER-208	Expired operator certifications — 12 machinists and inspectors	Certification expiry not tracked against the shift roster; the training coordinator role was vacant for five months	Pending — training schedule drafted	Action planning	D. Kowalski	2026-10-29	-
CAPA-MER-024	NCR-MER-012	Porosity at FPI — MER-3103	Casting porosity from the supplier's degassing step, not screened at receipt	Pending — actions in progress	Action planning	D. Reyes	2026-10-29	-

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CAPA	NCR	Title	Root cause	Effectiveness	Status	Owner	Due	Days past due
CAPA-MER-031	NCR-MER-020	Cure cycle deviation — MER-3102	Thermocouple lead pinched in the bag; cure controlled on a failed reading	Pending — actions in progress	Implementation	L. Tran	2026-10-29	-
CAPA-MER-032	NCR-MER-021	Heat lot mismatch on CoC — MER-3107	Receiving checked the CoC for presence, not heat lot against the mill cert	Pending — actions in progress	Implementation	T. Nakamura	2026-10-29	-
CAPA-MER-040	NCR-MER-029	Missing inspection stamp — MER-3103	Final inspection signed in batches at shift end	Pending — actions in progress	Implementation	T. Nakamura	2026-10-29	-
CAPA-MER-070	NCR-MER-060	Bore oversize — MER-3114	Boring bar replaced on hours, not on measured wear; tool life exceeded	Pending — actions in progress	Implementation	K. Osei	2026-10-29	-
CAPA-MER-001	NCR-MER-201	Ti-6Al-4V forging inclusion — wrong heat lot traceability	Not recorded	Pending — no root cause started	Initiated	R. Vasquez	2026-10-30	-
CAPA-MER-004	NCR-MER-204	NDT FPI false-call rate 14% on aluminum wing skins	FPI line developer dwell set by operator judgment, not timed; two Level I operators reading indications unsupervised	Pending — operator requalification started	Implementation	M. Okonkwo	2026-11-02	-
CAPA-MER-003	NCR-MER-203	A320neo nacelle bracket OTD failure — 4 consecutive months <60%	Not recorded	Pending — no action plan	Root cause	T. Nakamura	2026-11-04	-
CAPA-MER-005	NCR-MER-205	Composite layup cure cycle deviation — 3 autoclave batches out of spec	Not recorded	Pending — thermocouple investigation underway	Root cause	S. Petrov	2026-11-06	-

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CAPA	NCR	Title	Root cause	Effectiveness	Status	Owner	Due	Days past due
CAPA-MER-009	NCR-MER-209	Boeing rivet spacing nonconformance — fuselage panel lot 26-018	Not recorded	Pending — lot quarantined	Root cause	A. Chen	2026-11-09	-
CAPA-MER-014	NCR-MER-214	GE Aviation engine mount bracket hardness out of spec	Not recorded	Pending — heat treat parameters under review	Root cause	R. Vasquez	2026-11-12	-
CAPA-MER-010	NCR-MER-210	Chemical processing tank concentration drift — chromate conversion	Titration frequency cut from daily to weekly to save lab time; drift went undetected between checks	Pending — tank drained and recharged	Verification	P. Gutierrez	2026-11-15	-
CAPA-MER-011	NCR-MER-211	Supplier raw material CoC discrepancies — 3 titanium lots	Not recorded	Pending — supplier notified	Root cause	K. Williams	2026-11-19	-
CAPA-MER-013	NCR-MER-213	FOD control failure in sheet metal shop — debris in assembly	No FOD walk at shift change in the sheet metal shop; drill swarf left on benches feeding assembly	Pending — clean-as-you-go audit failed	Implementation	B. Harper	2026-11-22	-
CAPA-MER-012	NCR-MER-212	Prevent recurrence of quality manager vacancy gap	No deputy named for the quality manager; the role's duties were not written down	Pending — succession plan drafted	Action planning	V. Singh (QD)	2026-11-24	-
CAPA-MER-015	NCR-MER-215	Prevent audit finding recurrence — establish internal audit cadence	Internal audit schedule held only in the former quality manager's calendar; nobody else could run it	Pending — schedule proposed	Action planning	V. Singh (QD)	2026-11-29	-

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5.2 Open Audit Findings

Finding	Description	Severity	Clause	Status	Assigned to	Due
FIND-MER-001	Ti-6Al-4V traceability failure — 3 forging lots with incorrect heat lot on CoC	Major	AS9100D 8.5.2	Open	R. Vasquez	2026-10-30
FIND-MER-002	Pyrometry records — 6-month gap in furnace #3 survey documentation	Major	AMS 2750F §3.4	Open	G. Hoffman	2026-10-25
FIND-MER-003	Systematic OTD failure — 4 consecutive months below 60% on nacelle bracket program	Major	AS9100D 8.5.1	Open	T. Nakamura	2026-11-04
FIND-MER-004	32 calibration assets overdue — measurement system integrity compromised	Major	AS9100D 7.1.5	Open	L. Tran	2026-10-23
FIND-MER-005	12 expired operator certifications on active production lines	Major	AS9100D 7.2	Open	D. Kowalski	2026-10-29
FIND-MER-006	Rivet spacing nonconformance on fuselage panel lot 26-018 — acceptance criteria not met	Major	AS9100D 8.5.1	Open	A. Chen	2026-11-09
FIND-MER-007	Supplier CoC discrepancies — 3 titanium lots from Great Plains Titanium with formatting errors	Minor	AS9100D 8.4.2	Open	K. Williams	2026-11-19
FIND-MER-008	Pyrometry control procedure (PYR-200) obsolete — operators working without valid WI	Minor	AS9100D 7.5	Open	G. Hoffman	2026-10-27
FIND-MER-009	Internal audit program lapsed — no internal audits for 4 months (May to September) during QM vacancy	Minor	AS9100D 9.2	Open	V. Singh (QD)	2026-11-29
FIND-MER-010	Engine mount bracket hardness below spec — product released without proper disposition	Minor	AS9100D 8.6	Open	R. Vasquez	2026-11-12
FIND-MER-011	CNC program revision control failure — obsolete G-code executed on 5-axis center	Minor	AS9100D 8.5.1	Open	J. Reeves	2026-10-27
FIND-MER-012	Radiographic inspection film density outside acceptable range on 2 lots	Minor	ASTM E2104	Open	Not assigned	2026-11-14

5.3 Open Risks

Risk	Description	Score	Status	Owner	Due	Mitigation
RISK-MER-01	CB surveillance audit failure leading to AS9100D suspension	25	Identified	V. Singh (QD)	2026-11-04	Pre-audit readiness blitz — gap closure plan in 14 days
RISK-MER-02	Airbus de-source action on A320neo nacelle bracket program	20	Identified	T. Nakamura	2026-11-09	Weekly recovery brief + dedicated expediting cell
RISK-MER-03	NADCAP heat treatment accreditation revoked	20	Identified	G. Hoffman	2026-10-25	Pyrometry record restoration + furnace requalification
RISK-MER-04	Boeing contract termination for chronic SCAR non-closure	20	Identified	R. Vasquez	2026-11-02	SCAR response team + root cause sprint

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Risk	Description	Score	Status	Owner	Due	Mitigation
RISK-MER-06	Measurement system integrity — 32 overdue calibrations invalidate acceptance data	20	Identified	L. Tran	2026-10-23	Emergency calibration vendor mobilization
RISK-MER-05	Titanium raw material traceability gaps expose latent field escapes	16	Identified	K. Williams	2026-11-06	Lot-by-lot containment review + supplier CoC reconciliation
RISK-MER-07	Workforce competency — 12 expired operator certs on active production lines	16	Identified	D. Kowalski	2026-10-29	Accelerated requalification program + interim supervision
RISK-MER-09	GE Aviation engine mount bracket field return — hardness failure	15	Identified	R. Vasquez	2026-11-12	Lot containment + heat treat parameter revalidation
RISK-MER-08	Spirit AeroSystems quality escalation — second-tier customer ripple effect	12	Identified	T. Nakamura	2026-11-15	Proactive communication + shared corrective action visibility
RISK-MER-10	Insurance/liability exposure from uncontrolled product release	12	Identified	V. Singh (QD)	2026-11-24	Legal review + product containment verification

5.4 Closed CAPAs (Effectiveness Checks)

CAPA	Title	Status	Closed	Effectiveness criteria
CAPA-MER-016	Hardness below spec after heat treat — MER-3117	Closed	2026-09-20	Closed; effectiveness check due 2026-12-04
CAPA-MER-017	Hardness below spec after heat treat — MER-3106	Closed	2026-04-23	Verified effective — no recurrence in 45 days
CAPA-MER-018	Heat lot mismatch on CoC — MER-3114	Closed	2026-02-15	Verified effective — no recurrence in 73 days
CAPA-MER-020	Bore oversize — MER-3102	Closed	2026-01-15	Verified effective — no recurrence in 74 days
CAPA-MER-021	Surface finish Ra out of spec — MER-3114	Closed	2026-02-10	Verified effective — no recurrence in 50 days
CAPA-MER-022	Porosity at FPI — MER-3118	Closed	2026-01-17	Verified effective — no recurrence in 50 days
CAPA-MER-023	Delamination — MER-3102	Closed	2026-08-06	Verified effective — no recurrence in 49 days
CAPA-MER-025	Edge distance violation — MER-3106	Closed	2026-07-08	Verified effective — no recurrence in 68 days
CAPA-MER-026	Edge distance violation — MER-3102	Closed	2026-08-11	Verified effective — no recurrence in 41 days
CAPA-MER-027	Heat lot mismatch on CoC — MER-3107	Closed	2026-08-06	Verified effective — no recurrence in 35 days
CAPA-MER-028	Porosity at FPI — MER-3115	Closed	2026-01-17	Verified effective — no recurrence in 74 days
CAPA-MER-030	Missing inspection stamp — MER-3115	Closed	2025-11-18	Verified effective — no recurrence in 61 days

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CAPA	Title	Status	Closed	Effectiveness criteria
CAPA-MER-033	Wrong revision program run — MER-3112	Closed	2026-09-03	Closed; effectiveness check due 2026-11-08
CAPA-MER-034	Hardness below spec after heat treat — MER-3104	Closed	2026-01-18	Verified effective — no recurrence in 64 days
CAPA-MER-035	Porosity at FPI — MER-3105	Closed	2026-07-09	Verified effective — no recurrence in 72 days
CAPA-MER-036	Edge distance violation — MER-3112	Closed	2026-08-06	Verified effective — no recurrence in 43 days
CAPA-MER-037	Edge distance violation — MER-3117	Closed	2026-09-16	Closed; effectiveness check due 2026-11-06
CAPA-MER-038	Cure cycle deviation — MER-3110	Closed	2026-05-20	Verified effective — no recurrence in 48 days
CAPA-MER-039	Porosity at FPI — MER-3109	Closed	2026-06-12	Verified effective — no recurrence in 67 days
CAPA-MER-041	Porosity at FPI — MER-3102	Closed	2026-05-23	Verified effective — no recurrence in 72 days
CAPA-MER-043	Cure cycle deviation — MER-3112	Closed	2025-11-28	Verified effective — no recurrence in 52 days
CAPA-MER-044	Surface finish Ra out of spec — MER-3117	Closed	2026-04-29	Verified effective — no recurrence in 59 days
CAPA-MER-045	Cure cycle deviation — MER-3102	Closed	2026-02-03	Verified effective — no recurrence in 38 days
CAPA-MER-046	Delamination — MER-3109	Closed	2026-02-01	Verified effective — no recurrence in 47 days
CAPA-MER-047	Delamination — MER-3108	Closed	2026-04-19	Verified effective — no recurrence in 33 days
CAPA-MER-048	Delamination — MER-3110	Closed	2025-12-04	Verified effective — no recurrence in 36 days
CAPA-MER-049	Edge distance violation — MER-3116	Closed	2026-08-29	Closed; effectiveness check due 2026-10-01
CAPA-MER-050	Bore oversize — MER-3113	Closed	2026-09-13	Closed; effectiveness check due 2026-11-27
CAPA-MER-051	Porosity at FPI — MER-3116	Closed	2026-06-16	Verified effective — no recurrence in 52 days
CAPA-MER-053	Bore oversize — MER-3109	Closed	2026-03-29	Verified effective — no recurrence in 65 days
CAPA-MER-054	Delamination — MER-3103	Closed	2026-08-08	Closed; effectiveness check due 2026-10-13
CAPA-MER-055	Porosity at FPI — MER-3113	Closed	2026-09-18	Closed; effectiveness check due 2026-10-24
CAPA-MER-056	Porosity at FPI — MER-3118	Closed	2026-02-08	Verified effective — no recurrence in 35 days
CAPA-MER-057	Delamination — MER-3108	Closed	2026-07-29	Verified effective — no recurrence in 40 days
CAPA-MER-058	Surface finish Ra out of spec — MER-3103	Closed	2026-01-07	Verified effective — no recurrence in 66 days

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CAPA	Title	Status	Closed	Effectiveness criteria
CAPA-MER-059	Wrong revision program run — MER-3115	Closed	2026-05-10	Verified effective — no recurrence in 55 days
CAPA-MER-060	Bore oversize — MER-3113	Closed	2026-05-22	Verified effective — no recurrence in 36 days
CAPA-MER-061	Bore oversize — MER-3103	Closed	2026-01-21	Verified effective — no recurrence in 72 days
CAPA-MER-062	Wrong revision program run — MER-3101	Closed	2025-12-04	Verified effective — no recurrence in 32 days
CAPA-MER-063	Missing inspection stamp — MER-3110	Closed	2026-02-18	Verified effective — no recurrence in 36 days
CAPA-MER-064	Delamination — MER-3107	Closed	2026-01-02	Verified effective — no recurrence in 65 days
CAPA-MER-065	Surface finish Ra out of spec — MER-3111	Closed	2026-09-13	Closed; effectiveness check due 2026-11-20
CAPA-MER-066	Bore oversize — MER-3113	Closed	2026-03-16	Verified effective — no recurrence in 30 days
CAPA-MER-067	Porosity at FPI — MER-3103	Closed	2026-09-08	Closed; effectiveness check due 2026-10-17
CAPA-MER-068	Porosity at FPI — MER-3102	Closed	2026-07-13	Verified effective — no recurrence in 30 days
CAPA-MER-069	Delamination — MER-3101	Closed	2026-03-27	Verified effective — no recurrence in 62 days

SAMPLE REPORT

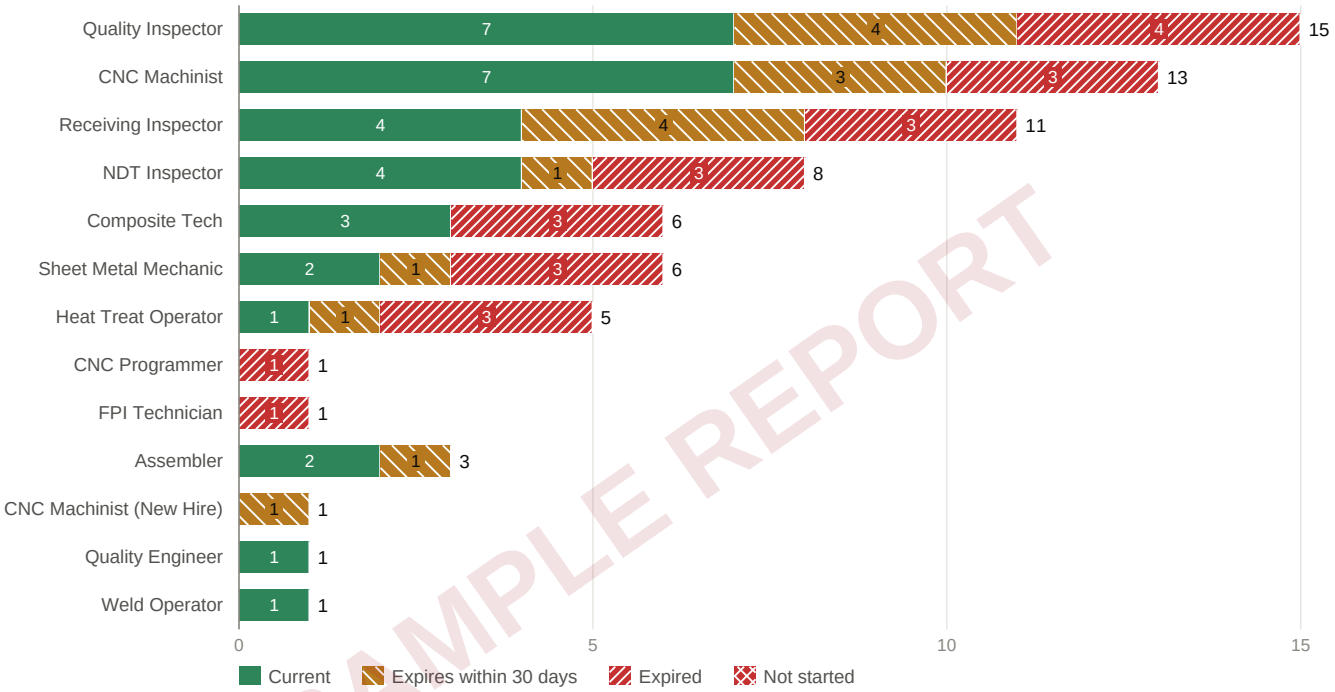
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Sample report. Contains no export-controlled (ITAR/EAR) data.

6. Training & Competency Snapshot

Measure	Value	What it measures
Training assignment completion (%)	**65.3**	47 of 72 training assignments completed.
Expired qualifications	**12**	Qualification records whose expiry date is past.
People with an expired qualification	**12**	Distinct people holding at least one expired qualification.

Qualification Currency by Role



Qualifications held, by the holder's role in the training matrix, on the report date. Not started: assigned and not yet begun.

Quality Inspector: 7 current, 4 expires within 30 days, 4 expired; CNC Machinist: 7 current, 3 expires within 30 days, 3 expired; Receiving Inspector: 4 current, 4 expires within 30 days, 3 expired; NDT Inspector: 4 current, 1 expires within 30 days, 3 expired; Composite Tech: 3 current, 3 expired; Sheet Metal Mechanic: 2 current, 1 expires within 30 days, 3 expired; Heat Treat Operator: 1 current, 1 expires within 30 days, 3 expired; CNC Programmer: 1 expired; FPI Technician: 1 expired; Assembler: 2 current, 1 expires within 30 days; CNC Machinist (New Hire): 1 expires within 30 days; Quality Engineer: 1 current; Weld Operator: 1 current.

