Group Supplier Nonconformance Codes

Revision	Changes
G	Added code MD7

Code	Defect Description
AS	**Assembly - Defects That are Specific to the Assembly Process**
AS1	**Assembly mismatch**
AS2	Bushing defects, seating / flushness / size / material
AS3	Clearance, details
AS4	Damaged
AS5	Edge Distance, details, holes
AS6	Fastener, rivet defects, seating / gaps / flushness / head shape
AS7	Foreign Object - Contamination
AS8	Gaps, details
AS9	Incomplete Assembly
AS10	Incorrect Assembly
AS11	Insulation, missing / incorrect / torn / misapplied
AS12	Leakage
AS13	Loose
AS14	Mislocated assembly details
AS15	Mislocated fabrication features / holes / slots
AS16	Missing detai(s) l or hardware
AS17	Overlap
AS18	Reversed or opposite
AS19	Sealant, missing / lack of squeeze out / incorrect
AS20	Water entrapment
AS21	Weight, over / under
AS22	Test Failure Other
AS23	Torque over/under
AS24	Test Failure Elect ESS
AS25	Test Failure Elect CCA Programming
AS26	Test Failure Elect CCA Assembly
AS27	Test Failure Elect Bonding
AS28	Test Failure Elect Room Temp ATP
AS29	Test Failure Elect S/W Loading
AS30	Test Failure ATP
AS31	Test Failure Leak Test
AS32	Test Failure Break in
AS33	Test Failure Calibration
AS34	Test Failure FAT
AS35	Test Failure Leakage
AS36	Lock/Safety Wire Problem
AS37	Component Missing
AS38	Component - Reversed
AS39	Component - Damaged
AS99	Asseembly Defect Non Specific
CA	**Casting Specific - Defects That are Specific to the Casting Production Process**
CA1	Blowhole
CA2	Cracks, surface / internal
CA3	Distortion
CA4	Gas hole
CA5	Inclusion
CA6	Insufficient fill
CA7	Laps
CA8	Porosity, surface / included / internal
CA9	Not Properly Trimmed
CA99	Forging/Casting Defects Non-Specific

Group Supplier Nonconformance Codes

Code	Defect Description
CE	**Certification and Documentation - Issues Related to Errors that Occur in the Certification or Documentation Process**
CE1	Incomplete or open supplier operations
CE2	No certificate of conformance
CE3	No first article documentation
CE4	No shipper
CE5	Missing test reports or testing documents
CE6	Unapproved processor utilized
CE7	Unapproved supplier utilized
CE8	Incorrect Part Number
CE9	Serial Number Duplicated
CE10	Serial Number Incorrect
CE11	Special Handling Ignored
CE12	Wrong Part Received
CE13	Inadequate Process
CE14	Doccumentation Errors
CE15	Missig Stamp or Date
CE16	Configuration Issue
CE99	Error in Cert/Docs Non-Specific
CF	**Configuration - Errors that Occur in the Determination of Proper Configuration**
CF1	Incorrect Configuration
CF2	Obsolete Part
CF3	Wrong Part
CF4	Incorrect Design
CF99	Configuration Non-Specific
CO	**Composites - Defects That are are Specific to the Composite Fabrication Process**
CO1	Adhesive Bond
CO2	Core, damage / mislocation / crushed / condensed
CO3	Cracking, crazing
CO4	Cure, incorrect cycle
CO5	Cut, sanded plys
CO6	Delamination
CO7	Disbond
CO8	Inserts, size / location / missing / damaged / high / low
CO9	Ply, cut / missing / extra / mislocated / overlap / distortion / wrinkles
CO10	Porosity, internal / surface
CO11	Potting, missing / high / low / voids /
CO12	Resin Starvation
CO13	Voids, internal / surface
CO14	Drilled Hole punch through, delamination
CO99	Composites Defects Non Specific
DI	**Dimension - Defects That are Specific to the Dimensional Aspect of Detail Part Inspection**
DI1	Angularity
DI2	Circularity / roundness
DI3	Cylindricity
DI4	Depth
DI5	Extra
DI6	Hole diameter
DI7	Hole location
DI8	Length / linear dimension
DI9	Mislocated
DI10	Dimension Missing
DI11	Parallelism
DI12	Profile
DI13	Radius
DI14	Thickness, over / under
DI15	True position
DI16	Warped, twisted
DI17	Width

