



Non-Destructive Testing Newsletter



February 2009

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From the Chair.....

2009! Another year full of promise, challenges, opportunities, changes and...more opportunities! Delving into this issue of the NDT Newsletter, there is a taste of some of the changes, but also a reminder that some of the “new” issues coming up aren’t all that new, after all. We said goodbye to the steady presence of Louise Belak, a lady who managed to deal so successfully with the “children” of the NDT Task Group but now finds her pleasure in spending time with her own children, and grandchildren. And “Welcome” to Rhonda Joseph as she is indoctrinated into the wonderful world that is our NDT family. Thanks, Louise, for all the years that went into keeping me, and our Staff, in line. And “Come on in, Rhonda, just don’t mind the mess!”

We take a step closer, this year, to the realization of “Audit on Demand”. This is a concept of putting all the requirements from the various primes into a checklist that is tailored to the individual supplier. Through the Herculean efforts of the Staff Engineers there will be a combined checklist/handbook that puts all the information in one place, but doesn’t quite go the final step of creating individualized checklists. But we are getting there. Congratulations to the NDT Staff for the great work they did to make this happen.

This is such a quantum leap from the days of the early 90’s when this program was just getting started. At those meetings the first day or two were devoted to “NDT Library Hours”. The Staff Engineer would bring along three copies of each of the audits performed during the previous quarter and these were made available for the Task Group members to review prior to the actual meeting sessions. Then the meeting hours were dedicated to review of these paper copies by 3 person sub-teams. At the end of the day the entire group would vote on the recommendations of these sub-teams. Meetings didn’t really last forever, it just felt that way! In those days it was user primes only, no supplier interaction, though there was no lack of “healthy debate”!

I hope everyone had a wonderful Holiday Season, return to work refreshed, recharged and ready for an exciting year of challenges and opportunities. I look forward to seeing you at future meetings and wish everyone a happy, healthy and productive New Year.

Phil Keown – NDT Task Group Chair

Nadcap Meeting Schedule

2009	Location
February 16-20	Dallas, Texas, USA
July 13-17	Istanbul, Turkey
October 19-23	Pittsburgh, Pennsylvania, USA



Compliance Jobs – Expectations

Compliance jobs, the most enjoyable portion of a Nadcap audit. Everyone is all excited; from the Level 3 who has all the confidence in the world in the inspectors to the inspectors themselves, who are fighting among each other to be the lucky one selected to perform the compliance!

Before jumping in with both feet, there are some things to undertake prior to the compliance portion of an audit. First off, make sure that there are parts available for the audit.

The NDT Task Group expects the following for compliance:

- Three jobs are required to be witnessed by the auditor for each NDT Method.
- The parts used for each job should be from a prime subscriber of Nadcap as listed in your scope of accreditation.
- The jobs should represent the different types of processing equipment/systems in use by the organization.
- If possible, different inspectors should be used for each job.

Having parts available for compliance could be difficult. Even though this is what we do for a living, having the right parts at the right time is a challenge for many organizations.

Every attempt must be made to have all compliance jobs lined up for the audit. This may be difficult due to the demands of moving material at an efficient pace through the NDT process. Contacting customers prior to the audit to make arrangements

may prove to be beneficial. By communicating with your customer, one or two parts could be held back from a larger job to fulfill the compliance requirement. Just keep in mind that you will need a purchase order for the jobs that you will present to the auditor. The checklist will have a spot for the auditor to record the purchase order number. In part, “the auditor is expected to review and follow traceability from the purchase order to completion of the NDT process or final certification”. This will rule out any use of “borrowed” user prime parts from another company or source. Other problems encountered using borrowed parts could result in customer confidentiality issues, unapproved inspection techniques and even ITAR/EAR issues. Unless you have specific authorization from a prime, borrowing parts for the compliance job is not acceptable.

At the opening meeting with the auditor, discuss the coordination/scheduling of any compliance jobs. Auditors will work with you to schedule any reasonable request in order to fulfill the compliance requirement.

As a supplier seeking accreditation, it is your responsibility to be prepared for the audit. Failure to provide the required number of compliance jobs may result in an NCR being written, the Task Group recommending another audit or in severe cases, audit failure.

Gary White – Orbit Industries, Inc.
Supplier Voting Member – NDT Task Group

NDT Newsletter – Want to be on the Circulation?