Expired Qualifications

Employee	Name	Qualification	Expired
MER-E006	Aisha Patel	AS9102 FAI Documentation	2026-05-01
MER-E022	Sawyer Mbeki	GD&T per ASME Y14.5	2026-06-08
MER-E002	Janice Whitfield	ASNT NDT Level II (UT)	2026-06-16
MER-E004	Maria Santos	Autoclave Cure Cycle Qualification	2026-06-17
MER-E001	Carlos Rivera	NADCAP Heat Treat Operator Qual	2026-07-01
MER-E025	Parker Castillo	AMS 2750 Pyrometry Requirements	2026-07-05

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Employee	Name	Qualification	Expired
MER-E031	Parker Chen	GD&T per ASME Y14.5	2026-07-20
MER-E003	Derek Fung	Fanuc CNC Programming Cert	2026-07-27
MER-E021	Riley Yamada	ASNT NDT Level II (PT)	2026-08-10
MER-E005	Kevin O'Brien	Boeing BAC 5000 Series Awareness	2026-08-14
MER-E012	Samantha Brooks	ASNT NDT Level II (PT/MT)	2026-08-18
MER-E030	Reese Castillo	AS9102 FAI Documentation	2026-08-26

SAMPLE REPORT

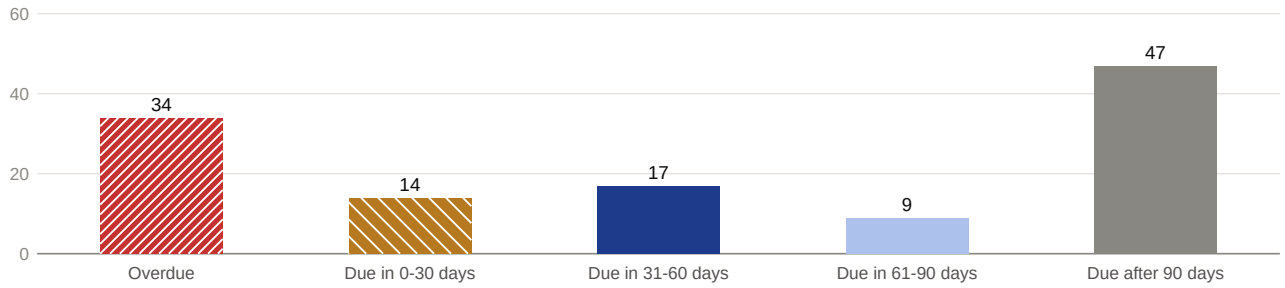
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7. Calibration & MSA

Calibration Compliance: 73.6% · Past due: 34 · Failed calibration: 3

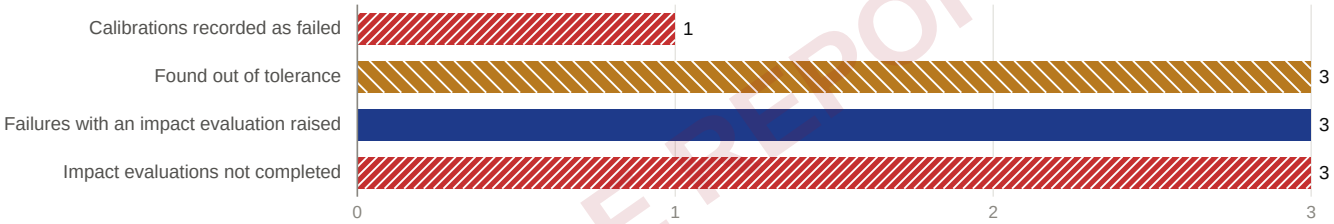
When Each Gauge Falls Due



Measuring equipment in service by when its next calibration falls due from the report date. Overdue is as your calibration register records it.

121 gauges in service: 34 overdue, 14 due in 0-30 days, 17 due in 31-60 days, 9 due in 61-90 days, 47 due after 90 days.

Failed and Out-of-Tolerance Calibrations



From 108 calibrations recorded in the 12 months to the report date, and the impact evaluations raised for failures.

108 calibrations in 12 months: 1 failed, 3 found out of tolerance; 3 impact evaluations raised, 3 not completed.

SAMPLE REPORT

Failed Calibration and Product Impact (7.1.5.2)

Asset	Equipment	Failed	Evaluation	In doubt	Disposition
CAL-MER-121	Bore Gauge 12mm (cell 4)	2026-09-19	Pending evaluation	Not yet assessed	Not yet dispositioned
CAL-MER-02	Wilson Rockwell Hardness Tester	2026-09-21	Pending evaluation	Not yet assessed	Not yet dispositioned
CAL-MER-03	Fluke 1586A Super-DAQ Pyrometer	2026-09-21	Pending evaluation	Not yet assessed	Not yet dispositioned

"Not yet assessed" means no measurement record links this equipment to the parts it accepted. Supply the gauge-usage records (instrument, work order, date) to size the suspect population; until then it is unbounded, not zero.

Overdue Calibrations

Risk Statement: Overdue calibrations may impact product acceptance decisions made using affected measurement equipment.

Asset	Serial	Equipment	Location	Due	Days past due
CAL-MER-018	TPG-7018	Thread Plug Gauge Set	Receiving	2026-04-21	191
CAL-MER-015	MIC-7015	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-04-26	186

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Asset	Serial	Equipment	Location	Due	Days past due
CAL-MER-022	PRF-7022	Profilometer SJ-210	Inspection Bay 2	2026-05-07	175
CAL-MER-021	PG-7021	Pressure Gauge 0-100 psi	Autoclave	2026-05-09	173
CAL-MER-014	TW-7014	Torque Wrench 20-100 Nm	Sub-Assembly	2026-05-15	167
CAL-MER-029	MIC-7029	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-05-16	166
CAL-MER-035	TPG-7035	Thread Plug Gauge Set	Receiving	2026-05-24	158
CAL-MER-024	TPG-7024	Thread Plug Gauge Set	Receiving	2026-06-10	141
CAL-MER-031	TW-7031	Torque Wrench 20-100 Nm	Sub-Assembly	2026-06-14	137
CAL-MER-016	MIC-7016	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-06-25	126
CAL-MER-01	CMM-4401	Zeiss Contura CMM	Inspection Bay 1	2026-07-01	120
CAL-MER-013	CAL-7013	Mitutoyo Digital Caliper 150mm	CNC Shop Floor	2026-07-03	118
CAL-MER-033	MIC-7033	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-07-12	109
CAL-MER-012	SP-7012	Surface Plate Grade A	Inspection Bay 1	2026-07-15	106
CAL-MER-08	SHG-5503	Starrett Height Gauge 0-600mm	Sheet Metal Shop	2026-07-16	105
CAL-MER-121	BG-14	Bore Gauge 12mm (cell 4)	CNC Cell 4	2026-07-16	105
CAL-MER-023	MIC-7023	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-07-17	104
CAL-MER-030	CAL-7030	Mitutoyo Digital Caliper 150mm	CNC Shop Floor	2026-07-21	100
CAL-MER-027	MIC-7027	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-07-26	95
CAL-MER-011	MIC-7011	Mitutoyo Outside Micrometer 0-25mm	CNC Shop Floor	2026-07-28	93
CAL-MER-025	BG-7025	Bore Gauge 10-18mm	CNC Shop Floor	2026-08-07	83
CAL-MER-034	BG-7034	Bore Gauge 10-18mm	CNC Shop Floor	2026-08-10	80
CAL-MER-04	UT-3310	Olympus OmniScan MX2 UT System	NDT Cell	2026-08-18	72
CAL-MER-028	DUR-7028	Durometer Shore A	Receiving	2026-08-20	70
CAL-MER-036	CAL-7036	Mitutoyo Digital Caliper 150mm	CNC Shop Floor	2026-08-23	67
CAL-MER-019	TPG-7019	Thread Plug Gauge Set	Receiving	2026-08-25	65
CAL-MER-032	DUR-7032	Durometer Shore A	Receiving	2026-08-25	65
CAL-MER-020	TC-7020	Type K Thermocouple	Furnace #2	2026-08-27	63
CAL-MER-09	TC-9912	Autoclave Thermocouple Array (12 ch)	Composite Bay	2026-09-08	51
CAL-MER-017	PRF-7017	Profilometer SJ-210	Inspection Bay 2	2026-09-08	51
CAL-MER-026	TPG-7026	Thread Plug Gauge Set	Receiving	2026-09-18	41
CAL-MER-05	BG-6601	Mitutoyo Bore Gauge Set 50-150mm	CNC Shop Floor	2026-09-26	33

Total equipment tracked: 121

SAMPLE REPORT

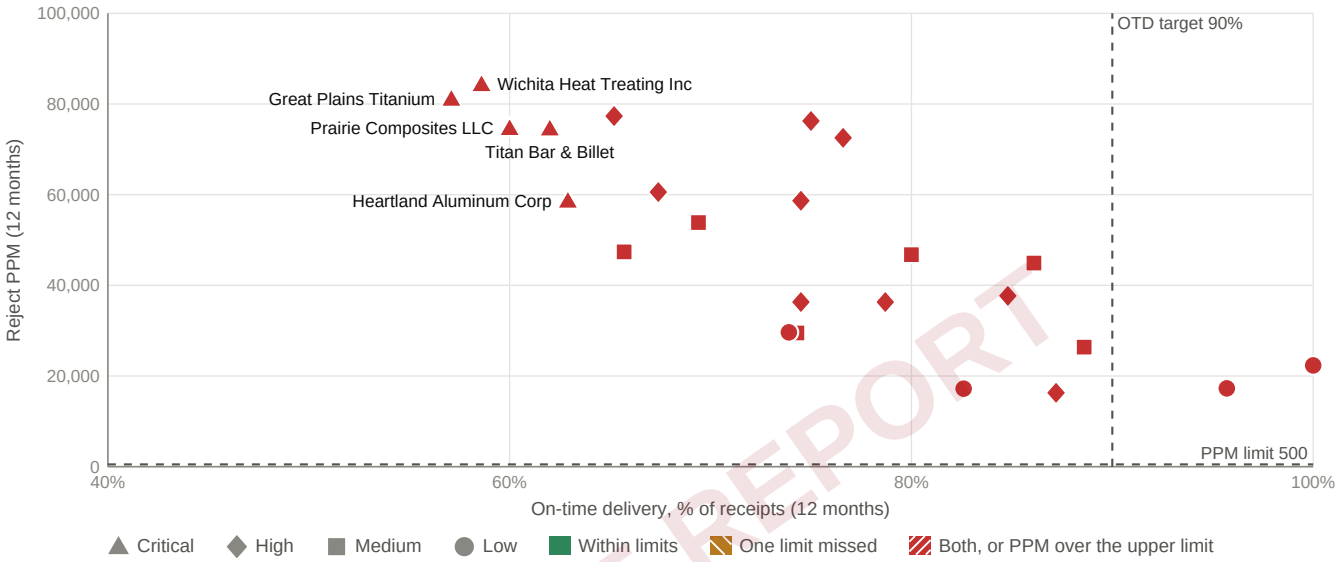
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Sample report. Contains no export-controlled (ITAR/EAR) data.

8. Supplier Governance

25 suppliers on record; 12 need attention. Each row joins the supplier's scores with its special-process accreditation (8.5.1.2), its sub-tiers' NADCAP accreditation (8.4.2), requirement flow-down (8.4.3), counterfeit cases (8.1.4) and risk index.

Delivery Against Rejects



Each supplier with receipts: delivery and rejects from its receipts. Marker shape is the criticality on the supplier list; the furthest out are named.

24 suppliers with receipts, 24 missing a limit. Furthest out: Wichita Heat Treating Inc 58.6% on time, 84,261 PPM (critical); Great Plains Titanium 57.1% on time, 81,034 PPM (critical); Prairie Composites LLC 60% on time, 74,576 PPM (critical); Titan Bar & Billet 62% on time, 74,483 PPM (critical); Flint Chemical Processing 65.2% on time, 77,333 PPM (high); Heartland Aluminum Corp 62.9% on time, 58,554 PPM (critical).

Supplier	Status	Criticality	OTD %	Quality	Reject PPM	Risk index	Flow-down	Special proc. without current approval	Sub-tier NADCAP gaps	Counterfeit open
Great Plains Titanium	Probation	Critical	57.1	68	81,034	71.7 (Medium)	0/1 flowed (0 verified)	-	1	1
Heartland Aluminum Corp	Probation	Critical	62.9	74	58,554	39 (Low)	none mapped	-	1	-
Aero Fastener Brokers	Conditional	High	75	69	76,250	20 (Low)	0/1 flowed, 1 partly (0 verified)	-	-	2
Great Bend Machining	Conditional	Medium	65.7	81	47,385	17.8 (Low)	0/1 flowed (0 verified)	-	1	-
Prairie Composites LLC	Probation	Critical	60	71	74,576	55.5 (Medium)	none mapped	-	-	-
Wichita Heat Treating Inc	Conditional	Critical	58.6	65	84,261	45.5 (Medium)	1/1 flowed (1 verified)	-	-	-
Titan Bar & Billet	Probation	Critical	62	70	74,483	39.8 (Low)	0/1 flowed (0 verified)	-	-	-

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Sample report. Contains no export-controlled (ITAR/EAR) data.

Supplier	Status	Criticality	OTD %	Quality	Reject PPM	Risk index	Flow-down	Special proc. without current approval	Sub-tier NADCAP gaps	Counterfeit open
Emporia Anodizing Co	Probation	High	76.6	71	72,537	28.5 (Low)	0/1 flowed (0 verified)	-	-	-
Flint Chemical Processing	Conditional	High	65.2	72	77,333	23.1 (Low)	none mapped	-	-	-
Kansas Precision Castings	Conditional	High	67.4	76	60,571	22 (Low)	none mapped	-	-	-
Central NDT Services	Conditional	High	74.5	78	58,659	19.8 (Low)	none mapped	-	-	-
Salina Sheet Metal Works	Conditional	Medium	69.4	79	53,846	17 (Low)	none mapped	-	-	-
Manhattan Metrology Services	Approved	High	74.5	86	36,316	8.9 (Low)	none mapped	-	-	-
Midwest Fastener Supply	Approved	High	78.7	83	36,311	7.5 (Low)	none mapped	-	-	-
Flint Hills Adhesives	Approved	Medium	74.3	87	29,493	7 (Low)	none mapped	-	-	-
Plains Surface Technologies	Approved	Medium	80	80	46,763	6.9 (Low)	none mapped	-	-	-
Precision Tooling Solutions	Approved	High	84.8	86	37,688	5.8 (Low)	none mapped	-	-	-
Hays Composite Tooling	Approved	Medium	86.1	84	44,912	5.4 (Low)	none mapped	-	-	-
Newton Tool Grinding	Approved	Low	73.9	90	29,630	5.3 (Low)	none mapped	-	-	-
Topeka Test Labs	Approved	High	87.2	94	16,292	4.4 (Low)	none mapped	-	-	-
Dodge City Freight Services	Approved	Low	82.6	93	17,204	4.3 (Low)	none mapped	-	-	-
Hutchinson Seals & Gaskets	Approved	Medium	88.6	88	26,367	3.4 (Low)	none mapped	-	-	-
Lawrence Wire & Harness	Approved	Low	95.7	95	17,273	1.8 (Low)	none mapped	-	-	-
Sunflower Packaging & Kitting	Approved	Low	100	92	22,335	0.3 (Low)	none mapped	-	-	-

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Sample report. Contains no export-controlled (ITAR/EAR) data.

Supplier	Status	Criticality	OTD %	Quality	Reject PPM	Risk index	Flow-down	Special proc. without current approval	Sub-tier NADCAP gaps	Counterfeit open
Sunflower NDT Services LLC	Approved	-	-	0	-	-	none mapped	-	-	-

Suppliers Needing Attention

Great Plains Titanium — status probation; 1 sub-tier special process without a current NADCAP accreditation: Wichita Heat Treating Inc (nondestructive testing, not accredited); 1 counterfeit case open: CF-MER-003.

Heartland Aluminum Corp — status probation; 1 sub-tier special process without a current NADCAP accreditation: Flint Chemical Processing (chemical processing, expired 2026-08-31).

Prairie Composites LLC — status probation.

Wichita Heat Treating Inc — status conditional.

Central NDT Services — status conditional.

Flint Chemical Processing — status conditional.

Kansas Precision Castings — status conditional.

Titan Bar & Billet — status probation.

Aero Fastener Brokers — status conditional; 2 counterfeit cases open: CF-MER-001, CF-MER-002.

Great Bend Machining — status conditional; 1 sub-tier special process without a current NADCAP accreditation: Plains Surface Technologies (coatings, not accredited).

Salina Sheet Metal Works — status conditional.

Emporia Anodizing Co — status probation.

SAMPLE REPORT

OTD % is the share of the last 12 months' receipts delivered on time. Reject PPM is rejected over received units on the last 12 months' receipts (24 of 25 suppliers have receipts). The risk index is Aegis's proprietary assessment of each supplier's delivery, quality and findings, taking account of the criticality your supplier list records. The table is ordered by it. Not assessed from the records supplied: on-time-in-full (receipts record quantity received, not quantity ordered); corrective-action request cycle time (quality events record no closure date).

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Sample report. Contains no export-controlled (ITAR/EAR) data.

9. Internal Audit Program Evidence

Internal audits: 8

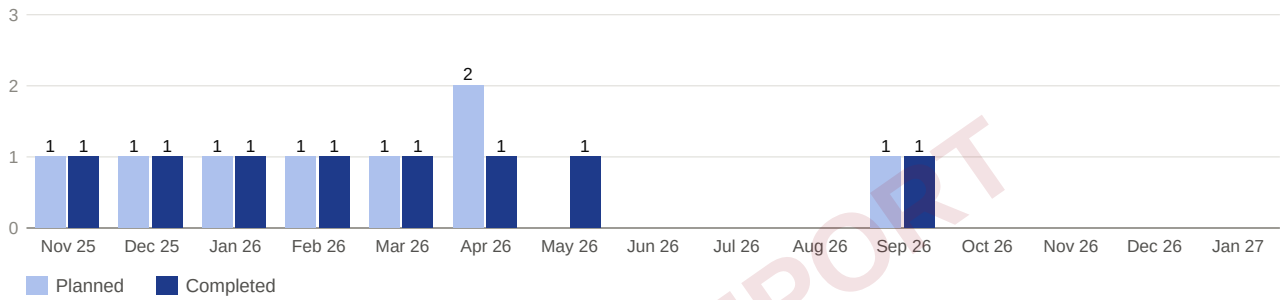
Completed: 8

In Progress: 0

Planned: 0

External, customer and registrar audits: 4 (listed in the schedule below; not part of the internal audit program).

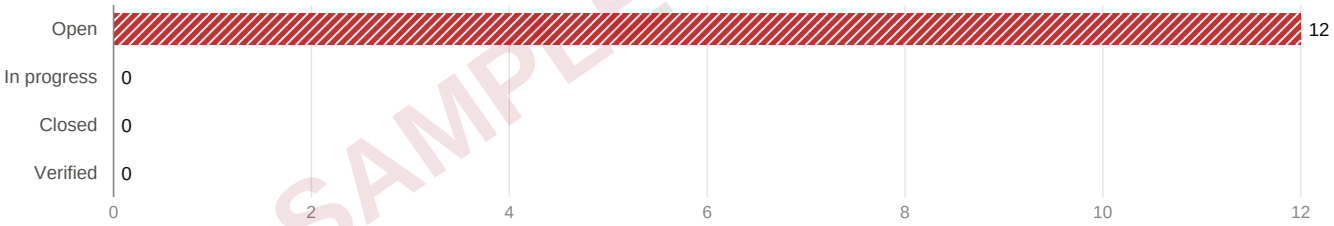
Internal Audit Program: Planned Against Completed



Internal audit program: audits scheduled in each month and audits completed in it, twelve months back and three ahead.

8 internal audits scheduled and 8 completed from Nov 25 to Jan 27.

Findings by Status



Audit findings by status, internal, external and customer.

12 audit findings: 12 open, 0 in progress, 0 closed, 0 verified.