Group Supplier Nonconformance Codes

Code	Defect Description
DI	**Dimension - Defects That are Specific to the Dimensional Aspect of Detail Part Inspection**
DI18	Perpendicularity
DI19	Straightness
DI20	Flatness
DI21	Circular Runout
DI22	Total Runout
DI23	Profile of a Line
DI24	Profile of a Surface
DI25	Concentricity
DI26	Symmetry
DI27	Diameter Oversize
DI28	Diameter Undersize
DI29	Dimension Oversize
DI30	Dimension Undersize
DI31	Feature is Mislocated
DI32	Feature Missing
DI33	Hole is Missing
DI34	Hole, Extra
DI35	Thread Minor Diameter Oversized
DI36	Thread Minor Diameter Undersized
DI37	Thread Pitch Diameter Oversized
DI38	Thread Pitch Diameter Undersized
DI39	Profile All-Around
DI40	Non-Cleanup
DI41	Timing
DI42	Stock Removal
DI99	Dimensional Defect Non-Specific
E	**Electrical - Defects That are Specific to Electrical Components Supplied or Provided as Part of an Assembly**
E1	Conductivity
E2	Impedance
E3	Improper electrical bond
E4	Resistance
E5	Short
E6	Damaged - Other
E7	Solder problem
E8	Solderballs or Splash
E9	Lock/Safety Wire Problem
E10	Component Missing
E11	Component - Wrong
E12	Component - Reversed
E13	Component - Damaged
E14	Ecobond Problem
E15	Terminal problems - poor crimp, etc.
E16	Jumper Wires Incorrectly Routed
E17	Lifted Solder Pad
E18	PCB Damaged
E19	Conformal coating issue
E99	Electrical Non Specific

Group Supplier Nonconformance Codes

Code	Defect Description
F	**Fabrication - Defects That are Specific to the Detail Part Fabrication Process**
F1	Bearings, incorrect installation / binding
F2	Bent
F3	Burrs, holes / trim
F4	Chamfer, missing / size / depth
F5	Counterbore, missing / size / depth
F6	Countersink, missing / size / depth
F7	Cutter chatter marks
F8	Double drill hole(s)
F9	Drill mark(s)
F10	Edge trim
F11	Fabricated angle incorrect
F12	Heat induced discoloration
F13	Hole edge distance, short / long
F14	Hole elongated
F15	Hole mislocated
F16	Hole missing
F17	Hole quantity incorrect
F18	Hole size incorrect
F19	Incomplete fabrication
F20	Inside diameter incorrect
F21	Machining - Milling - Grinding - Turning mis-cut / undercut / gouged/false cut
F22	Misformed/mismatch
F23	Oil Can
F24	Outside diameter incorrect
F25	Radius incorrect / large / small / location
F26	Slot location
F27	Thickness, thick / thin
F28	Threads - diameter / depth / pitch / burrs / torn
F29	Balance
F30	Deburr, Blend, Edge Break
F31	Grind Burns
F32	Improper Oil / protectant
F33	Mutilated
F34	Damaged - Other
F99	Fabrication Non Specific
GS	**Gears / Splines**
GS1	Backlash
GS2	Curvic Coupling Error
GS3	DOP / DUP Dim. OVer between pins
GS4	Lead Error
GS5	Major Diameter
GS6	Number of Teeth
GS7	Pitch Line Runout
GS8	Root Diameter / Dimension
GS9	Root Radius
GS10	Tooth Profile / Form
GS11	Tooth Spacing
GS12	Damaged - Other
GS99	Gear/Spline Defects Non Specific

Group Supplier Nonconformance Codes

Code	Defect Description
H	**Handling-Packaging-Preservation-Delivery - Defects That are Specific to the Handling, Packaging, Preservation & Delivery of Supplied Products**
H1	Bent or Broken
H2	Crushed
H3	Incorrectly delivered quantities
H4	Material out of temperature
H5	Missing Temperature recorders
H6	No electro discharge protection per requirements
H7	Delivered Quantity Incorrect (Missing, Over, etc.)
H99	Handling Damage Non-Specific
I	**Identification and Marking - Defects That Specific to the part / Material / Assembly Identification and Marking Process**
I1	Identification error
I2	Identification missing
I3	Incorrect markings, marking materials / plates / locations / methods
I4	Missing stamps or Date
M	**Material - Defects That are Specific to Supplied Materials**
M1	Conductivity
M2	Discoloration
M3	Expired material (Shelf Life)
M4	Hardness not to requirement
M5	Incorrect grain direction
M6	Incorrect material
M7	Length
M8	Over temperature
M9	Porosity
M10	Test failure
M11	Thickness
M12	Traceability
M13	Width
M14	Wrong material
M15	Part Destroyed for Test
M16	Old Stock
MD	**Machining - Defects That are Specific to Supplied Machine Parts**
MD1	Broken Tap
MD2	Broken Tool
MD3	Extra Hole(s)/Feature(s)
MD4	Gouged
MD5	Threads Damaged
MD6	Hole/Feature Drilled Too Deep
MD7	Laser Strike
MD99	Machine Damage Non-Specific
MES	**Triumph Aerostructures MES Defect Codes**
AB	[assy errors]ADJUSTMENT ERROR
AC	[assy errors]ALIGNMENT ERROR
AD	[assy errors]ASSEMBLY INCOMPLETE
CK	[assy errors]CLOCKING ERROR
CP	[assy errors]COMPONENT MALFUNCTION
IP	[assy errors]INCORRECT PART INSTALLED