Audit Schedule

Audit	Name	Type	Status	Lead auditor	Scheduled	Findings
AUD-MER-01	Clause 4-6 context, leadership, risk	Internal	Completed	Registrar	2025-11-24	0
AUD-MER-02	Clause 7.1.5 measuring resources	Internal	Completed	P. Green	2025-12-20	0
AUD-MER-03	Clause 7.2 competence	Internal	Completed	K. Osei	2026-01-15	0
AUD-MER-04	Clause 8.4 external providers	Internal	Completed	K. Osei	2026-02-10	0
AUD-MER-05	Clause 8.5 production and traceability	Internal	Completed	K. Osei	2026-03-08	0
AUD-MER-06	Clause 8.7 / 10.2 nonconformity and CAPA	Internal	Completed	P. Green	2026-04-03	0
AUD-MER-07	Clause 9.1-9.3 performance evaluation	Internal	Completed	K. Osei	2026-04-29	7
AUD-MER-08	Boeing source inspection	External	Completed	P. Green	2026-05-25	2

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Audit	Name	Type	Status	Lead auditor	Scheduled	Findings
AUD-MER-09	Nadcap heat treat	External	Completed	Registrar	2026-06-20	2
AUD-MER-10	CB surveillance (registrar)	Surveillance	Completed	Registrar	2026-07-16	0
AUD-MER-11	Airbus Level 3 escalation review	External	Completed	K. Osei	2026-08-11	0
AUD-MER-12	Clause 7.5 documented information	Internal	Completed	P. Green	2026-09-06	1

Findings Closure Rate: 0% (0/12)

SAMPLE REPORT

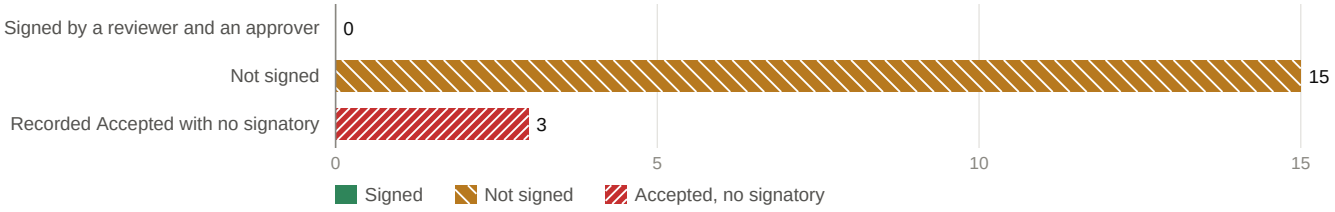
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10. First Article Inspection (AS9102)

Clause 8.5.1.3 — production process verification. Each report below shows its status and outcome, and whether it carries the two distinct signatures AS9102 Rev C fields 20 and 22 require.

Signature State



First article reports by signature state, from the FAI log. Accepted with no signatory is a records gap: the report was accepted but who reviewed and approved it is not on record.

18 first article reports: 0 signed, 15 not signed, 3 recorded Accepted with no signatory.

FAI	Part	Type	Customer	Status	Due	Findings / disposition	Signatures
FAI-MER-101	MER-3101 A320neo Nacelle Bracket Assy	Full	Airbus	Open	2026-10-02	Heat treat certs missing; 4 dimensional chars out of tolerance; Resubmit	Not signed
FAI-MER-102	MER-3102 737 Fuselage Frame Segment	Full	Boeing	Rejected	2026-09-24	Material CoC mismatch — wrong Ti alloy traced; Rejected — new lot required	Not signed
FAI-MER-103	MER-3103 Wing Rib Upper Panel	Full	Boeing	Open	2026-10-06	CNC program rev not matching drawing rev; In Review	Not signed
FAI-MER-104	MER-3104 Pylon Attach Fitting	Full	Airbus	Accepted	2026-09-14	1 minor balloon note error; Accepted	Accepted; no signatories recorded
FAI-MER-105	MER-3105 Floor Beam Support Clip	Partial	Boeing	Accepted	2026-09-01	No findings; Accepted	Accepted; no signatories recorded
FAI-MER-106	MER-3106 Composite Trailing Edge Panel	Full	Spirit AeroSystems	Open	2026-10-09	Autoclave cure cycle deviation; FPI rework not documented; Resubmit	Not signed
FAI-MER-107	MER-3107 Engine Mount Bracket	Delta	GE Aviation	Rejected	2026-09-26	Hardness below spec after heat treat; Rejected — process revalidation required	Not signed
FAI-MER-108	MER-3108 Cargo Door Hinge Fitting	Full	Airbus	Open	2026-10-12	Awaiting calibrated CMM data — CMM overdue; On Hold	Not signed
FAI-MER-109	MER-3109 Stringer Doubler	Delta	Boeing	Accepted	2026-09-06	1 minor cosmetic note; Accepted	Accepted; no signatories recorded
FAI-MER-110	MER-3110 Flap Track Fairing	Full	Spirit AeroSystems	Open	2026-10-17	Composite layup records incomplete; In Review	Not signed

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FAI	Part	Type	Customer	Status	Due	Findings / disposition	Signatures
FAI-MER-111	MER-3111 Nacelle Thrust Link	Full	Airbus	Open	2026-09-23	Balloon drawing incomplete; In Review	Not signed
FAI-MER-112	MER-3112 Keel Beam Splice Plate	Full	Boeing	Open	2026-09-05	Balloon drawing incomplete; In Review	Not signed
FAI-MER-113	MER-3113 Access Panel Frame	Full	Spirit AeroSystems	Open	2026-09-25	Balloon drawing incomplete; In Review	Not signed
FAI-MER-114	MER-3114 Fan Cowl Latch Bracket	Full	GE Aviation	In review	2026-08-27	Balloon drawing incomplete; In Review	Not signed
FAI-MER-115	MER-3115 Seat Track Splice	Full	Boeing	In review	2026-08-06	Balloon drawing incomplete; In Review	Not signed
FAI-MER-116	MER-3116 Pressure Bulkhead Clip	Full	Airbus	Open	2026-09-16	Balloon drawing incomplete; In Review	Not signed
FAI-MER-117	MER-3117 Composite Fairing Skin	Full	Spirit AeroSystems	Open	2026-10-10	Balloon drawing incomplete; In Review	Not signed
FAI-MER-118	MER-3118 Titanium Hinge Lug	Full	Boeing	Open	2026-09-21	Balloon drawing incomplete; In Review	Not signed

Open item: 15 first article reports are not yet signed by both a reviewer and an approver.
Records gap: 3 first article reports are recorded as accepted with no reviewer or approver on record.

SAMPLE REPORT

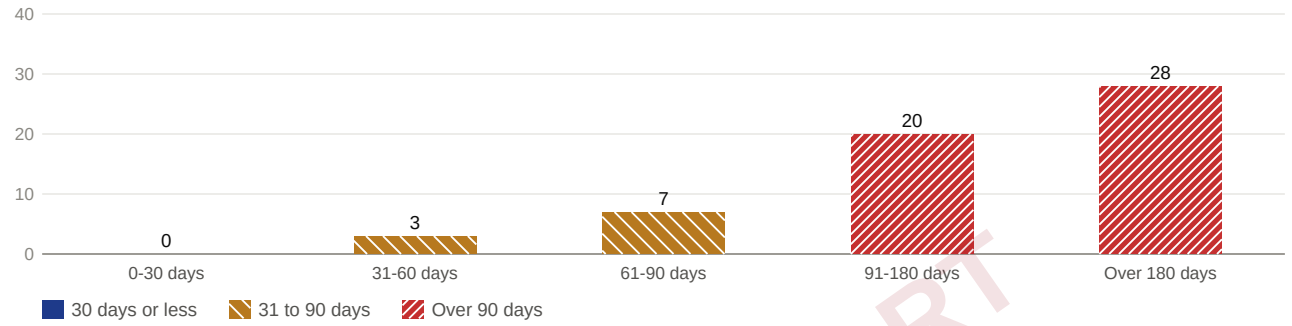
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11. Nonconforming Product, Containment and Material Review

Clause 8.7 — control of nonconforming outputs. Containment is the control that decides whether suspect product reached a customer, so it is reported per nonconformance rather than in summary.

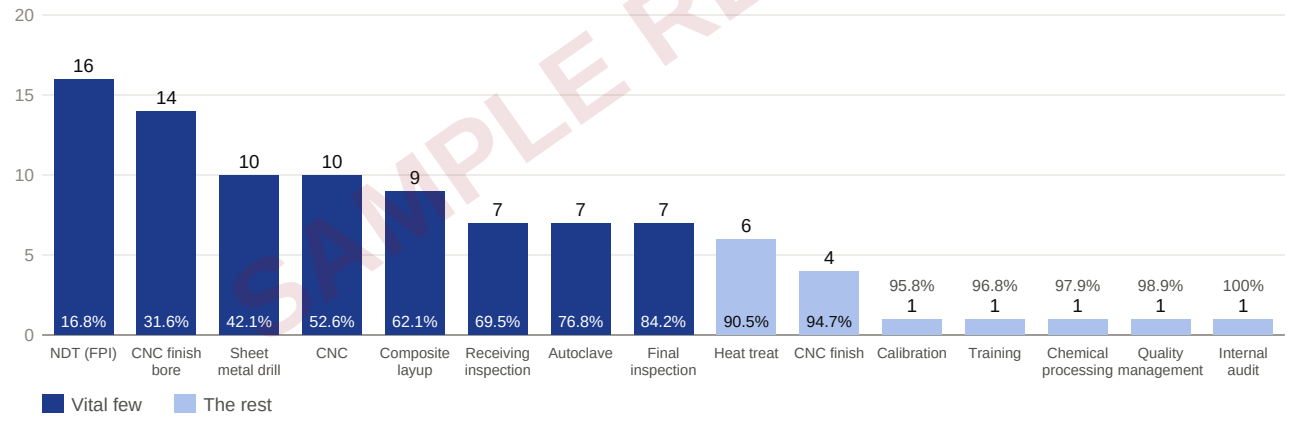
Open Nonconformances by Age



Open nonconformances by days since detected.

58 open nonconformances by age: 0 0-30 days, 3 31-60 days, 7 61-90 days, 20 91-180 days, 28 Over 180 days.

Where the Nonconformances Come From



95 nonconformances. Dark bars are the vital few (together 80%); the percentage in each bar is the cumulative share, largest first.

95 nonconformances: 8 of 15 account for 84.2%: NDT (FPI) (16), CNC finish bore (14), Sheet metal drill (10), CNC (10), Composite layup (9), Receiving inspection (7), Autoclave (7), Final inspection (7).

Containment Status

NCR	Nonconformance	Contained	Zones outstanding	Deadline	Status
NCR-MER-001	Hardness below spec after heat treat — MER-3117	Yes	None	2026-06-29	Complete
NCR-MER-002	Hardness below spec after heat treat — MER-3106	Yes	None	2026-03-07	Complete
NCR-MER-003	Heat lot mismatch on CoC — MER-3114	Yes	None	2026-01-16	Complete
NCR-MER-004	Delamination — MER-3103	Yes	None	2026-09-23	Complete

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NCR	Nonconformance	Contained	Zones outstanding	Deadline	Status
NCR-MER-005	Edge distance violation — MER-3109	Yes	None	2026-04-24	Complete
NCR-MER-006	Bore oversize — MER-3102	Yes	None	2025-12-03	Complete
NCR-MER-007	Surface finish Ra out of spec — MER-3114	Yes	None	2025-11-30	Complete
NCR-MER-008	Porosity at FPI — MER-3118	Yes	None	2025-12-16	Complete
NCR-MER-009	Delamination — MER-3102	Yes	None	2026-04-11	Complete
NCR-MER-010	Cure cycle deviation — MER-3117	Yes	None	2026-08-18	Complete
NCR-MER-011	Wrong revision program run — MER-3115	Yes	None	2026-09-14	Complete
NCR-MER-012	Porosity at FPI — MER-3103	Yes	None	2026-07-17	Complete
NCR-MER-013	Edge distance violation — MER-3106	Yes	None	2026-03-18	Complete
NCR-MER-014	Bore oversize — MER-3110	Yes	None	2026-08-18	Complete
NCR-MER-015	Edge distance violation — MER-3102	Yes	None	2026-07-06	Complete
NCR-MER-016	Heat lot mismatch on CoC — MER-3107	Yes	None	2026-04-10	Complete
NCR-MER-017	Porosity at FPI — MER-3115	Yes	None	2025-11-03	Complete
NCR-MER-018	Missing inspection stamp — MER-3105	Yes	None	2025-10-23	Complete
NCR-MER-019	Missing inspection stamp — MER-3115	Yes	None	2025-10-14	Complete
NCR-MER-020	Cure cycle deviation — MER-3102	Yes	None	2026-08-03	Complete
NCR-MER-021	Heat lot mismatch on CoC — MER-3107	Yes	None	2026-07-30	Complete
NCR-MER-022	Wrong revision program run — MER-3112	Yes	None	2026-06-30	Complete
NCR-MER-023	Hardness below spec after heat treat — MER-3104	Yes	None	2025-12-05	Complete
NCR-MER-024	Porosity at FPI — MER-3105	Yes	None	2026-06-05	Complete
NCR-MER-025	Edge distance violation — MER-3112	Yes	None	2026-05-18	Complete
NCR-MER-026	Edge distance violation — MER-3117	Yes	None	2026-05-21	Complete
NCR-MER-027	Cure cycle deviation — MER-3110	Yes	None	2026-03-20	Complete
NCR-MER-028	Porosity at FPI — MER-3109	Yes	None	2026-03-29	Complete
NCR-MER-029	Missing inspection stamp — MER-3103	Yes	None	2026-07-11	Complete
NCR-MER-030	Porosity at FPI — MER-3102	Yes	None	2026-01-06	Complete
NCR-MER-031	Wrong revision program run — MER-3110	Yes	None	2026-01-12	Complete
NCR-MER-032	Cure cycle deviation — MER-3112	Yes	None	2025-10-24	Complete
NCR-MER-033	Surface finish Ra out of spec — MER-3117	Yes	None	2026-02-18	Complete
NCR-MER-034	Cure cycle deviation — MER-3102	Yes	None	2025-12-24	Complete
NCR-MER-035	Delamination — MER-3109	Yes	None	2025-11-15	Complete
NCR-MER-036	Delamination — MER-3108	Yes	None	2026-01-04	Complete
NCR-MER-037	Delamination — MER-3110	Yes	None	2025-10-23	Complete
NCR-MER-038	Edge distance violation — MER-3116	Yes	None	2026-06-29	Complete
NCR-MER-039	Bore oversize — MER-3113	Yes	None	2026-06-06	Complete

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NCR-MER-040	Porosity at FPI — MER-3116	Yes	None	2026-04-06	Complete
NCR-MER-041	Bore oversize — MER-3107	Yes	None	2026-04-01	Complete
NCR-MER-042	Bore oversize — MER-3109	Yes	None	2025-12-06	Complete
NCR-MER-043	Delamination — MER-3103	Yes	None	2026-06-25	Complete
NCR-MER-044	Porosity at FPI — MER-3113	Yes	None	2026-05-17	Complete
NCR-MER-045	Porosity at FPI — MER-3118	Yes	None	2025-12-25	Complete
NCR-MER-046	Delamination — MER-3108	Yes	None	2026-06-08	Complete
NCR-MER-047	Surface finish Ra out of spec — MER-3103	Yes	None	2025-11-27	Complete
NCR-MER-048	Wrong revision program run — MER-3115	Yes	None	2026-03-28	Complete
NCR-MER-049	Bore oversize — MER-3113	Yes	None	2026-04-22	Complete
NCR-MER-050	Bore oversize — MER-3103	Yes	None	2025-11-12	Complete
NCR-MER-051	Wrong revision program run — MER-3101	Yes	None	2025-11-01	Complete
NCR-MER-052	Missing inspection stamp — MER-3110	Yes	None	2025-12-27	Complete
NCR-MER-053	Delamination — MER-3107	Yes	None	2025-12-03	Complete
NCR-MER-054	Surface finish Ra out of spec — MER-3111	Yes	None	2026-05-31	Complete
NCR-MER-055	Bore oversize — MER-3113	Yes	None	2025-12-25	Complete
NCR-MER-056	Porosity at FPI — MER-3103	Yes	None	2026-06-10	Complete
NCR-MER-057	Porosity at FPI — MER-3102	Yes	None	2026-03-27	Complete
NCR-MER-058	Delamination — MER-3101	Yes	None	2026-02-09	Complete
NCR-MER-059	Bore oversize — MER-3115	Yes	None	2026-08-19	Complete
NCR-MER-060	Bore oversize — MER-3114	Yes	None	2026-07-27	Complete
NCR-MER-061	Missing inspection stamp — MER-3101	Yes	None	2025-12-05	Complete
NCR-MER-062	Heat lot mismatch on CoC — MER-3113	Yes	None	2026-09-06	Complete
NCR-MER-063	Bore oversize — MER-3110	Yes	None	2026-05-19	Complete
NCR-MER-064	Bore oversize — MER-3110	Yes	None	2025-10-11	Complete
NCR-MER-065	Cure cycle deviation — MER-3112	Yes	None	2026-04-26	Complete
NCR-MER-066	Porosity at FPI — MER-3104	Yes	None	2025-11-03	Complete
NCR-MER-067	Wrong revision program run — MER-3114	Yes	None	2026-06-16	Complete
NCR-MER-068	Heat lot mismatch on CoC — MER-3108	Yes	None	2026-06-08	Complete
NCR-MER-069	Missing inspection stamp — MER-3117	Yes	None	2026-03-21	Complete
NCR-MER-070	Bore oversize — MER-3118	Yes	None	2026-01-11	Complete
NCR-MER-071	Edge distance violation — MER-3106	Yes	None	2026-08-03	Complete
NCR-MER-072	Wrong revision program run — MER-3113	Yes	None	2026-01-10	Complete
NCR-MER-073	Porosity at FPI — MER-3111	Yes	None	2026-07-28	Complete
NCR-MER-074	Porosity at FPI — MER-3116	Yes	None	2026-03-14	Complete

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NCR	Nonconformance	Contained	Zones outstanding	Deadline	Status
NCR-MER-075	Hardness below spec after heat treat — MER-3115	Yes	None	2026-08-02	Complete
NCR-MER-076	Wrong revision program run — MER-3103	Yes	None	2026-07-14	Complete
NCR-MER-077	Edge distance violation — MER-3106	Yes	None	2026-05-17	Complete
NCR-MER-078	Wrong revision program run — MER-3114	Yes	None	2026-08-26	Complete
NCR-MER-079	Bore oversize — MER-3117	Yes	None	2026-01-09	Complete
NCR-MER-080	Porosity at FPI — MER-3105	Yes	None	2026-05-17	Complete
NCR-MER-201	Ti-6Al-4V forging inclusion — wrong heat lot traceability	Yes	None	2026-03-09	Complete
NCR-MER-202	Pyrometry gap — 6-month hole in heat treat furnace #3 records	Yes	None	2026-03-09	Complete
NCR-MER-203	A320neo nacelle bracket OTD failure — 4 consecutive months <60%	Yes	None	2026-03-09	Complete
NCR-MER-204	NDT FPI false-call rate 14% on aluminum wing skins	Yes	None	2026-03-09	Complete
NCR-MER-205	Composite layup cure cycle deviation — 3 autoclave batches out of spec	Yes	None	2026-03-09	Complete
NCR-MER-206	CNC program revision control — obsolete G-code run on 5-axis center	Yes	None	2026-03-09	Complete
NCR-MER-207	Calibration overdue — 32 assets including CMM and hardness testers	Yes	None	2026-03-09	Complete
NCR-MER-208	Expired operator certifications — 12 machinists and inspectors	Yes	None	2026-03-09	Complete
NCR-MER-209	Boeing rivet spacing nonconformance — fuselage panel lot 26-018	Yes	None	2026-03-09	Complete
NCR-MER-210	Chemical processing tank concentration drift — chromate conversion	Yes	None	2026-03-09	Complete
NCR-MER-211	Supplier raw material CoC discrepancies — 3 titanium lots	Yes	None	2026-03-09	Complete
NCR-MER-212	Prevent recurrence of quality manager vacancy gap	Yes	None	2026-03-09	Complete
NCR-MER-213	FOD control failure in sheet metal shop — debris in assembly	Yes	None	2026-03-09	Complete
NCR-MER-214	GE Aviation engine mount bracket hardness out of spec	Yes	None	2026-03-09	Complete
NCR-MER-215	Prevent audit finding recurrence — establish internal audit cadence	Yes	None	2026-03-09	Complete

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Material Review Board Dispositions

MRB	NCR	Part	Description	Disposition	Qty	Cost	Approver	Board date	Status
MRB-MER-301	NCR-MER-081	MER-3102	Ti-6Al-4V forging — inclusions found at ultrasonic inspection	Scrap	8	$94,000	V. Singh (QD)	2026-08-25	Closed
MRB-MER-302	NCR-MER-082	MER-3101	Nacelle bracket — hardness 28 HRC vs 32-36 HRC spec after heat treat	Rework	12	$38,000	G. Hoffman	2026-08-27	Closed
MRB-MER-303	NCR-MER-083	MER-3103	Wing rib — CNC profile 0.008" out of tolerance on contour	Rework	6	$22,000	J. Reeves	2026-08-29	Closed
MRB-MER-304	NCR-MER-084	MER-3106	Composite panel — porosity >2% in ultrasonic C-scan	Scrap	4	$67,000	S. Petrov	2026-08-31	Closed
MRB-MER-305	NCR-MER-085	MER-3105	Floor beam clip — rivet hole elongation from worn drill bushing	Rework	20	$8,400	MRB Chair	2026-09-03	Closed
MRB-MER-306	NCR-MER-086	MER-3107	Engine mount bracket — Rockwell C hardness 3 points below minimum	Scrap	5	$41,000	V. Singh (QD)	2026-09-05	Closed
MRB-MER-307	NCR-MER-087	MER-3101	Nacelle bracket lot 26-014 — chromate conversion coating blistering	Rework	15	$18,500	P. Gutierrez	2026-09-07	Pending
MRB-MER-308	NCR-MER-088	MER-3108	Cargo door hinge — bore diameter 0.003" oversize	Use as is	3	$1,200	Eng Auth (pending)	2026-09-10	Pending
MRB-MER-309	NCR-MER-089	MER-3102	Fuselage frame — FPI indication at fillet radius	Rework	7	$29,000	M. Okonkwo	2026-09-12	Pending
MRB-MER-310	NCR-MER-090	MER-3110	Flap track fairing — fiber waviness exceeding 5° in ply 3	Scrap	3	$52,000	S. Petrov	2026-09-14	Pending
MRB-MER-311	NCR-MER-091	MER-3104	Pylon fitting — anodize layer thickness below AMS 2468 minimum	Return to vendor	10	$14,000	P. Gutierrez	2026-09-16	Pending
MRB-MER-312	NCR-MER-092	MER-3109	Stringer doubler — wrong aluminum alloy per supplier CoC	Return to vendor	18	$27,000	K. Williams	2026-09-18	Pending
MRB-MER-313	NCR-MER-001	MER-3117	Hardness below spec after heat treat — MER-3117	Use as is	29	$18,000	G. Hoffman	2026-07-01	Closed
MRB-MER-314	NCR-MER-003	MER-3114	Heat lot mismatch on CoC — MER-3114	Rework	3	$38,000	G. Hoffman	2026-01-18	Closed
MRB-MER-315	NCR-MER-006	MER-3102	Bore oversize — MER-3102	Rework	7	$11,000	G. Hoffman	2025-12-05	Closed

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MRB	NCR	Part	Description	Disposition	Qty	Cost	Approver	Board date	Status
MRB-MER-316	NCR-MER-008	MER-3118	Porosity at FPI — MER-3118	Return to vendor	36	$34,000	G. Hoffman	2025-12-18	Closed
MRB-MER-317	NCR-MER-009	MER-3102	Delamination — MER-3102	Return to vendor	7	$21,000	G. Hoffman	2026-04-13	Closed
MRB-MER-318	NCR-MER-011	MER-3115	Wrong revision program run — MER-3115	Return to vendor	21	$31,000	V. Singh (QD)	2026-09-16	Closed
MRB-MER-319	NCR-MER-013	MER-3106	Edge distance violation — MER-3106	Scrap	33	$25,000	V. Singh (QD)	2026-03-20	Closed
MRB-MER-320	NCR-MER-018	MER-3105	Missing inspection stamp — MER-3105	Rework	1	$18,000	G. Hoffman	2025-10-25	Closed
MRB-MER-321	NCR-MER-022	MER-3112	Wrong revision program run — MER-3112	Return to vendor	32	$4,000	V. Singh (QD)	2026-07-02	Closed
MRB-MER-322	NCR-MER-023	MER-3104	Hardness below spec after heat treat — MER-3104	Rework	23	$18,000	G. Hoffman	2025-12-07	Closed
MRB-MER-323	NCR-MER-026	MER-3117	Edge distance violation — MER-3117	Scrap	2	$32,000	V. Singh (QD)	2026-05-23	Closed
MRB-MER-324	NCR-MER-029	MER-3103	Missing inspection stamp — MER-3103	Rework	7	$54,000	V. Singh (QD)	2026-07-13	Closed
MRB-MER-325	NCR-MER-030	MER-3102	Porosity at FPI — MER-3102	Use as is	3	$56,000	V. Singh (QD)	2026-01-08	Closed
MRB-MER-326	NCR-MER-032	MER-3112	Cure cycle deviation — MER-3112	Scrap	3	$52,000	G. Hoffman	2025-10-26	Closed
MRB-MER-327	NCR-MER-035	MER-3109	Delamination — MER-3109	Use as is	17	$15,000	V. Singh (QD)	2025-11-17	Closed
MRB-MER-328	NCR-MER-036	MER-3108	Delamination — MER-3108	Scrap	21	$48,000	G. Hoffman	2026-01-06	Closed
MRB-MER-329	NCR-MER-037	MER-3110	Delamination — MER-3110	Rework	26	$5,000	V. Singh (QD)	2025-10-25	Closed
MRB-MER-330	NCR-MER-039	MER-3113	Bore oversize — MER-3113	Rework	31	$36,000	G. Hoffman	2026-06-08	Closed
MRB-MER-331	NCR-MER-043	MER-3103	Delamination — MER-3103	Rework	24	$25,000	V. Singh (QD)	2026-06-27	Closed
MRB-MER-332	NCR-MER-046	MER-3108	Delamination — MER-3108	Return to vendor	13	$15,000	V. Singh (QD)	2026-06-10	Closed
MRB-MER-333	NCR-MER-049	MER-3113	Bore oversize — MER-3113	Use as is	34	$51,000	G. Hoffman	2026-04-24	Closed
MRB-MER-334	NCR-MER-050	MER-3103	Bore oversize — MER-3103	Rework	5	$15,000	G. Hoffman	2025-11-14	Closed
MRB-MER-335	NCR-MER-051	MER-3101	Wrong revision program run — MER-3101	Return to vendor	28	$60,000	G. Hoffman	2025-11-03	Closed
MRB-MER-336	NCR-MER-052	MER-3110	Missing inspection stamp — MER-3110	Scrap	20	$4,000	G. Hoffman	2025-12-29	Closed

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36 dispositions; recorded cost $1,098,100.

5 dispositions are use-as-is or repair; either needs customer concession where the contract reserves it.

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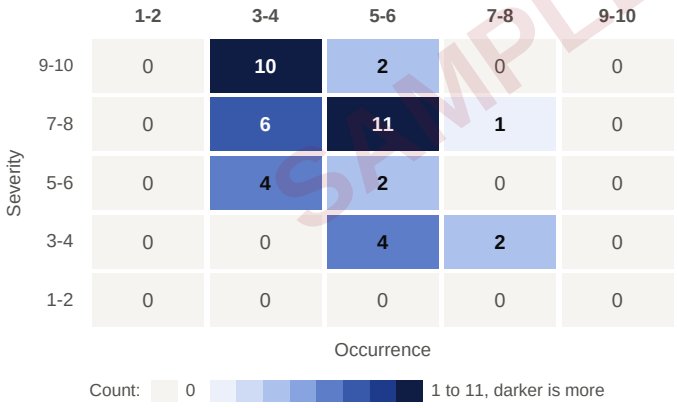
12. Advanced Product Quality Planning (AS9145)

Clause 8.1 — operational planning and control. Failure modes are ranked by Action Priority rather than risk priority number, because multiplying severity, occurrence and detection lets a flight-critical failure share a score with a cosmetic one.

Failure Mode Registers

FMEA	Part / Process	Type	Rev	Modes	High Priority	Status
PFMEA-MER-3101	MER-3101 A320neo Nacelle Bracket Assy machining and heat treat	PFMEA	B	7	4	In Review
PFMEA-MER-3102	MER-3102 737 Fuselage Frame Segment machining and heat treat	PFMEA	B	7	5	In Review
PFMEA-MER-3103	MER-3103 Wing Rib Upper Panel machining and heat treat	PFMEA	B	7	4	Draft
PFMEA-MER-3104	MER-3104 Pylon Attach Fitting machining and heat treat	PFMEA	B	7	4	Draft
PFMEA-MER-3105	MER-3105 Floor Beam Support Clip machining and heat treat	PFMEA	B	7	5	In Review
PFMEA-MER-3106	MER-3106 Composite Trailing Edge Panel machining and heat treat	PFMEA	B	7	5	In Review

Process Failure Modes by Severity and Occurrence



42 process failure modes by severity and occurrence band, from the PFMEA registers. Severity 9-10 is the top row.

42 failure modes; 30 with severity 7 or above; 1 with severity and occurrence both 7 or above.

Control Plans

Plan	Part	Stage	Rev	Characteristics	Status
CP-MER-3101	MER-3101 A320neo Nacelle Bracket Assy	Production	A	5	Draft
CP-MER-3103	MER-3103 Wing Rib Upper Panel	Production	A	5	Draft
CP-MER-3104	MER-3104 Pylon Attach Fitting	Production	A	5	Draft

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Plan	Part	Stage	Rev	Characteristics	Status
CP-MER-3105	MER-3105 Floor Beam Support Clip	Production	A	5	Draft
CP-MER-3106	MER-3106 Composite Trailing Edge Panel	Production	A	5	Draft

Control Plan Flow-Down (AS13100)

Finding: the failure modes below carry a High action priority and no control plan raised from their FMEA names them. A register and a control plan that disagree are two documents, not one control.

FMEA	Part / Process	High-priority modes	Not in a control plan
PFMEA-MER-3101	MER-3101 A320neo Nacelle Bracket Assy machining and heat treat	4	2
PFMEA-MER-3102	MER-3102 737 Fuselage Frame Segment machining and heat treat	5	5
PFMEA-MER-3103	MER-3103 Wing Rib Upper Panel machining and heat treat	4	2
PFMEA-MER-3104	MER-3104 Pylon Attach Fitting machining and heat treat	4	2
PFMEA-MER-3105	MER-3105 Floor Beam Support Clip machining and heat treat	5	2
PFMEA-MER-3106	MER-3106 Composite Trailing Edge Panel machining and heat treat	5	2

Production Part Approval

PPAP	Part	Customer	Level	Elements	Warrant	Status	Required
PPAP-MER-3101	MER-3101 A320neo Nacelle Bracket Assy	Airbus	3	None recorded	In Progress	Draft	2026-10-03
PPAP-MER-3102	MER-3102 737 Fuselage Frame Segment	Boeing	3	None recorded	Not Started	Draft	2026-09-11
PPAP-MER-3103	MER-3103 Wing Rib Upper Panel	Boeing	3	None recorded	In Progress	Draft	2026-09-13
PPAP-MER-3104	MER-3104 Pylon Attach Fitting	Airbus	3	None recorded	Not Started	Draft	2026-09-04
PPAP-MER-3105	MER-3105 Floor Beam Support Clip	Boeing	3	None recorded	In Progress	Submitted	2026-10-27
PPAP-MER-3106	MER-3106 Composite Trailing Edge Panel	Spirit AeroSystems	3	None recorded	In Progress	Draft	2026-11-18

Open item: 6 submissions have no signed Part Submission Warrant. Until the warrant is signed nobody has attested that the required elements are complete.

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13. Process Capability and Measurement Systems

Clauses 9.1.1 and 7.1.5.2. Capability indices are derived from the recorded measurements, and control limits are computed from the process rather than the drawing tolerance. Cpk uses the within-subgroup spread and Ppk the overall spread, so a gap between them means the process is capable but not being held.

Capability Studies

Study	Part	Characteristic	Spec	Cpk	Ppk	Chart	Gauge
SPC-3101-BORE	MER-3101	Bore diameter	12.687 - 12.713 mm	6.24	1.09	X-bar R	BG-14
SPC-3104-BORE	MER-3104	Bore diameter	18.98 - 19.02 mm	1.98	1.92	X-bar R	BG-6601
SPC-3101-FLANGE	MER-3101	Flange thickness	4.95 - 5.05 mm	2.05	1.96	X-bar R	MIC-7015
SPC-3108-HINGE	MER-3108	Hinge lug width	24.96 - 25.04 mm	1.66	1.16	X-bar R	CMM-4401
SPC-3107-HARD	MER-3107	Hardness HRC	32.0 - 36.0 HRC	0.81	0.81	X-bar R	HT-2205

1 characteristic shows Cpk materially above Ppk: the process is capable within a subgroup and drifting between them, which is a control problem rather than a capability problem.

Measurement System Analysis

Study	Gauge	Gauge ID	Type	%GR&R	Repeat	Reprod	ndc	Expires
GRR-BG6601	Mitutoyo Bore Gauge	BG-6601	GR&R	5.0%	4.3%	2.5%	28	2027-05-07
GRR-CMM4401	Zeiss Contura CMM	CMM-4401	GR&R	23.9%	19.0%	14.5%	5	2027-05-07
GRR-HT2205	Wilson Rockwell	HT-2205	GR&R	59.0%	48.9%	33.2%	1	2027-05-07

Finding: the capability claims below rest on a measurement system not shown to carry them. Until the gauge is qualified, a Cpk is a statement about the gauge as much as the process; each reason is given.

Characteristic	Part	Cpk	Gauge	Reason
Bore diameter	MER-3101	6.24	BG-14	gauge BG-14 has no Gage R&R study
Flange thickness	MER-3101	2.05	MIC-7015	gauge MIC-7015 has no Gage R&R study
Hardness HRC	MER-3107	0.81	HT-2205	gauge HT-2205 consumes 59.0% of total variation; this study measures the gauge

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Measurements in Doubt (7.1.5.2)

Finding: 3 calibration failures have no completed impact evaluation. Every measurement taken with the affected equipment since its last good calibration remains in doubt, and product accepted on those measurements has not been dispositioned.

Asset	Equipment	Failed	Last good	Measurements in doubt	Evaluation
CAL-MER-121	Bore Gauge 12mm (cell 4)	2026-09-19	2026-01-17	Not yet assessed	Pending evaluation
CAL-MER-02	Wilson Rockwell Hardness Tester	2026-09-21	2026-02-03	Not yet assessed	Pending evaluation
CAL-MER-03	Fluke 1586A Super-DAQ Pyrometer	2026-09-21	2025-11-24	Not yet assessed	Pending evaluation

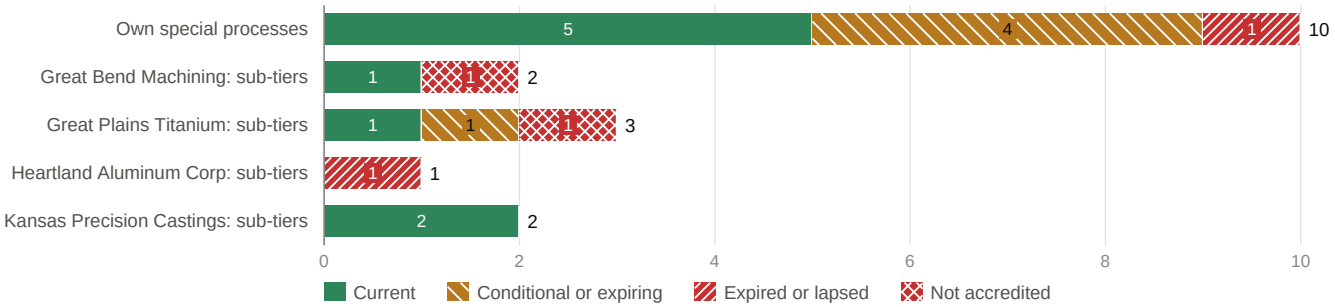
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14. Special Processes, Flow-Down and Traceability

Special Processes (8.5.1.2)



Special processes performed by each supplier's sub-tiers, and the organization's own, by NADCAP or customer approval state, from the sub-tier map and the special-process register.

Own special processes: 5 current, 4 conditional or expiring, 1 expired or lapsed; Great Bend Machining: sub-tiers: 1 current, 1 not accredited; Great Plains Titanium: sub-tiers: 1 current, 1 conditional or expiring, 1 not accredited; Heartland Aluminum Corp: sub-tiers: 1 expired or lapsed; Kansas Precision Castings: sub-tiers: 2 current. 4 without a current approval.

Process	Specification	Certification body	NADCAP	Status	Expires	Audit findings
SP-MER-01 Heat Treat — Solution & Age (Ti-6Al-4V)	AMS 2801 / AMS 2750F	PRI	Conditional	Conditional	2026-11-29	3 Major: pyrometry records gap, furnace survey overdue, load thermocouple deviation
SP-MER-02 Heat Treat — Stress Relief (Aluminum)	AMS 2770 / AMS 2750F	PRI	Conditional	Conditional	2026-11-29	1 Major: pyrometry gap shared with SP-MER-01
SP-MER-03 NDT — Fluorescent Penetrant Inspection	ASTM E1417 / ASTM E2297	PRI	Current	Active	2027-03-06	2 Minor: operator qualification records, light meter calibration
SP-MER-04 NDT — Ultrasonic Testing	ASTM E2375 / AMS 2630	PRI	Current	Active	2027-02-13	1 Minor: reference standard traceability
SP-MER-05 NDT — Radiographic Inspection	ASTM E2104 / ASTM E1742	PRI	Expired	Expired	2026-09-14	2 Major: film density control, IQI selection documentation
SP-MER-06 Chemical Processing — Chromate Conversion	MIL-DTL-5541 / AMS 2473	PRI	Conditional	Conditional	2026-12-25	1 Major: tank concentration out-of-spec
SP-MER-07 Chemical Processing — Sulfuric Acid Anodize	MIL-A-8625 / AMS 2468	PRI	Current	Active	2027-04-01	1 Minor: rinse water conductivity
SP-MER-08 Shot Peening	AMS 2430 / AMS-S-13165	Customer Approved	N/A (customer approved)	Active	2027-04-17	No findings
SP-MER-09 Composite Autoclave Cure	Customer Spec + ASTM D5528	Customer Approved	N/A (customer approved)	Conditional	2026-12-14	1 Major: thermocouple array calibration overdue
SP-MER-10 Welding — GTAW Structural	AWS D17.1	Customer Approved	N/A (customer approved)	Active	2027-06-06	No findings

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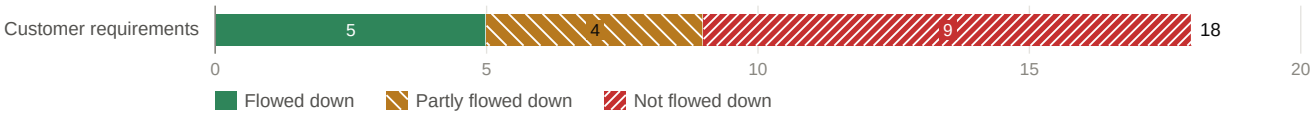
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Open item: 1 special process is performed without a current approval.

Customer Requirement Flow-Down (8.4.3)

18 customer requirements in scope: 5 flowed down to their supplier or in place in their process, 4 only partly, 9 not flowed down.



Accepted customer requirements by whether they reached the supplier or the process they apply to, from the flow-down register.

18 customer requirements: 5 flowed down, 4 only partly, 9 not flowed down.

Finding: the requirements below are not recorded as flowed to the supplier, or in place in the process, they apply to, so nothing on record shows they are being met.