Group Supplier Nonconformance Codes

Code	Defect Description
MES	**Triumph Aerostructures MES Defect Codes**
IS	[assy errors]INCORRECTLY INSTALLED PART (OTHER THAN A FASTENER)
PM	[assy errors]PART MISLOCATED
PX	[assy errors]PART EXTRA/MISSING
WT	[assy errors]WELD DEFECT
BP	[bonding]BACK PRESSURE
CC	[bonding]CORE CRUSHED
CF	[bonding]CURE CYCLE FAILURE
CG	[bonding]CORE MIGRATION
CU	[bonding]CUT PLIES
DO	[bonding]DELAMINATION
EH	[bonding]EXCESSIVE HEAT
FB	[bonding]FIBER BREAKOUT
GI	[bonding]GLUE LINE VOID
HC	[bonding]HEATUP/COOLDOWN RATE
IV	[bonding]INTERNAL VOIDS
IW	[bonding]INCORRECT WARP/FILL/PLY ORIENTATION
NP	[bonding]INCORRECT NUMBER OR MISLOCATED PLIES
NS	[bonding]NODE SEPARATION
PG	[bonding]POTTING ERROR
PO	[bonding]POROSITY
RR	[bonding]RESIN RICH AREA
RS	[bonding]RESIN STARVED AREA
SD	[bonding]SPLICING DEFECTS
SP	[bonding]SANDED THRU PLIES
VL	[bonding]VACUUM LOSS
WN	[bonding]WRINKLED
BK	[damage]BROKEN OR MUTILATED
BS	[damage]BLANKING SHEARS OR TEARS
CM	[damage]CHEM-MILL DEFECT
CZ	[damage]CORROSION
DR	[damage]DRILL STARTS/ DRILL RUNS
EX	[damage]EXCESSIVE BLENDING
FC	[damage]FALSE CUT
FY	[damage]FRAYED/ABRADED
GR	[damage]GRINDING DEFECT
PB	[damage]BENT/DENTED
PK	[damage]TORN PLIES
PS	[damage]SCRATCHED/SCORED/BURRS
PU	[damage]NICKS OR GOUGES
SC	[damage]SURFACE CRACK OR CRACKS
TO	[damage]TOOL SET OR CHATTER MARKS
AK	[dimensional]ANGULARITY ERROR
CH	[dimensional]CHORDAL HEIGHT / FLANGE ANGLE
CI	[dimensional]CONTOUR IS INCORRECT
CQ	[dimensional]CONCENTRICITY ERROR
FL	[dimensional]FLATNESS BOW OR TWIST
JO	[dimensional]JOGGLE ERROR
LW	[dimensional]LENGTH OR WIDTH IN ERROR
MF	[dimensional]MINIMUM FLAT VIOLATION
OS	[dimensional]OVERSIZE THICKNESS
PF	[dimensional]PROFILE DEFICIENCY

Group Supplier Nonconformance Codes

Code	Defect Description
MES	**Triumph Aerostructures MES Defect Codes**
RE	[dimensional]RADIUS IN ERROR
TE	[dimensional]THREADING ERROR
TP	[dimensional]TRIM PROBLEM
UT	[dimensional]UNDERSIZE THICKNESS
E4	[electrical]WIRING FOULING
EA	[electrical]ELECTRICAL ATTRIBUTE ERROR
WE	[electrical]WIRING ERROR
DF	[fastener]DAMAGED FASTENER
ET	[fastener]MISSING FASTENERS
FF	[fastener]FASTENER FLUSHNESS
FH	[fastener]FASTENER HEIGHT INCORRECT
FI	[fastener]INCORRECT FASTENER
LH	[fastener]LOOSE HARDWARE
OF	[fastener]OPEN HEAD/OPEN SHANK FASTENER
OT	[fastener]TORQUE OVER OR UNDER
AO	[fit]AERO GAP, STEP OR WAVE
BD	[fit]BINDING
CN	[fit]CANS (OIL CAN)
GP	[fit]GAP, STEP OR WAVE (USE AO FOR AERO SURFACE)
IN	[fit]INTERFERENCE/RIDING CONDITION
PD	[fit]PRELOAD
CW	[hole prep]COUNTERSINK OR SPOTFACE ERROR
DD	[hole prep]DOUBLE DRILLED HOLES
EO	[hole prep]EXTRA HOLES
HS	[hole prep]HOLE SPLINTERED
MH	[hole prep]MISLOCATED HOLES
OH	[hole prep]OVERSIZE HOLES
OM	[hole prep]OMITTED HOLES, SLOTS OR CUTOUTS
PH	[hole prep]PILOT HOLE OR TOOL HOLE NOT COORDINATED
SH	[hole prep]SHORT EDGE DISTANCE/ MARGIN
UH	[hole prep]UNDERSIZE HOLES
CT	[misc]CONTAMINATION
FG	[misc]FOREIGN OBJECT DEBRIS
ID	[misc]IDENTIFICATION ERROR
LB	[misc]INCORRECT WEIGHT
LK	[misc]LEAK
PN	[misc]PACKAGING NOT ACCEPTABLE
TT	[misc]TEST FAILURE/ NO TEST PANEL
AF	[ndi]ACOUSTIC TEST FAILURE
HD	[ndi]HARDNESS/CONDUCTIVITY ERROR
MZ	[ndi]MAGNAFLUX/ZYGLO INDICATION
UD	[ndi]ULTRASONIC REJECTION (USE ONLY WHEN NO OTHER CODE SUCH AS FG, CT, DO, IV, PO, ETC. APPLIES)
XR	[ndi]X-RAY REJECTION (USE ONLY WHEN NO OTHER CODE SUCH AS FG, CT, DO, IV, PO, ETC. APPLIES)
DQ	[process]DEVIATION FROM PLANNED SEQUENCE
MI	[process]MATERIAL INCORRECT
PP	[process]PAPERWORK ERROR