Requirement	Customer	Requirement text	Flowed to	Gap
FLD-MER-01	Boeing D6-82479	Counterfeit part prevention & traceability — AS9100D 8.4.3	Supplier: Great Plains Titanium	No counterfeit prevention clause in PO to supplier
FLD-MER-02	Boeing D6-82479	Material identification & heat lot traceability — AS9100D 8.5.2	Process: Receiving Inspection	Checklist does not include heat lot cross-reference step
FLD-MER-03	Airbus AIMS 09-00-002	Process control for special processes (heat treat) — AS9100D 8.5.1	Process: Heat Treat	Pyrometry procedure obsolete; no valid control document
FLD-MER-04	Airbus AIMS 04-04-011	Measurement system analysis for key characteristics — AS9100D 7.1.5.1	Process: Inspection	No MSA studies on file for nacelle bracket KC dimensions
FLD-MER-05	GE Aviation P11TF12	Product acceptance — hardness verification per AMS 6415 — AS9100D 8.6	Process: Heat Treat + Inspection	Hardness tester overdue on calibration (CAL-MER-02)
FLD-MER-11	Airbus AP2190	Key characteristic flowdown — AS9100D 8.4.3	Supplier: Titan Bar & Billet	Key characteristics not identified on POs to Titan Bar & Billet
FLD-MER-12	Airbus AP2190	Airbus FAI per AS9102 for all new parts — AS9100D 8.5.1	Process: FAI	FAI procedure does not require AS9102 FAI for every new Airbus part
FLD-MER-13	Spirit SQ-1000	Right of access for customer and regulator — AS9100D 8.4.3	Supplier: Great Bend Machining	Right-of-access clause missing from POs to Great Bend Machining
FLD-MER-15	GE S-1000	Special process sources must be GE-approved — AS9100D 8.4.3	Supplier: Emporia Anodizing Co	Emporia Anodizing Co not on GE's approved special-process source list

Only partly flowed down: started and not complete. These are not counted as flowed down.

Requirement	Customer	Requirement text	Partly flowed to	Gap
FLD-MER-09	Airbus AIMS 09-00-002	NADCAP heat treatment checklist compliance — NADCAP AC7102	Process: Heat Treat	Self-audit conducted but 3 checklist items non-compliant
FLD-MER-10	GE Aviation P11TF12	Operator competency requirements for special processes — AS9100D 7.2	Process: All special processes	12 expired certs not identified until post-vacancy review

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Requirement	Customer	Requirement text	Partly flowed to	Gap
FLD-MER-16	Boeing D6-82479	Counterfeit prevention for distributors — AS9100D 8.1.4	Supplier: Aero Fastener Brokers	Not stated in the register
FLD-MER-18	Airbus AP2190	Gauge calibration traceable to national standards — AS9100D 7.1.5	Process: Calibration	Not stated in the register

Traceability and Counterfeit Prevention (8.5.2, 8.1.4)

40 certificates of conformity on record for this scope: 11 flagged, 29 verified.

Finding: 11 lots do not have a valid certificate of conformity. Material without traceable certification is suspect until proven otherwise (8.1.4).

Record	Supplier	Lot / heat	What was found
TRC-MER-01	Great Plains Titanium	LOT-26-009 / H-GP-7741	Missing — heat lot mismatch
TRC-MER-02	Great Plains Titanium	LOT-26-011 / H-GP-7742	Missing — CoC references wrong heat
TRC-MER-03	Great Plains Titanium	LOT-26-014 / H-GP-7745	Missing — no mill test report attached
TRC-MER-05	Prairie Composites LLC	LOT-26-018 / Batch-PC-441	Pending — shelf life verification
TRC-MER-15	Sunflower Packaging & Kitting	LOT-26-115 / H-4414	Missing — CoC not received
TRC-MER-19	Lawrence Wire & Harness	LOT-26-119 / H-2597	Missing — CoC not received
TRC-MER-22	Emporia Anodizing Co	LOT-26-122 / H-3780	Missing — CoC not received
TRC-MER-25	Prairie Composites LLC	LOT-26-125 / H-6314	Missing — CoC not received
TRC-MER-35	Aero Fastener Brokers	LOT-26-135 / H-4057	Missing — CoC not received
TRC-MER-36	Dodge City Freight Services	LOT-26-136 / H-2219	Missing — CoC not received
TRC-MER-38	Great Bend Machining	LOT-26-138 / H-6800	Missing — CoC not received

Counterfeit and Suspect-Part Cases



Counterfeit and suspect-part cases by stage, from the traceability register. Open stages are hatched.

3 counterfeit or suspect-part cases, 3 open: investigation 1, quarantine 1, reporting 1.

Finding: 3 counterfeit part cases are recorded against this scope.

Case	Part	Supplier	Stage	What was found
CF-MER-001	MS21042-3	Aero Fastener Brokers	Quarantine	Head marking inconsistent with OEM
CF-MER-002	NAS1149F0363P	Aero Fastener Brokers	Investigation	CoC from unlisted distributor
CF-MER-003	AMS 4928 bar	Great Plains Titanium	Reporting	Heat lot genealogy cannot be established

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15. Ownership, Actions and Management Review

Clauses 5.3, 9.3 and 10.2. An auditor asking who is accountable for a clause is asking for the RACI; asking what is being done about a finding is asking for the action register.

Assigned Ownership (5.3)

1 RACI matrix defines accountability for the processes in scope.

Open Actions (10.2)

Action	Owner	Due	Priority	Status
[ACT-MER-001] Establish daily recovery war room — 7 AM standup with all lane owners	Recovery Lead	2026-09-26	High	In Progress
[ACT-MER-005] Escalate titanium traceability issue to Boeing SQR — request containment guidance	R. Vasquez	2026-09-26	Critical	Not Started
[ACT-MER-004] Quarantine all product accepted with overdue calibration instruments	M. Okonkwo	2026-09-27	High	In Progress
[ACT-MER-002] Complete CAPA triage — rank all 24 open CAPAs by risk score and customer impact	V. Singh (QD)	2026-09-28	High	Not Started
[ACT-MER-013] Schedule Boeing and Airbus weekly recovery briefing cadence	T. Nakamura	2026-09-28	Medium	In Progress
[ACT-MER-003] Mobilize emergency calibration vendor — prioritize CMM, hardness tester, pyrometer	L. Tran	2026-09-29	High	Not Started
[ACT-MER-012] Build KPI scorecard baseline in Aegis AeroAssure® — establish truth dashboard	Recovery Lead	2026-09-29	Medium	Not Started
[ACT-MER-014] Escalate NADCAP radiographic inspection expiry — identify interim outsource capacity	M. Okonkwo	2026-09-29	Critical	Not Started
[ACT-MER-009] Escalate Airbus OTD recovery plan — request Level 3 review extension	T. Nakamura	2026-09-30	Critical	Not Started
[ACT-MER-007] Launch accelerated requalification program for 12 expired operator certifications	D. Kowalski	2026-10-02	High	Not Started
[ACT-MER-015] Map all open NCRs to root CAPAs and verify containment status	A. Chen	2026-10-02	Medium	Not Started
[ACT-MER-008] Prepare CB surveillance audit gap analysis — identify top 10 nonconformance risks	V. Singh (QD)	2026-10-04	High	Not Started
[ACT-MER-010] Establish pyrometry record restoration for Furnace #3 — 6-month gap closure	G. Hoffman	2026-10-06	High	Not Started

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Quality Objectives (9.1.1)

1 scorecard tracks quality objectives against target.

Management Review (9.3)

Review	Date	Stage	Status
Quarterly business review	2026-10-03	Pre read	-

Management review records in the document register:

Document	Title	Type	Status
DOC-MER-034	RPT-220 Management Review Minutes	Record	Approved

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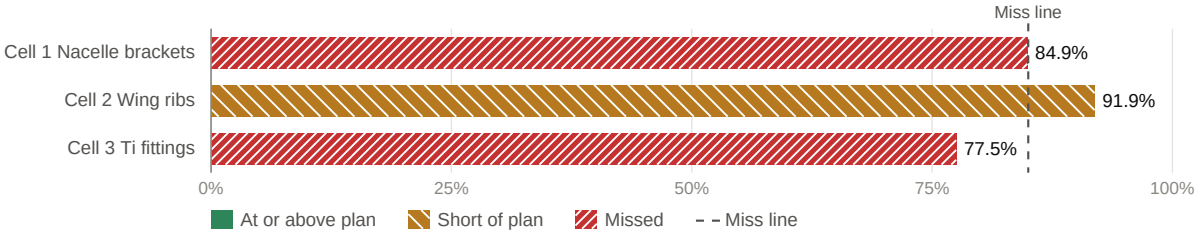
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16. Operations: The Floor, Material Review and the Supply Base

The Floor, Hour by Hour

30 hour-by-hour boards: 1985 made against a plan of 2320 for the hours recorded (85.6% attainment); 126 hours missed and 49 escalations.



Actual as a share of plan for the hours recorded, every shift. Dashed: the miss line.

Attainment to plan: Cell 1 Nacelle brackets 84.9%, Cell 2 Wing ribs 91.9%, Cell 3 Ti fittings 77.5%.

Cell	09-21	09-22	09-23	09-24	09-25	Week	No reason written	Missed twice running
Cell 1 Nacelle brackets	84%	84%	91%	82%	83%	84.9%	6	10
Cell 2 Wing ribs	89%	93%	94%	90%	93%	91.9%	5	2
Cell 3 Ti fittings	79%	72%	83%	76%	77%	77.5%	14	12

Every escalation, by hour, is on the Floor board page and in the Audit Defense Pack's 13_Operations workbook; 49 escalations this period.

Shift Handover: Issues Still Open

Cell	Logged	Shift	Type	Issue	Assigned to	Days open
Cell 3 Ti fittings	2026-09-22	1st	quality	Two MER-3102 forgings back from Wichita Heat Treating at 29 HRC; quarantined and MRB requested	Quality engineering	37
Cell 1 Nacelle brackets	2026-09-23	2nd	equipment	HMC-02 spindle alarm three times this shift; running at reduced feed	Maintenance	36
Cell 2 Wing ribs	2026-09-24	1st	material	Heartland plate lot 44718 short 6 sheets; Tuesday's ribs moved to Thursday	Purchasing	35
Cell 1 Nacelle brackets	2026-09-25	1st	quality	Bore gauge BG-14 read 0.004 mm high against the master; parts since 06:00 on hold for re-measure	Metrology	34

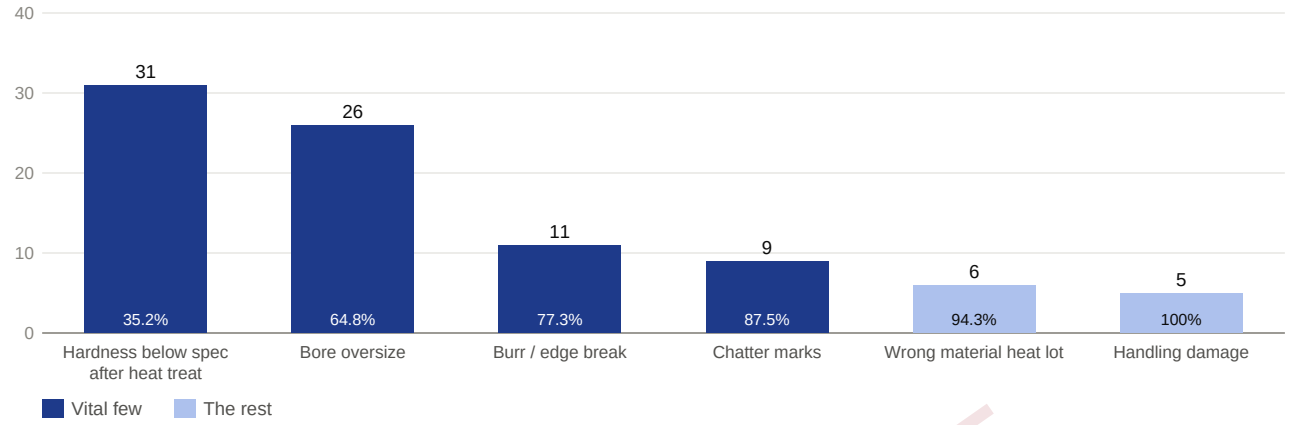
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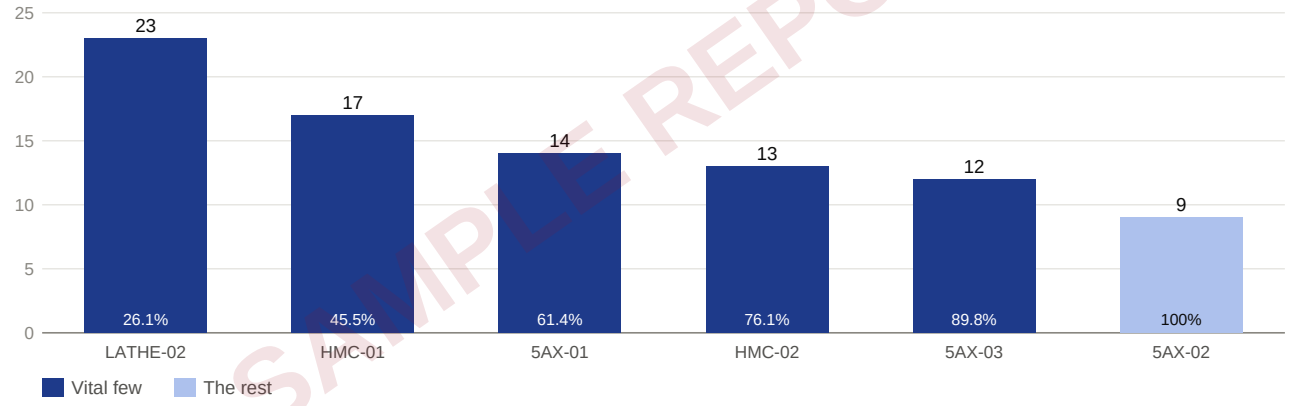
Where the Scrap Comes From

88 parts scrapped over 46 entries. 4 of 6 reasons make up 87.5%: Hardness below spec after heat treat (31), Bore oversize (26), Burr / edge break (11), Chatter marks (9).



88 parts scrapped, by reason. Dark bars are the vital few (together 80%); the percentage in each bar is the cumulative share, largest first.

88 parts scrapped, by reason: 4 of 6 account for 87.5%: Hardness below spec after heat treat (31), Bore oversize (26), Burr / edge break (11), Chatter marks (9).



88 parts scrapped, by machine. Dark bars are the vital few (together 80%); the percentage in each bar is the cumulative share, largest first.

88 parts scrapped, by machine: 5 of 6 account for 89.8%: LATHE-02 (23), HMC-01 (17), 5AX-01 (14), HMC-02 (13), 5AX-03 (12).

Reason	Parts	Share	Cumulative	By machine
Hardness below spec after heat treat	31	35.2%	35.2%	HMC-02 8, HMC-01 7, 5AX-01 6, LATHE-02 6, 5AX-02 4
Bore oversize	26	29.5%	64.8%	HMC-01 7, LATHE-02 7, 5AX-03 6, 5AX-01 4, 5AX-02 2
Burr / edge break	11	12.5%	77.3%	LATHE-02 6, HMC-02 3, 5AX-03 2
Chatter marks	9	10.2%	87.5%	LATHE-02 4, 5AX-02 2, HMC-01 2, 5AX-03 1
Wrong material heat lot	6	6.8%	94.3%	5AX-03 3, 5AX-01 2, 5AX-02 1
Handling damage	5	5.7%	100%	5AX-01 2, HMC-02 2, HMC-01 1

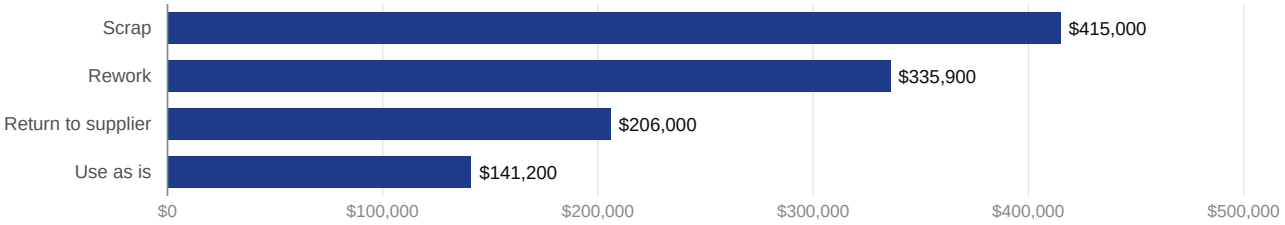
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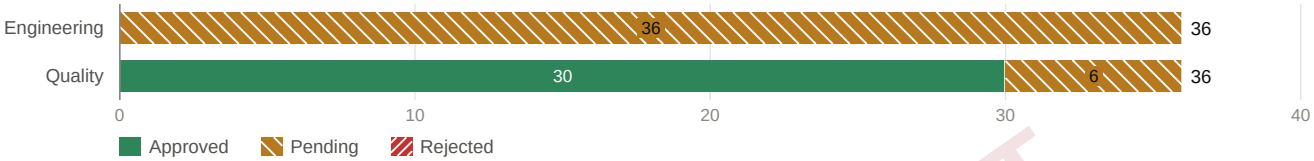
MRB: Cost and Approvals

36 dispositions with $1,098,100 of cost impact recorded; 6 awaiting a board decision.



Cost impact recorded on the dispositions, by disposition.

MRB cost impact $1,098,100: Scrap $415,000, Rework $335,900, Return to supplier $206,000, Use as is $141,200.



Dispositions by reviewer and decision. Customer counts only dispositions that need it.

MRB approvals: Engineering 0 approved, 36 pending, 0 rejected; Quality 30 approved, 6 pending, 0 rejected.

Disposition	Part	Type	Qty	Cost impact	Eng	Quality	Customer
NCR-MER-087	MER-3101	Rework	15	$18,500	pending	pending	n/a
NCR-MER-088	MER-3108	Use as is	3	$1,200	pending	pending	n/a
NCR-MER-089	MER-3102	Rework	7	$29,000	pending	pending	n/a
NCR-MER-090	MER-3110	Scrap	3	$52,000	pending	pending	n/a
NCR-MER-091	MER-3104	Return to supplier	10	$14,000	pending	pending	n/a
NCR-MER-092	MER-3109	Return to supplier	18	$27,000	pending	pending	n/a

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Supplier Onboarding



Supplier intakes by stage, from link sent to decision.

3 supplier intakes: 1 invited, 0 in progress, 1 submitted, 1 approved, 0 rejected.

Supplier	Stage	Red flags found	Decided by
Sunflower NDT Services	approved	None	V. Singh (QD)
Kansas Precision Plating	submitted	Special process 'chemical processing' offered without NADCAP accreditation for it; Special process 'coatings' offered without NADCAP accreditation for it; 1 root-cause analyses not closed: CAR-221; MER-3106: 40 good + 4 scrapped exceeds the 40 issued; Stated on-time delivery 98% but the imported data shows 50%	
Salina Anodize & Plate	invited	None	

Sub-Tier Special Processes (NADCAP)

The accreditation of every sub-tier special process is charted in Section 14, beside the organization's own.

Supplier	Sub-tier	Process	Status	Certificate	Expires
Great Bend Machining	Plains Surface Technologies	coatings	Not accredited	—	—
Great Plains Titanium	Central NDT Services	nondestructive testing	Expiring	NAD-NDT-11042	2026-10-15
Great Plains Titanium	Wichita Heat Treating Inc	nondestructive testing	Not accredited	—	—
Heartland Aluminum Corp	Flint Chemical Processing	chemical processing	Expired	NAD-CP-30911	2026-08-31

SAMPLE REPORT

17. Data Completeness

Complete. Every register supplied for this report was read in full; no section is blank because records could not be read.

Every figure in this pack is drawn from the registers and records your organization supplied, as they stood when the pack was generated. A section with nothing to report says so in words.

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18. Appendices

A. Controlled Document List

Doc ID	Title	Type	Revision	Status	Owner
DOC-MER-001	QMS-001 Quality Management System Manual	Procedure	Rev 8	Approved	V. Singh (QD)
DOC-MER-002	HT-100 Heat Treat Operation — Titanium Alloys	Work instruction	Rev 4	Under review	G. Hoffman
DOC-MER-003	PYR-200 Pyrometry Control per AMS 2750F	Procedure	Rev 3	Obsolete	G. Hoffman
DOC-MER-004	RI-300 Receiving Inspection — Raw Material	Work instruction	Rev 6	Under review	K. Williams
DOC-MER-005	NDT-400 FPI Process Instruction per ASTM E1417	Work instruction	Rev 5	Approved	M. Okonkwo
DOC-MER-006	CAL-500 Calibration Control Procedure	Procedure	Rev 7	Under review	L. Tran
DOC-MER-007	MRB-600 Material Review Board Charter & Procedure	Procedure	Rev 3	Approved	V. Singh (QD)
DOC-MER-008	TRN-700 Training Qualification & Records Management	Procedure	Rev 2	Obsolete	D. Kowalski
DOC-MER-009	CNC-800 CNC Program Control & Verification	Work instruction	Rev 4	Under review	J. Reeves
DOC-MER-010	FAI-900 First Article Inspection Procedure per AS9102	Procedure	Rev 5	Approved	A. Chen
DOC-MER-011	FRM-101 Nonconformance Report Form	Form	Rev 6	Approved	V. Singh (QD)
DOC-MER-012	RPT-201 Monthly Quality Performance Report	Record	Rev 3	Under review	Recovery Lead
DOC-MER-013	QP-4.1 Context and Interested Parties	Procedure	Rev 4	Approved	G. Hoffman
DOC-MER-014	QP-5.3 Roles and Authorities	Procedure	Rev 9	Approved	V. Singh (QD)
DOC-MER-015	QP-6.1 Risk Management	Procedure	Rev 4	Approved	G. Hoffman
DOC-MER-016	QP-7.1.5 Monitoring and Measuring Resources	Procedure	Rev 2	Approved	D. Reyes
DOC-MER-017	QP-7.2 Competence	Procedure	Rev 7	Approved	S. Brooks
DOC-MER-018	QP-7.5 Control of Documented Information	Procedure	Rev 2	Approved	K. Osei
DOC-MER-019	QP-8.1.4 Counterfeit Parts Prevention	Procedure	Rev 4	Approved	K. Osei
DOC-MER-020	QP-8.4 Control of External Providers	Procedure	Rev 4	Under review	T. Nakamura
DOC-MER-021	QP-8.5.2 Identification and Traceability	Procedure	Rev 6	Approved	D. Reyes
DOC-MER-022	QP-8.5.6 Control of Changes	Procedure	Rev 4	Approved	M. Alvarez
DOC-MER-023	QP-8.7 Control of Nonconforming Output	Procedure	Rev 5	Approved	D. Reyes
DOC-MER-024	QP-9.1.2 Customer Satisfaction	Procedure	Rev 5	Approved	S. Brooks
DOC-MER-025	QP-9.2 Internal Audit	Procedure	Rev 2	Approved	G. Hoffman
DOC-MER-026	QP-9.3 Management Review	Procedure	Rev 3	Approved	G. Hoffman
DOC-MER-027	QP-10.2 Nonconformity and Corrective Action	Procedure	Rev 2	Approved	D. Reyes
DOC-MER-028	WI-CNC-810 Tool Life Management	Work instruction	Rev 2	Under review	L. Tran
DOC-MER-029	WI-SM-120 Drill and Rivet	Work instruction	Rev 9	Approved	T. Nakamura
DOC-MER-030	WI-COMP-330 Layup and Bagging	Work instruction	Rev 8	Approved	G. Hoffman

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Doc ID	Title	Type	Revision	Status	Owner
DOC-MER-031	FRM-201 Supplier Scorecard	Form	Rev 2	Approved	M. Alvarez
DOC-MER-032	FRM-305 Calibration Recall Notice	Form	Rev 4	Approved	G. Hoffman
DOC-MER-033	FRM-410 FAI Report Forms 1-3	Form	Rev 4	Approved	L. Tran
DOC-MER-034	RPT-220 Management Review Minutes	Record	Rev 2	Approved	T. Nakamura
DOC-MER-035	WI-NDT-420 UT Inspection	Work instruction	Rev 3	Approved	G. Hoffman
DOC-MER-036	WI-HT-110 Furnace Load Thermocouples	Work instruction	Rev 5	Approved	R. Vasquez
DOC-MER-037	QP-8.3 Design Control (N/A statement)	Procedure	Rev 7	Approved	R. Vasquez
DOC-MER-038	QP-8.5.1.3 Production Process Verification	Procedure	Rev 3	Approved	D. Reyes
DOC-MER-039	QP-7.1.4 Work Environment and FOD	Procedure	Rev 6	Approved	P. Green
DOC-MER-040	FRM-150 Deviation Request	Form	Rev 2	Approved	L. Tran

B. Acronyms & Definitions

Acronym	Definition
AS9100	Quality Management Systems - Requirements for Aviation, Space and Defense Organizations
CAPA	Corrective and Preventive Action
FAI	First Article Inspection
FMEA	Failure Mode and Effects Analysis
GR&R	Gauge Repeatability and Reproducibility
IATF	International Automotive Task Force
ISO	International Organization for Standardization
KPI	Key Performance Indicator
MRB	Material Review Board
MSA	Measurement System Analysis
NCR	Nonconformance Report
NDT	Non-Destructive Testing
OJT	On-the-Job Training
OTD	On-Time Delivery
QBR	Quarterly Business Review
QMS	Quality Management System
RACI	Responsible, Accountable, Consulted, Informed
RCA	Root Cause Analysis
SOP	Standard Operating Procedure

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C. Pack Generation

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D. Your Audit Checklist

119 questions an AS9100D auditor asks about the 17 clauses where your own records show a gap, critical first. Walk each clause with its process owner before the audit: tick a question only when the evidence is in hand, and note where it is kept. The full set of 252 questions is in the ZIP (11_Self_Audit/AS9100D_Self_Audit_Questions.xlsx), with these marked.

Clause 8.4.2: Type and extent of control

What your records showed

What was found	Records	Which
Sub-tier special process without NADCAP accreditation	3	Heartland Aluminum Corp, Great Bend Machining, Great Plains Titanium
Supplier on probation still delivering	5	Great Plains Titanium (SUP-MER-01), Heartland Aluminum Corp (SUP-MER-02), Prairie Composites LLC (SUP-MER-03), Titan Bar & Billet (SUP-MER-12), Emporia Anodizing Co (SUP-MER-17)
Sub-tier NADCAP accreditation expiring	1	Great Plains Titanium
FIND-MER-007 Supplier CoC discrepancies — 3 titanium lots from Great Plains Titanium with formatting errors	-	

	Question	Priority	Evidence location / initials
☐	**QB-8.4.2-002** Are customer and regulatory flow-down requirements included in purchase orders to external providers?	Critical	
☐	**QB-8.4.2-001** Are purchasing requirements adequately defined and communicated to suppliers?	High	
☐	**QB-8.4.2-003** Do purchase orders contain complete and unambiguous technical requirements including revision levels?	High	

	Have ready		
☐	Purchase orders with flow-down quality clauses	☐	Quality clauses in supplier agreements
☐	Flow-down requirements checklist or matrix	☐	Evidence of right-of-access provisions
☐	Sub-tier special process requirements records	☐	Purchase order samples with technical requirements
☐	Right-of-access clause evidence	☐	Drawing/specification revision references in POs
☐	Purchase order samples with requirement flowdown	☐	Special process requirements in POs
☐	Supplier quality requirements document	☐	PO review and approval records

Red flags an auditor looks for	
No flow-down quality clauses in purchase orders	No flowdown of critical requirements to sub-tier suppliers

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Red flags an auditor looks for	
Sub-tier suppliers unaware of prime customer requirements	Purchase orders lack drawing/specification references
Purchase orders contain only part number and quantity	Supplier produced to wrong revision due to PO error

Clause 8.1.4: Prevention of counterfeit parts (AS9100 specific)

What your records showed

What was found	Records	Which
Counterfeit part case open	3	CF-MER-001, CF-MER-002, CF-MER-003

	Question	Priority	Evidence location / initials
☐	**QB-8.1.4-001** Are counterfeit part prevention controls implemented per AS6174/AS6081?	Critical	
☐	**QB-8.1.4-002** Is counterfeit part prevention integrated into the procurement and receiving inspection processes?	Critical	
☐	**QB-8.1.4-003** Are obsolete or surplus electronic components managed to prevent counterfeit parts from entering the supply chain?	Critical	
☐	**QB-8.1.4-004** Is there a process for reporting suspect unapproved parts (SUPs) to the FAA or equivalent authority?	Critical	

	Have ready		
☐	Counterfeit parts prevention procedure	☐	Electronic component sourcing procedure
☐	Approved supplier list with source verification	☐	Authorized distributor list for electronic components
☐	Incoming inspection records for counterfeit detection	☐	Enhanced inspection procedure for non-standard sources
☐	Training records on counterfeit awareness	☐	X-ray or decapsulation testing records for suspect components
☐	Quarantine and disposition records for suspect parts	☐	SUP reporting procedure
☐	GIDEP or equivalent reporting records	☐	SUP investigation records
☐	Approved supplier list specifying authorized distributors	☐	FAA/authority reporting records
☐	Authentication testing procedures and records	☐	GIDEP reporting records for confirmed issues
☐	GIDEP alert monitoring records	☐	Quarantine and disposition records for SUPs
☐	Quarantine records for suspected counterfeit parts		

Red flags an auditor looks for	
Parts purchased from brokers without source verification	GIDEP membership lapsed or alerts ignored
No counterfeit prevention procedure exists	Electronic components purchased from brokers without testing
Suspect parts found but not reported	No counterfeit detection testing capability for electronics
Parts purchased from unapproved sources without additional testing	No SUP reporting procedure despite regulatory requirement
No counterfeit part prevention program exists	SUPs found but not reported to authorities

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Clause 8.5.1.2: Validation and control of special processes

What your records showed

What was found	Records	Which
Special process without current accreditation	1	NDT — Radiographic Inspection

	Question	Priority	Evidence location / initials
☐	**QB-NADCAP-001** Are special processes (welding, heat treat, NDT, surface treatment) validated per NADCAP requirements?	Critical	
☐	**QB-NADCAP-002** Are NDT (Non-Destructive Testing) operations controlled per NAS-410/EN4179 and customer requirements?	Critical	
☐	**QB-NADCAP-003** Are heat treatment processes controlled with continuous monitoring and recording of parameters?	Critical	
☐	**QB-NADCAP-004** Are NDT procedures qualified per applicable specifications and are procedure qualification records maintained?	Critical	
☐	**QB-NADCAP-005** Is the chemical process control (plating, anodizing, passivation) maintained per NADCAP Chemical Processing requirements?	Critical	
☐	**QB-NADCAP-006** Are welding procedures qualified per applicable codes (AWS D17.1, AMS standards) and are welder qualifications current?	Critical	
☐	**QB-NADCAP-007** Is composite material processing controlled per NADCAP requirements including layup, cure, and NDT inspection?	Critical	
☐	**QB-NADCAP-008** Are shot peening and surface enhancement processes controlled per AMS 2430/2432 and NADCAP requirements?	Critical	
☐	**QB-NADCAP-010** Are special process suppliers NADCAP accredited or equivalently qualified for the specific processes they perform?	Critical	
☐	**QB-NADCAP-011** Are NDT operator eye examinations current and do they meet the requirements of NAS 410/EN 4179?	Critical	
☐	**QB-NADCAP-012** Do heat treatment furnace instrumentation systems meet AMS 2750 (pyrometry) requirements?	Critical	
☐	**QB-NADCAP-013** Are NDT sensitivity levels (penetrant, magnetic particle, ultrasonic) verified before each inspection session?	Critical	
☐	**QB-NADCAP-015** Are non-conventional machining processes (EDM, ECM, laser, waterjet) controlled per customer and specification requirements?	Critical	
☐	**QB-NADCAP-009** Are NADCAP audit findings addressed with effective corrective actions and are root causes systemic?	High	
☐	**QB-NADCAP-014** Are coating (paint, primer, sealant) application processes controlled per customer and specification requirements?	High	

	Have ready		
☐	NADCAP accreditation certificate (if applicable)	☐	Almen strip intensity verification records
☐	Process validation records	☐	Coverage verification records
☐	Process parameter monitoring records	☐	Media condition monitoring records
☐	Operator qualification records	☐	Supplier NADCAP accreditation certificates with scope

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	Have ready		
☐	Equipment calibration/validation records	☐	Equivalent qualification records for non-NADCAP suppliers
☐	NDT personnel certification records (NAS-410/EN4179)	☐	Customer approval records for special process suppliers
☐	Level III oversight records	☐	Supplier audit records for special processes
☐	NDT procedure approvals	☐	Annual eye examination records for all NDT personnel
☐	Equipment calibration records	☐	Color vision test results
☐	Sensitivity verification/system performance records	☐	Near-vision acuity test results (Jaeger J1 or equivalent)
☐	AMS2750 pyrometry records	☐	Corrective lens documentation on certification records
☐	Temperature uniformity survey (TUS) reports	☐	AMS 2750 compliance checklist for each furnace
☐	System accuracy test (SAT) records	☐	Instrument type classification records
☐	Thermocouple calibration records	☐	SAT records with pass/fail results
☐	Furnace chart records showing process parameters	☐	TUS records with uniformity data
☐	NDT procedure qualification records	☐	Thermocouple expenditure records (load vs. control)
☐	Reference standard/test piece records and calibration	☐	System performance check records
☐	Procedure qualification review and approval records	☐	Reference standard certification and verification
☐	Customer or prime approval of NDT procedures	☐	Sensitivity verification logs
☐	Solution analysis records and control charts	☐	Out-of-sensitivity response records
☐	Coupon test results per specification	☐	Non-conventional machining process specifications
☐	Chemical process specification compliance matrix	☐	Etch inspection records for EDM/ECM surfaces
☐	Waste treatment and environmental compliance records	☐	Metallographic examination records where required
☐	WPS documentation with supporting PQR	☐	NADCAP audit reports and findings
☐	Welder qualification records with expiration dates	☐	Corrective action responses to NADCAP findings
☐	Weld inspection procedure and inspector qualifications	☐	NADCAP accreditation certificates
☐	Weld parameter monitoring records	☐	Self-audit results (pre-audit preparation)
☐	Weld repair procedure and records	☐	Coating material traceability records
☐	Cure cycle monitoring records (autoclave or oven)	☐	Shelf-life monitoring for coatings and sealants
☐	Material traceability records including shelf-life and out-time	☐	Application parameter monitoring records
☐	Ply layup verification records	☐	Film thickness measurement records
☐	NDT inspection of composite parts (ultrasonic, thermography)	☐	Operator qualification records for coating application
☐	Material qualification test results		

Red flags an auditor looks for	
Special process performed without validation	Coverage requirements not met or not verified
NADCAP accreditation expired	Special processes outsourced to non-accredited, non-qualified suppliers
Operators performing special processes without current qualification	Supplier NADCAP accreditation expired without organization's knowledge
NDT performed by uncertified personnel	NDT operators performing inspections with expired eye exams

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Red flags an auditor looks for	
No Level III available for procedure approval	Color blind NDT operator performing liquid penetrant inspection
TUS failed but furnace continued in operation	Furnace operating with expired TUS or SAT
No pyrometry compliance records	AMS 2750 compliance not maintained
NDT performed with unqualified procedures	Inspections performed without sensitivity verification
Reference standards missing or unverified	Reference standards uncertified or damaged
Solution analysis overdue or control limits exceeded	No etch inspection after EDM on flight-critical parts
No coupon testing for thickness, adhesion, or corrosion resistance	Excessive recast layer without detection or disposition
Welding performed without qualified WPS	NADCAP accreditation lapsed or at risk
Welders performing work outside their qualification range	Same findings recurring at multiple NADCAP audits
Prepreg material used beyond allowable out-time or shelf-life	Expired coating materials used in production
Cure cycle records show deviations with no investigation	Environmental conditions out of specification during coating application
Shot peening performed without intensity verification	

Clause 8.5.1.3: Production process verification

What your records showed

What was found	Records	Which
Part submission warrant unsigned	6	MER-3101 (PPAP-MER-3101), MER-3102 (PPAP-MER-3102), MER-3103 (PPAP-MER-3103), MER-3104 (PPAP-MER-3104), MER-3105 (PPAP-MER-3105), MER-3106 (PPAP-MER-3106)
First article report not signed	15	MER-3101 (FAI-MER-101), MER-3102 (FAI-MER-102), MER-3103 (FAI-MER-103), MER-3106 (FAI-MER-106), MER-3107 (FAI-MER-107), MER-3108 (FAI-MER-108), MER-3110 (FAI-MER-110), MER-3111 (FAI-MER-111), MER-3112 (FAI-MER-112), MER-3113 (FAI-MER-113), MER-3114 (FAI-MER-114), MER-3115 (FAI-MER-115), MER-3116 (FAI-MER-116), MER-3117 (FAI-MER-117), MER-3118 (FAI-MER-118)
Accepted first article report with no signatures on record	3	MER-3104 (FAI-MER-104), MER-3105 (FAI-MER-105), MER-3109 (FAI-MER-109)

	Question	Priority	Evidence location / initials
☐	**QB-AS9102-001** Is First Article Inspection (FAI) performed per AS9102 for new or changed parts?	Critical	
☐	**QB-AS9102-004** Are FAI triggers clearly defined and consistently applied (new part, design change, process change, supplier change, production break)?	Critical	
☐	**QB-AS9102-005** Does the FAI process include verification of all design characteristics including functional, dimensional, and material requirements?	Critical	
☐	**QB-AS9102-015** Are FAI measurement results compared against design tolerances with clear pass/fail determination for each characteristic?	Critical	
☐	**QB-AS9102-002** Are FAI records complete with all required forms and data?	High	
☐	**QB-AS9102-006** Are FAI non-conformances dispositioned and is the FAI re-performed or partially re-performed after corrective action?	High	

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	Question	Priority	Evidence location / initials
☐	**QB-AS9102-007** Are FAI records maintained with traceability to the specific part, tooling, equipment, and operators used?	High	
☐	**QB-AS9102-008** Is the organization managing FAI requirements flow-down to sub-tier suppliers and verifying their FAI completion?	High	
☐	**QB-AS9102-010** Is the FAI Form 1 (Part Number Accountability) complete with all required information including design authority and part revision?	High	
☐	**QB-AS9102-011** Is FAI Form 2 (Raw Material, Special Processes, and Functional Testing) properly completed with actual test results?	High	
☐	**QB-AS9102-012** Are FAI results reviewed and approved by authorized personnel with appropriate technical competence?	High	
☐	**QB-AS9102-013** Is the FAI process integrated with the organization's change management process to ensure FAI is triggered by all applicable changes?	High	
☐	**QB-AS9102-003** Is partial FAI properly used and documented when only some characteristics are affected by a change?	Medium	
☐	**QB-AS9102-009** Is there a process for managing FAI waivers or deviations from the standard FAI process?	Medium	
☐	**QB-AS9102-014** Is FAI status tracked and reported including open FAIs, overdue FAIs, and FAI pass/fail rates?	Medium	