Group Supplier Nonconformance Codes

Code	Defect Description
MES	**Triumph Aerostructures MES Defect Codes**
PV	[process]PROCESS SPEC VIOLATION
SA	[process]SEALANT APPLICATION ERROR
VS	[process]VOID IN SEAL
AU	[surface]APPEARANCE UNACCEPTABLE
CV	[surface]CONVEX CONDITION (BUMP OR PROTRUSION)
CX	[surface]COATING THICKNESS INCORRECT
DP	[surface]DEPRESSION
FN	[surface]FINISH DISCOLORED
IF	[surface]INCORRECT FINISH APPLIED
MO	[surface]MARKOFF (tool impression)
PE	[surface]PLATING ERROR
SR	[surface]SURFACE ROUGHNESS ERROR (NOT FOR USE WHERE SKIN QUALITY IS REQUIRED)
SU	[surface]SURFACE BLISTER/RAISED AREA
N	**Non Destructive Testing- Defects That are Specific to Parts or Materials that Received Non Destructive Testing**
N1	Inclusion
N2	Incomplete Penetration
N3	Mag Particle
N4	Non Fusion
N5	Penatrant
N6	Porosity Inline
N7	Porosity Round
N8	Radiographic
N9	Surface Indication
N10	Ultrasonic
N99	Non-Destructive Testing Non-Specific
O	**Other**
O1	Other
O2	Multiple Errors
O3	Supplier Recall
P	**Processing - Defects That are Specific to Parts or Materials that Receive Processing**
P1	Alpha Case / Case Depth
P2	Anodize defects
P3	Brazing defects
P4	Chem-mill burns
P5	Coating blisters
P6	Coating crazed
P7	Coating or Plating adhesion
P8	Coating orange peel
P9	Coating overspray
P10	Coating peeling
P11	Coating runs
P12	Coating, missing / flaking / thickness / uneven
P13	Heat treating, incorrect / missing / not to requirements
P14	NDT, incomplete / incorrect / missing / indications
P15	Plating - missing / flaking / thickness / uneven / cracks / burns / melts
P16	Surface treatment defects – Shot peen / non-machining surface inhancements
P17	Welding defects - C160cracks / porosity / lack of fusion / undercut / arc strike / start / stop
P18	Contamination
P19	Wrong Material/Process
P20	Foreign Material

Group Supplier Nonconformance Codes

Code	Defect Description
P21	Incorrectly Masked
P22	Not Properly Etched
P23	Over Etched
P24	Pitted Surface
P25	Scratched/Chipped Coating
P26	Wrong Color
P27	White Layer Removal
P28	Cleaning Process
P29	Incomplete Processing
P99	Process Defects Non-Specific
S	**Surface - Defects That are Specific to a Part or Material Surface or Finish**
S1	Bent, bowed, curved, contour
S2	Cracked material
S3	Creased, not cracked
S4	Cut, Scratched, nicked, gouged, dinged or chipped
S5	Flatness not to requirements
S6	Forming marks on surface
S7	Puctured, through surface
S8	Surface finishing / Smoothness not to requirements
S9	Surface corrosion, rust / pitting / oxidation / discoloration
S10	Surface dent
S11	Surface waviness
S12	Surface wrinkles
S13	Tool marks in surface
S14	NDT, incomplete / incorrect / missing / indications