	Have ready		
☐	AS9102 FAI procedure	☐	Sub-tier supplier FAI reports received
☐	Completed FAI forms (Form 1: Part Number Accountability, Form 2: Product Accountability, Form 3: Characteristic Accountability)	☐	Review and acceptance records for sub-tier FAIs
☐	FAI trigger matrix showing when FAI is required	☐	Sub-tier FAI tracking log
☐	Partial FAI records (when applicable)	☐	FAI Form 1 with all fields completed
☐	Sub-tier FAI records or delegation evidence	☐	Cross-reference to sub-assembly FAIs
☐	FAI trigger criteria procedure	☐	Manufacturing process reference in Form 1
☐	FAI tracking log showing trigger reasons	☐	Design authority and revision identification
☐	Production break monitoring records	☐	FAI Form 2 with material data populated
☐	Supplier change notification records triggering FAI	☐	Material certification cross-references
☐	Ballooned drawings with characteristic numbering	☐	Special process certification references
☐	FAI Form 3 with all characteristics measured	☐	Functional test results with actual values
☐	Material certification verification in FAI	☐	FAI approval authority designation
☐	Special process certification verification in FAI	☐	Approver competence/qualification records
☐	FAI Form 3 with design values and actual measurements	☐	Multi-level approval records (if required)
☐	Pass/fail determination for each characteristic	☐	FAI rejection and re-work records
☐	Near-limit analysis for characteristics close to tolerance	☐	Change management procedure referencing FAI requirements
☐	Measurement uncertainty consideration in pass/fail decisions	☐	ECN/ECO forms with FAI impact assessment field
☐	Completed Form 1 with all required fields	☐	FAI trigger evaluation records for recent changes

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	Have ready		
☐	Completed Form 2 with material and process details	☐	Supplier change notifications linked to FAI requirements
☐	Completed Form 3 with actual measured values for all characteristics	☐	Partial FAI records referencing original FAI
☐	Supporting raw data (CMM reports, test results)	☐	Change justification for partial FAI
☐	FAI non-conformance disposition records	☐	Approval records for partial FAI
☐	Corrective action records for FAI failures	☐	FAI waiver/deviation procedure
☐	Re-FAI or partial re-FAI records after corrective action	☐	FAI waiver records with justification
☐	Customer notification of FAI failures if required	☐	Customer approval for FAI deviations
☐	FAI records with part serial/lot number traceability	☐	Risk assessment supporting FAI waivers
☐	Measurement equipment identification in FAI records	☐	FAI tracking dashboard or log
☐	Operator identification in FAI documentation	☐	FAI aging report
☐	Tooling and fixture identification used during FAI production	☐	FAI pass/fail rate metrics
☐	Purchase orders with FAI flow-down requirements	☐	Management review inputs on FAI status

Red flags an auditor looks for	
No FAI process in place	Sub-tier suppliers not performing FAI when required
FAI not re-performed after design changes	Sub-tier FAI reports never reviewed or accepted
Missing characteristics on Form 3	Form 1 incomplete with missing required fields
Production resumed after long break without FAI	Wrong design revision referenced in FAI
No defined production break threshold	Form 2 incomplete or missing sections
Significant number of characteristics missing from FAI	Material data not verified against actual certifications
Material verification not part of FAI process	FAIs approved by unauthorized personnel
FAI approved with characteristics outside tolerance	Complex FAIs approved without engineering review
Actual measurements missing or incorrect on Form 3	Changes made without FAI evaluation
Forms incomplete or missing required data fields	No integration between change management and FAI process
No actual measurements recorded, only pass/fail	Partial FAI used without a valid original complete FAI
FAI approved with out-of-tolerance characteristics and no concession	FAI waivers granted without customer knowledge or approval
FAI failures without corrective action	Blanket FAI waivers without case-by-case evaluation
FAI records lack traceability to the inspected part	Large number of overdue FAIs with no plan to complete
Measurement equipment used during FAI found out of calibration	No FAI tracking or reporting system

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Clause 8.5.2: Identification and traceability

What your records showed

What was found	Records	Which
Customer requirement not flowed down	1	FLD-MER-02 (Boeing) in Receiving Inspection
Lot held at receiving for its certificate of conformity	11	TRC-MER-01 (lot LOT-26-009), TRC-MER-02 (lot LOT-26-011), TRC-MER-03 (lot LOT-26-014), TRC-MER-05 (lot LOT-26-018), TRC-MER-15 (lot LOT-26-115), TRC-MER-19 (lot LOT-26-119), TRC-MER-22 (lot LOT-26-122), TRC-MER-25 (lot LOT-26-125), TRC-MER-35 (lot LOT-26-135), TRC-MER-36 (lot LOT-26-136), TRC-MER-38 (lot LOT-26-138)
FIND-MER-001 Ti-6Al-4V traceability failure — 3 forging lots with incorrect heat lot on CoC	-	

	Question	Priority	Evidence location / initials
☐	**QB-8.5.2-002** Is product identification maintained throughout all stages of production including lot/batch/serial traceability?	Critical	
☐	**QB-8.5.2-004** Is material traceability maintained from raw material receipt through finished product delivery?	Critical	
☐	**QB-8.5.2-001** Is product identification and traceability maintained throughout production?	High	
☐	**QB-8.5.2-003** Is the inspection and test status of product clearly indicated at all stages of production?	High	

	Have ready		
☐	Product identification procedure	☐	Traceability records (lot/batch tracking)
☐	Traceability records linking product to materials and processes	☐	Material certifications linked to product
☐	Marking/labeling specifications	☐	Inspection status marking/identification
☐	Lot/batch/serial number assignment records	☐	Traveler/router with traceability data
☐	Traceability procedure	☐	Inspection status identification procedure
☐	Material traceability records (heat/lot through production)	☐	Status indicators in use (stamps, tags, color codes, locations)
☐	Reverse traceability demonstration records	☐	Work-in-progress staging area controls
☐	Sub-tier traceability requirements	☐	Inspection hold point enforcement records

Red flags an auditor looks for	
Product found without identification in production area	No traceability system for critical materials
Traceability breaks - cannot link product to material certs	Unable to trace product to material source
Cannot trace finished product back to raw material	Product shipped without clear evidence of inspection completion
Traceability breaks at key manufacturing stages	Mandatory hold points bypassed

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Clauses 7.1.5, 7.1.5.1 and 7.1.5.2: Measurement traceability

What your records showed

What was found	Records	Which
Measurements in doubt after a calibration failure	3	Wilson Rockwell Hardness Tester (CAL-MER-02), Fluke 1586A Super-DAQ Pyrometer (CAL-MER-03), Bore Gauge 12mm (cell 4) (CAL-MER-121)
Capability claim resting on an unqualified gauge	3	Hardness HRC on MER-3107 measured with HT-2205, Bore diameter on MER-3101 measured with BG-14, Flange thickness on MER-3101 measured with MIC-7015
Customer requirement not flowed down	1	FLD-MER-04 (Airbus) in Inspection
Measurement system not acceptable	1	HT-2205 (GRR-HT2205)
FIND-MER-004 32 calibration assets overdue — measurement system integrity compromised	-	

	Question	Priority	Evidence location / initials
☐	**QB-7.1.5-001** Are monitoring and measuring resources identified, controlled, and calibrated?	Critical	
☐	**QB-7.1.5-004** Is calibration traceable to national or international standards and are calibration intervals justified?	Critical	
☐	**QB-7.1.5-006** Is there a process for handling calibration recall when equipment is found out of tolerance?	Critical	
☐	**QB-7.1.5-002** Is measurement uncertainty considered for critical measurements?	High	
☐	**QB-7.1.5-003** Are measurement systems analyzed for adequacy using Measurement System Analysis (MSA) techniques?	High	
☐	**QB-7.1.5-005** Are measurement devices suitable for the measurement task in terms of accuracy, resolution, and range?	High	
☐	**QB-7.1.5-007** Are customer-owned or customer-specified measurement devices controlled and calibrated per customer requirements?	High	

	Have ready		
☐	Calibration schedule/register	☐	Gauge R&R study results
☐	Calibration certificates with traceability	☐	Uncertainty budget calculations for critical measurements
☐	Out-of-calibration investigation records	☐	Gage R&R study results for critical gages
☐	Equipment identification labels/stickers	☐	MSA plan identifying which instruments require studies
☐	Recall procedure for OOC equipment	☐	Action records for unacceptable MSA results
☐	Calibration certificates with traceability statements	☐	Measurement uncertainty budgets for critical measurements
☐	Calibration interval justification records	☐	Measurement device selection criteria
☐	Out-of-tolerance notification and impact assessment records	☐	Device capability verification records
☐	Calibration provider accreditation (ISO 17025)	☐	Resolution and accuracy specifications vs. requirements
☐	Out-of-tolerance recall procedure	☐	Customer-specified gage register

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	Have ready		
☐	Impact assessment records for out-of-tolerance findings	☐	Calibration records per customer requirements
☐	Product disposition records for affected measurements	☐	Customer-owned gage identification and tracking
☐	Customer notification records when product is affected	☐	Customer gage maintenance records
☐	Measurement system analysis records		

Red flags an auditor looks for	
Multiple instruments overdue for calibration	No awareness of measurement uncertainty requirements
No process for handling out-of-calibration discoveries	No MSA program exists
Calibration performed by unqualified personnel	Critical measurements made with gages showing >30% R&R
Gages in use past calibration due date	Measurement devices with insufficient resolution for critical dimensions
No impact assessment process for out-of-tolerance findings	No consideration of measurement capability in device selection
Calibration provider lacks accreditation	Customer-specified calibration requirements not followed
No recall process for out-of-tolerance findings	Customer-owned gages lost or damaged without notification
Out-of-tolerance findings with no impact assessment	

SAMPLE REPORT

Clause 8.5.1: Control of production and service provision

What your records showed

What was found	Records	Which
Customer requirement not flowed down	2	FLD-MER-03 (Airbus) in Heat Treat, FLD-MER-12 (Airbus) in FAI
Process not capable of its tolerance	1	Hardness HRC on MER-3107 (SPC-3107-HARD)
FIND-MER-003 Systematic OTD failure — 4 consecutive months below 60% on nacelle bracket program	-	
FIND-MER-011 CNC program revision control failure — obsolete G-code executed on 5-axis center	-	
FIND-MER-006 Rivet spacing nonconformance on fuselage panel lot 26-018 — acceptance criteria not met	-	

	Question	Priority	Evidence location / initials
☐	**QB-8.5.1-009** Are special processes (welding, heat treatment, NDT, surface treatment) controlled per qualified procedures and performed by qualified personnel?	Critical	
☐	**QB-8.5.1-011** Are FOD (Foreign Object Debris/Damage) prevention controls implemented at all stages of production and assembly?	Critical	
☐	**QB-8.5.1-015** Are process validation records maintained for processes whose output cannot be verified by subsequent inspection?	Critical	
☐	**QB-8.5.1-019** Are production hold/stop-work procedures defined and is there authority for any employee to stop production for quality?	Critical	

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	Question	Priority	Evidence location / initials
☐	**QB-8.5.1-001** Are production controls defined, documented, and applied including work instructions at point of use?	High	
☐	**QB-8.5.1-008** Are work instructions available and adequate for all operations that affect product quality?	High	
☐	**QB-8.5.1-010** Are production processes monitored and controlled using statistical methods where applicable?	High	
☐	**QB-8.5.1-012** Are inspection personnel qualified and are inspection methods validated for the types of inspections performed?	High	
☐	**QB-8.5.1-013** Are preventive maintenance programs established for production equipment to prevent unplanned downtime and quality issues?	High	
☐	**QB-8.5.1-014** Are temporary deviations from approved processes documented, approved, and time-limited?	High	
☐	**QB-8.5.1-016** Are controlled production environments (clean rooms, temperature-controlled areas) monitored and alarmed?	High	
☐	**QB-8.5.1-017** Are sampling plans used for inspection statistically valid and documented per appropriate standards (e.g., AS13100, ANSI/ASQ Z1.4)?	High	
☐	**QB-8.5.1-018** Are automated inspection systems (CMM, vision systems, CT scanning) validated and maintained per requirements?	High	
☐	**QB-8.5.1-020** Are temporary repairs on tooling and equipment assessed for impact on product quality?	High	

	Have ready		
☐	Special process qualification records	☐	Process capability (Cpk) trend data
☐	Process parameter monitoring records	☐	Inspector qualification procedure and records
☐	Personnel qualification/certification records	☐	Visual acuity test records
☐	Re-qualification schedule and records	☐	Inspection method validation records
☐	FOD prevention program documentation	☐	Stamp/signature authority register
☐	FOD zone designation records	☐	Preventive maintenance program documentation
☐	Tool accountability records	☐	PM schedule and completion records
☐	Hardware accountability (nut/bolt count) records	☐	Equipment criticality classification
☐	FOD inspection records at assembly close-out	☐	Correlation data between PM and quality performance
☐	FOD incident reporting and investigation records	☐	Temporary deviation/concession procedure
☐	Process validation procedure	☐	Temporary deviation records with approvals and expiry dates
☐	Process validation records	☐	Product traceability for items made under deviations
☐	Re-validation criteria and schedule	☐	Permanent resolution action plans
☐	Process validation review and approval records	☐	Environmental monitoring system records
☐	Stop-work/production hold procedure	☐	Alarm threshold settings documentation
☐	Stop-work authority documentation	☐	Excursion response procedure
☐	Stop-work event records and outcomes	☐	Excursion investigation records
☐	Training records on stop-work authority	☐	Sampling plan documentation referencing standards

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	Have ready		
☐	Work instructions at workstations	☐	AQL selection justification
☐	Process control documents	☐	Customer-approved sampling plans
☐	Equipment setup records	☐	Switching rules application records (normal/tightened/reduced)
☐	Traveler/router documents	☐	Automated inspection system validation records
☐	Work instructions at point of use	☐	System calibration and maintenance records
☐	Revision control on work instructions	☐	Correlation study results (automated vs. manual)
☐	Visual aids for complex operations	☐	Program change control records
☐	Operator acknowledgment of instruction review	☐	Temporary repair assessment and approval records
☐	SPC charts for critical characteristics	☐	Temporary repair expiration tracking
☐	Control chart limit calculation records	☐	Product quality monitoring during temporary repair period
☐	Reaction plan documentation for out-of-control conditions	☐	Permanent repair action plan

Red flags an auditor looks for	
Special process performed without qualification	Inspectors without current qualifications performing inspections
Unqualified personnel performing special processes	No visual acuity testing program
No FOD prevention program in assembly areas	No preventive maintenance program exists
FOD found in delivered products	Critical equipment PM consistently overdue
No tool accountability for open-cavity assembly	Temporary deviations expired but still in use
Critical processes not validated	No formal approval process for temporary deviations
Validation records missing or incomplete	Environmental monitoring gaps during non-working hours
No stop-work authority defined for production personnel	Excursions with product in area and no impact assessment
Operators express fear of consequences for stopping production	No documented basis for sampling plans
No work instructions for critical operations	100% inspection required by customer but sampling used instead
Obsolete instructions being used	CMM programs unvalidated or significantly different from manual results
Operators working from outdated instruction revisions	No program change control for automated inspection
SPC charts consistently show out-of-control with no action	Long-standing temporary repairs with no permanent fix plan
Control limits based on specification, not process data	Quality issues linked to equipment in temporary repair status

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Clause 8.7.1: Control of nonconforming output: actions

What your records showed

What was found	Records	Which
Customer escape caused by a supplier	4	BOEING-QN-2291 (Great Plains Titanium), BOEING-SCAR-D1-4426-003 (Great Plains Titanium), GE-QN-0448 (Wichita Heat Treating Inc), SPIRIT-CAR-7712 (Prairie Composites LLC)

	Question	Priority	Evidence location / initials
☐	**QB-8.7-002** Are MRB (Material Review Board) dispositions documented with technical justification and authorized by qualified personnel?	Critical	
☐	**QB-8.7-004** Is rework performed to documented procedures and is reworked product re-inspected to original requirements?	Critical	
☐	**QB-8.7-005** Is scrap controlled to prevent inadvertent use and is scrap destruction documented?	Critical	
☐	**QB-8.7-001** Is there a documented process for identifying, controlling, and dispositioning nonconforming product?	High	
☐	**QB-8.7-003** Are nonconformance trends analyzed and used to drive corrective action and process improvement?	High	
☐	**QB-8.7-006** Are concession/deviation requests to customers complete with technical justification and impact assessment?	High	

	Have ready		
☐	MRB charter with membership and authority	☐	Nonconformance reports (NCRs)
☐	MRB disposition records with technical justification	☐	MRB meeting minutes and disposition records
☐	Customer concession request and approval records	☐	Customer concession/deviation records
☐	Engineering analysis supporting use-as-is dispositions	☐	Segregation area for nonconforming product
☐	Rework procedure documentation	☐	NCR trend analysis reports (Pareto charts, trend graphs)
☐	Rework instructions specific to the nonconformance	☐	Corrective actions initiated from NCR trend analysis
☐	Re-inspection records after rework	☐	Cost of nonconformance data
☐	Customer approval for rework if required	☐	Management review inputs on NCR trends
☐	Scrap segregation and destruction procedure	☐	Concession/deviation request procedure
☐	Scrap destruction records	☐	Concession request forms with technical justification
☐	Scrap area access controls	☐	Impact assessment on form, fit, function
☐	Periodic verification that scrap has been properly destroyed	☐	Customer approval records with conditions
☐	Nonconformance procedure		

Red flags an auditor looks for	
Use-as-is dispositions without engineering justification	Nonconforming product mixed with conforming product
Customer concession not sought when contractually required	Use-as-is without customer approval on customer-contractual items

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Red flags an auditor looks for	
Rework performed without documented procedure	Same nonconformance repeated without investigation
Reworked product not re-inspected to original requirements	No trend analysis performed on NCR data
Scrap parts indistinguishable from usable parts	Concession requests submitted without safety impact assessment
Scrap parts not physically destroyed for critical/safety items	Customer conditions on concessions not implemented

Clause 7.2: Competence

What your records showed

What was found	Records	Which
FIND-MER-005 12 expired operator certifications on active production lines	-	

	Question	Priority	Evidence location / initials
☐	**QB-7.2-002** Are competency requirements defined for personnel performing special processes (welding, NDT, heat treatment)?	Critical	
☐	**QB-7.2-006** Is initial and recurrent training performed for personnel involved in handling hazardous materials, dangerous goods, or ITAR-controlled items?	Critical	
☐	**QB-7.2-001** Has required competence for personnel affecting quality been determined?	High	
☐	**QB-7.2-004** Are competency matrices maintained showing current qualification status for all personnel in quality-affecting roles?	High	
☐	**QB-7.2-005** Are personnel qualified through a combination of education, training, and experience as required by the role?	High	
☐	**QB-7.2-007** Are temporary or agency workers given adequate quality training and supervision before performing quality-affecting work?	High	
☐	**QB-7.2-003** Is training effectiveness evaluated beyond simple attendance tracking?	Medium	

	Have ready		
☐	NDT personnel certification records (Level I, II, III)	☐	Action plans for competency gaps
☐	Welder qualification records per applicable code	☐	Qualification criteria for key roles
☐	Special process operator qualification records	☐	OJT program documentation and completion records
☐	Proficiency testing or re-examination records	☐	Mentoring program records
☐	Dangerous goods training records and certifications	☐	Experience verification records for new hires
☐	ITAR awareness training records	☐	Temporary worker orientation and training records
☐	Hazardous material handling training records	☐	Supervision requirements for temporary workers
☐	Recurrent training schedule and compliance tracking	☐	Competence verification records for temporary workers
☐	Competence matrices or skills matrices	☐	Restricted operations list for temporary workers
☐	Training records	☐	Training effectiveness evaluation criteria
☐	Qualification records for special process operators	☐	Post-training assessment records

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	Have ready		
☐	Auditor qualification records	☐	On-the-job training validation records
☐	Competency/skills matrix for production and quality roles	☐	Training gap analysis documentation
☐	Qualification status tracking (current, expiring, expired)		

Red flags an auditor looks for	
NDT personnel performing inspections without current certification	Personnel performing tasks for which they are not qualified
No qualification records for special process operators	No OJT program for production roles
Eye exam requirements not met for visual inspection personnel	Personnel performing critical operations without verified competence
Dangerous goods shipped by untrained personnel	Temporary workers performing unsupervised critical operations
ITAR-controlled items handled by persons without training	No quality training provided to temporary workers
Personnel performing critical tasks without documented competence	No training effectiveness evaluation exists
No qualification records for NDT or special process operators	Operators performing tasks for which training effectiveness was not confirmed
No competency matrix exists	

SAMPLE REPORT

Clause 10.2: Nonconformity and corrective action

What your records showed

What was found	Records	Which
Recovery action past its due date	13	ACT-MER-001, ACT-MER-002, ACT-MER-004, ACT-MER-005, ACT-MER-013, ACT-MER-003, ACT-MER-007, ACT-MER-008, ACT-MER-009, ACT-MER-010, ACT-MER-012, ACT-MER-014, ACT-MER-015
Corrective action past due	7	CAPA-MER-019, CAPA-MER-029, CAPA-MER-042, CAPA-MER-052, CAPA-MER-002, CAPA-MER-006, CAPA-MER-007
Recovery decision still pending past its date	2	ACT-MER-006, ACT-MER-011

	Question	Priority	Evidence location / initials
☐	**QB-10.2-002** Are corrective actions proportionate to the significance of the nonconformity and its potential impact on product safety?	Critical	
☐	**QB-10.2-008** Are escaped nonconformities (customer returns, field failures, warranty claims) prioritized for corrective action?	Critical	
☐	**QB-10.2-001** Is there a documented corrective action process with root cause analysis?	High	
☐	**QB-10.2-003** Is root cause analysis methodology effective and are multiple root cause analysis tools used appropriately?	High	
☐	**QB-10.2-004** Are corrective actions verified for effectiveness and are nonconformities confirmed as not recurring?	High	
☐	**QB-10.2-005** Are customer-initiated corrective actions (SCARs) responded to within contractual timelines with adequate root cause analysis?	High	

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	Question	Priority	Evidence location / initials
☐	**QB-10.2-006** Is the corrective action process integrated with the nonconformance process to ensure all significant NCRs trigger corrective action?	High	
☐	**QB-10.2-007** Is the 8D problem-solving methodology or equivalent used for complex or customer-reported nonconformities?	High	
☐	**QB-10.2-009** Are corrective action timelines monitored and is there an escalation process for overdue corrective actions?	High	

	Have ready		
☐	Corrective action procedure with severity classification	☐	Recurrence monitoring data post-corrective action
☐	Extent-of-condition analysis records	☐	Re-opened CAR records when effectiveness not demonstrated
☐	Containment action records	☐	SCAR tracking log with response timelines
☐	Corrective action verification records proportionate to risk	☐	SCAR response quality metrics
☐	Customer escape tracking and prioritization records	☐	Customer acceptance/rejection of SCAR responses
☐	Immediate containment actions for escapes	☐	Root cause analysis in SCAR responses
☐	Customer notification records for escaped nonconformities	☐	NCR-to-CAR escalation criteria
☐	Escape analysis and detection improvement records	☐	NCR-to-CAR conversion tracking
☐	Corrective action procedure	☐	Repeat NCR analysis and automatic escalation records
☐	Corrective action records (CARs)	☐	Customer escape analysis and corrective action records
☐	Root cause analysis records	☐	8D or equivalent problem-solving reports
☐	Effectiveness verification records	☐	Team formation records for problem solving
☐	Supplier corrective action requests (SCARs)	☐	Interim containment action records (D3)
☐	Root cause analysis procedure	☐	Verification of corrective action (D6) records
☐	RCA tool usage examples (5-Why, Ishikawa, fault tree)	☐	Corrective action timeline requirements
☐	RCA training records	☐	Corrective action aging report
☐	Evidence of systemic root causes identified and addressed	☐	Escalation procedure for overdue CARs
☐	Effectiveness verification procedure with timing criteria	☐	Management review of overdue CARs
☐	Effectiveness verification records with evidence		

Red flags an auditor looks for	
Safety-related nonconformities treated same as minor issues	Same nonconformity keeps recurring despite 'effective' corrective actions
No containment actions while product is at risk	SCARs consistently late without customer communication
Customer escapes with no corrective action	High SCAR rejection rate indicating poor root cause analysis
No analysis of detection effectiveness after escapes	Significant NCRs closed without corrective action
Recurring nonconformities with ineffective corrective actions	Repeat nonconformances not triggering corrective action
No root cause analysis performed	No structured problem-solving for complex issues
Corrective actions overdue by more than 60 days	8D reports completed as formality with no real analysis

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Red flags an auditor looks for	
Root cause consistently identified as 'operator error' or 'training'	Large percentage of CARs overdue with no escalation
No formal RCA methodology used	Overdue CARs including safety-related items
No effectiveness verification performed	

Clause 8.1.1: Operational risk management (AS9100 specific)

What your records showed

What was found	Records	Which
High-priority failure mode with no control	15	MER-3101 (FM-3101-03, FM-3101-07), MER-3102 (FM-3102-01, FM-3102-02, FM-3102-03, FM-3102-04, FM-3102-07), MER-3103 (FM-3103-03, FM-3103-07), MER-3104 (FM-3104-03, FM-3104-07), MER-3105 (FM-3105-03, FM-3105-07), MER-3106 (FM-3106-03, FM-3106-07)

	Question	Priority	Evidence location / initials
☐	**QB-8.1.1-001** Is operational risk management applied throughout product realization?	Critical	
☐	**QB-8.1.1-002** Is operational risk management integrated into production planning, including critical items and key characteristics?	Critical	
☐	**QB-8.1.1-004** Are control plans established for production of critical and safety-critical parts?	Critical	
☐	**QB-8.1.1-003** Are project management disciplines applied to product realization including schedule, resource, and risk management?	High	
☐	**QB-8.1.1-005** Are advanced product quality planning (APQP) or equivalent processes used for new product introduction?	High	
☐	**QB-8.1.1-006** Are manufacturing readiness levels (MRL) or equivalent maturity assessments used for new or transferred production?	Medium	

	Have ready		
☐	Operational risk assessments	☐	Project plans with milestones and deliverables
☐	Product safety risk analysis	☐	Resource allocation plans
☐	Risk mitigation records throughout product lifecycle	☐	Project risk registers
☐	Management of operational risk changes	☐	Schedule tracking and variance reports
☐	Critical items list with traceability to design	☐	APQP or equivalent NPI procedure
☐	Key characteristics identification records	☐	Phase gate review records
☐	Control plans for critical items	☐	PPAP or equivalent production approval records
☐	Work instructions referencing critical/key characteristics	☐	Cross-functional team meeting records
☐	Control plans for critical parts	☐	Manufacturing readiness assessment records
☐	Control plan linkage to PFMEA	☐	Production readiness review checklists
☐	Sampling plans referenced in control plans	☐	Low-rate production results and lessons learned
☐	Reaction plans for out-of-control conditions	☐	Transition plan from prototype to full production

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Red flags an auditor looks for	
No operational risk management process	No project management discipline applied to product realization
Product safety not addressed in risk assessments	Projects consistently late with no root cause analysis
Operators unaware of critical items they are manufacturing	No structured NPI process for complex aerospace products
No critical items list despite safety-critical products	New products launched without production approval
No control plans for safety-critical parts	Full-rate production started without readiness assessment
Control plan not updated after significant process changes	Significant quality issues at full-rate that were not seen at low-rate

Clause 8.4.1: Control of externally provided processes: general

What your records showed

What was found	Records	Which
Supplier audit past its scheduled date	6	Great Plains Titanium (SUP-MER-01), Prairie Composites LLC (SUP-MER-03), Wichita Heat Treating Inc (SUP-MER-04), Central NDT Services (SUP-MER-05), Great Bend Machining (SUP-MER-14), Emporia Anodizing Co (SUP-MER-17)

	Question	Priority	Evidence location / initials
☐	**QB-8.4.1-001** Are external providers evaluated, selected, and monitored based on defined criteria?	High	
☐	**QB-8.4.1-002** Is the supplier approval process based on objective criteria including quality performance data, capability assessment, and regulatory status?	High	
☐	**QB-8.4.1-003** Are external providers monitored using quality performance metrics including PPM, delivery, and escape rates?	High	
☐	**QB-8.4.1-004** Is there a process for managing work transferred between suppliers or between internal and external providers?	High	
☐	**QB-8.4.1-005** Are supplier on-site audits conducted based on risk classification and are audit findings tracked to closure?	High	
☐	**QB-8.4.1-006** Are approved suppliers periodically re-evaluated and is the approved supplier list maintained current?	High	
☐	**QB-8.4.1-007** Is there a process for managing supplier nonconformances and ensuring containment and corrective action?	High	

	Have ready		
☐	Approved supplier list with evaluation records	☐	Receiving provider qualification records
☐	Supplier evaluation criteria and methodology	☐	First article verification after work transfer
☐	Supplier performance monitoring data	☐	Risk-based supplier audit schedule
☐	Supplier audit records	☐	Supplier audit reports
☐	Supplier corrective action records	☐	Supplier corrective action tracking
☐	Supplier approval procedure with criteria	☐	Supplier audit finding closure verification
☐	Supplier audit/assessment reports	☐	Supplier re-evaluation procedure and schedule
☐	Supplier risk classification records	☐	Re-evaluation records with performance data

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	Have ready		
☐	Approved supplier list with approval dates and scope	☐	Approved supplier list with status dates
☐	Supplier scorecards/dashboards	☐	Supplier removal or probation records
☐	Supplier performance data (PPM, OTD, escape rates)	☐	Supplier nonconformance procedure
☐	Supplier corrective action requests	☐	Supplier NCR notification records
☐	Supplier development activity records	☐	Supplier containment action records
☐	Work transfer procedure	☐	Supplier corrective action effectiveness data
☐	Work transfer risk assessments		

Red flags an auditor looks for	
No approved supplier list	No validation of product quality after work transfer
Suppliers used without any evaluation	Critical suppliers never audited on-site
Chronic supplier quality issues with no corrective action	Supplier audit findings repeatedly open
No formal supplier approval criteria exist	Suppliers never re-evaluated after initial approval
Suppliers approved without any quality assessment	Approved supplier list includes inactive or removed suppliers
No supplier performance monitoring exists	Supplier quality escapes not communicated to suppliers
Chronically poor-performing suppliers continue without action	Repeated supplier nonconformances with no corrective action
Work transferred without any formal process	

SAMPLE REPORT

Clause 8.4.3: Information for external providers

What your records showed

What was found	Records	Which
Customer requirement not flowed down	4	FLD-MER-01 (Boeing) to Great Plains Titanium, FLD-MER-11 (Airbus) to Titan Bar & Billet, FLD-MER-13 (Spirit) to Great Bend Machining, FLD-MER-15 (GE) to Emporia Anodizing Co
Customer requirement only partly flowed down	1	FLD-MER-16 (Boeing) to Aero Fastener Brokers

	Question	Priority	Evidence location / initials
☐	**QB-8.4.3-001** Is verification of externally provided products and services adequate?	High	
☐	**QB-8.4.3-002** Is receiving inspection adequate to detect nonconforming externally provided product including verification of certifications?	High	
☐	**QB-8.4.3-003** Is source inspection performed at critical suppliers when required by customer or risk assessment?	High	

	Have ready		
☐	Incoming inspection procedure	☐	Material certification verification records
☐	Incoming inspection records	☐	Skip-lot inspection criteria and qualification records
☐	Certificates of conformance from suppliers	☐	Source inspection requirements register

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	Have ready		
☐	Source inspection records (if applicable)	☐	Source inspection reports
☐	Supplier nonconformance reports	☐	Customer source inspection requirements flow-down
☐	Receiving inspection procedure	☐	Source inspector qualification records
☐	Receiving inspection records with results		

Red flags an auditor looks for	
No incoming inspection performed on safety-critical items	Certifications not checked for completeness or correctness
Supplier CoC accepted without any verification	Customer source inspection requirements not met
Material released to production before receiving inspection	Source inspection never performed despite poor supplier performance

Clause 8.1: Operational planning and control

What your records showed

What was found	Records	Which
Customer requirement only partly flowed down	3	FLD-MER-09 (Airbus) in Heat Treat, FLD-MER-10 (GE) in All special processes, FLD-MER-18 (Airbus) in Calibration

	Question	Priority	Evidence location / initials
☐	**QB-8.1-002** Are operational planning outputs documented and sufficient to demonstrate product conformity at each stage?	High	
☐	**QB-8.1-001** Are operational processes planned with defined criteria, resources, and controls?	Medium	

	Have ready		
☐	Manufacturing plans / route cards / travelers	☐	Production control plans
☐	Inspection and test plans	☐	Work order documentation
☐	Acceptance criteria for each operation	☐	Process flow diagrams
☐	Product safety planning outputs	☐	Resource planning records

Red flags an auditor looks for	
No defined acceptance criteria for in-process operations	No formal production planning process
Product safety characteristics not identified in planning	

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Clause 8.6: Release of products and services

What your records showed

What was found	Records	Which
Customer requirement not flowed down	1	FLD-MER-05 (GE) in Heat Treat + Inspection
FIND-MER-010 Engine mount bracket hardness below spec — product released without proper disposition	-	

	Question	Priority	Evidence location / initials
☐	**QB-8.6-002** Are final inspection and test requirements defined and are all planned verification activities completed before product release?	Critical	
☐	**QB-8.6-003** Is the Certificate of Conformance (CoC) or equivalent release documentation accurate and complete before shipment?	Critical	
☐	**QB-8.6-001** Are product release criteria defined and applied, with authorization by competent personnel?	High	
☐	**QB-8.6-004** Are customer witness and hold points defined in inspection plans and properly managed?	High	

	Have ready		
☐	Final inspection procedure	☐	Release procedure
☐	Final inspection records showing all checks completed	☐	Authorization matrix for release personnel
☐	Test results with pass/fail status	☐	Completed inspection/test records
☐	Release authorization signatures	☐	Certificate of conformance
☐	Certificate of Conformance (CoC) or equivalent	☐	Release documentation (traveler sign-offs)
☐	CoC template and content requirements	☐	Customer witness/hold point register
☐	Sample CoCs verified for accuracy	☐	Customer notification records for witness points
☐	CoC signatory authorization records	☐	Customer attendance or waiver records
☐	Customer-specific CoC requirements register	☐	Hold point enforcement records in travelers

Red flags an auditor looks for	
Product released with outstanding test requirements	Product released without completing all required inspections
No formal release authority - anyone can ship product	No defined release authority
False or inaccurate information on CoCs	Work progressed past hold point without customer involvement
CoCs signed by unauthorized personnel	Customer witness/hold points unknown to production

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Clauses 7.5 and 7.5.3: Control of documented information

What your records showed

What was found	Records	Which
Document past its review date	11	DOC-MER-002, DOC-MER-004, DOC-MER-006, DOC-MER-009, DOC-MER-012, DOC-MER-017, DOC-MER-018, DOC-MER-029, DOC-MER-030, DOC-MER-034, DOC-MER-035
FIND-MER-008 Pyrometry control procedure (PYR-200) obsolete — operators working without valid WI	-	

	Question	Priority	Evidence location / initials
☐	**QB-7.5-004** Are customer-supplied documents (drawings, specifications, standards) controlled for current revision?	Critical	
☐	**QB-7.5-001** Is documented information controlled per AS9100 requirements?	High	
☐	**QB-7.5-002** Are electronic records and signatures controlled to ensure authenticity, integrity, and prevent unauthorized modification?	High	
☐	**QB-7.5-003** Are record retention requirements defined and do they meet customer, regulatory, and statutory obligations?	High	
☐	**QB-7.5-005** Are documented procedures maintained for all QMS processes and are they accessible to personnel who need them?	Medium	

	Have ready		
☐	Customer document revision tracking system	☐	Audit trail samples showing change history
☐	Current revision verification records	☐	Backup and recovery test records
☐	Obsolete customer document withdrawal records	☐	Record retention schedule with regulatory references
☐	Customer notification subscription records	☐	Storage condition monitoring records (if physical records)
☐	Document control procedure	☐	Record destruction authorization records
☐	Master document list / document register	☐	Customer-specific retention requirements register
☐	Evidence of controlled distribution	☐	QMS procedure register or master list
☐	Record retention schedule	☐	Procedure review schedule and records
☐	Backup and recovery procedures for electronic records	☐	Accessibility verification at point of use
☐	Electronic records management procedure	☐	Procedure training records for affected personnel
☐	Electronic signature validation records		

Red flags an auditor looks for	
Production using outdated customer drawing revision	Backup recovery never tested
No tracking system for customer document revisions	Records destroyed before regulatory retention period ends
Obsolete documents in active use on shop floor	No defined retention periods for some record types
No backup system for electronic quality records	Records stored in conditions causing deterioration

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Red flags an auditor looks for	
Shared accounts used for quality record entries	Critical processes operating without documented procedures
No audit trail on electronic quality records	Actual practice significantly different from documented procedure

Clause 9.2: Internal audit

What your records showed

What was found	Records	Which
FIND-MER-009 Internal audit program lapsed — no internal audits for 4 months (May to September) during QM vacancy	-	

	Question	Priority	Evidence location / initials
☐	**QB-9.2-001** Is an internal audit program planned and executed covering all QMS processes?	High	
☐	**QB-9.2-002** Is the internal audit program risk-based, covering all QMS processes including aerospace-specific requirements?	High	
☐	**QB-9.2-004** Are internal audit findings effectively addressed with root cause analysis and verified corrective actions?	High	
☐	**QB-9.2-008** Are special unannounced audits conducted in response to quality events, customer complaints, or product safety issues?	High	
☐	**QB-9.2-003** Are internal auditors qualified, independent, and following a systematic audit methodology?	Medium	
☐	**QB-9.2-005** Do internal auditors use process-based audit techniques rather than purely clause-based approaches?	Medium	
☐	**QB-9.2-006** Is internal audit performance itself evaluated (coverage, timeliness, finding quality, value added)?	Medium	
☐	**QB-9.2-007** Are supplier quality audits integrated into the internal audit program or managed as a complementary program?	Medium	

	Have ready		
☐	Internal audit program/schedule	☐	Auditor qualification criteria and records
☐	Audit reports	☐	Auditor training records (lead auditor, AS9100 standard)
☐	Auditor qualification records	☐	Audit plan and checklist examples
☐	Corrective action records for audit findings	☐	Independence verification records
☐	Audit closure verification records	☐	Process-based audit checklists
☐	Audit program with risk-based scheduling	☐	Product audit procedure and records
☐	Audit schedule showing coverage of all AS9100D clauses	☐	Audit plans showing process-based approach
☐	Audit reports for aerospace-specific requirements	☐	Turtle diagram-based audit records
☐	Product audit reports	☐	Audit program effectiveness metrics
☐	Audit finding corrective action records	☐	Audit coverage tracking data

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	Have ready		
☐	Root cause analysis for each finding	☐	Auditor performance feedback records
☐	Corrective action effectiveness verification records	☐	Audit program improvement actions
☐	Audit finding closure timeline tracking	☐	Supplier audit program or schedule
☐	Event-triggered audit procedure	☐	Supplier audit reports
☐	Records of unplanned audits and their triggers	☐	Supplier audit results in supplier performance tracking
☐	Rapid response audit reports	☐	Supplier audit finding closure tracking
☐	Event-triggered audit findings and corrective actions		

Red flags an auditor looks for	
Some processes never audited	No auditor qualification criteria defined
Audit findings open for over 12 months	Auditors auditing their own work areas
Auditors auditing their own work	Audits purely paper-based with no shop floor verification
AS9100D-specific clauses not covered in audit program	No process-based or product-based audit approach used
Audit findings recurring year after year	Audit program never evaluated for effectiveness
Audit findings recurring year after year with same root cause	Audits finding no issues despite known quality problems
No effectiveness verification on corrective actions	No supplier audit program despite critical supply chain
Significant quality events with no targeted audit response	Supplier audit results ignored in supplier decisions
No capability for event-triggered audits	

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