The NDT newsletter is published periodically throughout the year. The newsletters are read by the subscribing Nadcap Users, Suppliers, Auditors and anybody that happens to click on the latest NDT newsletter on the PRI website (www.pri-network.org). The aim of the newsletter is to communicate information relating to NDT within the Nadcap program to improve processes and to promote the sharing of best practices at all levels.

Have you stumbled across the NDT Newsletter by chance? Want to receive it on a regular basis? Keep up-to-date with the latest Nadcap NDT information by getting added to the distribution list! To receive notification when a new edition has been published, please e-mail Kellie O'Connor at koconnor@sae.org with your name, company and email address.

Merging of the audit checklists and handbooks

As part of the ongoing continuous improvement activities within the NDT Task Group, a decision was made to merge the handbook criteria into the checklist to create one document rather than two. The main driving force for this change was as follows:

- Reduce the number of documents controlled by the NDT Task Group.
- Reduce non-conformances where the company failed to utilize the NDT handbook in conjunction with the Nadcap NDT checklists when performing internal audits, pre-audits, etc.
- Expectations / requirements are flowed down via one document rather than two making auditing easier for the Nadcap auditor and the company internal auditors / responsible NDT Level 3's.

The document merging took place back in December with the latest changes made to the checklists (AC's), handbooks (HB's) and supplements (ACS's) following closure of the latest ballots. As per Nadcap policy, the documents were subject to the 90 day implementation period. As a result all audits conducted on or after March 8, 2009 will be audited using the merged documents, although audits conducted between now and March 7, 2009 are encouraged to follow the new guidelines if possible.

From March 8, 2009 onwards the following documents will exist:

AC7114, AC7114/1, AC7114/2, AC7114/3, AC7114/4

AC7114S, AC7114/1S, AC7114/2S, AC7114/3S, AC7114/4S

The Handbooks (HB7114, HB7114/1, HB7114/2, HB7114/3, HB7114/4) have been cancelled.

Nadcap NDT Task Group's position regarding the NAS 410 - ASNT Central Certification Program (ACCP) equivalency declaration:

ISSUE: ACCP-CP-1, Rev. 5, Forward, makes the following statement:

This document [ACCP-CP-1, Rev. 5] establishes the requirements for the ASNT Central Certification Program (ACCP). The ACCP has been developed to improve NDT reliability by providing standardized requirements administered by an accredited certification body. The program will provide prospective employers with NDT personnel that have achieved a high level of performance and competency within the NDT profession.

Individuals that successfully meet the training, experience and examination requirements of this document for a specified level of qualification covered

by this document will have met or exceeded the same time requirements as listed in the following documents:

- *ASNT Recommended Practice No. SNT-TC-1A, Personnel Qualification and Certification in Nondestructive Testing*
- *ANSI/ASNT Standard CP-189, ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel*
- *CP-106:2008, Nondestructive Testing - Qualification and Certification of Personnel*
- *Aerospace Industries Association Standard NAS 410, NAS Certification and Qualification of Nondestructive Testing Personnel"*

It is the Nadcap NDT Task Group's position that the ACCP process, as outlined and defined in ACCP-CP-1, actually does not meet or exceed the qualification and certification requirements of NAS 410. The main issues being the specific and practical examination requirements are not in compliance with NAS 410. In light of this position, if during a Nadcap NDT audit an individual is found to be qualified and certified solely in accordance with the ACCP-CP-1, and not NAS 410, there will be a Major NCR issued as a result.

D. Scott Sullivan – Honeywell Aerospace Nadcap NDT Task Group – NDT Systems Method Chair

Auditor Perspective – Drying Oven Controller Calibration

Editorial Note - Due to a number of recent NCR's associated with oven controller calibrations performed incorrectly, it is appropriate to re-issue an article that was published back in July 2005 when problems were identified at that time regarding oven controller calibration. In essence the article originally written by one of our most distinguished auditors, Ed Alloway, still applies in terms of the expectations. Below is that same article including reference to the latest specification revisions and paragraphs-

This article is essentially written around ASTM E 1417-05e and AC7114/1 for dryer oven calibration requirements. Apologies to any Primes who flow down their own standards, but the ASTM (which was the basis for dryer oven calibration within AC7114/1) is the only industry NDT standard that seems to address dryer oven calibration in any detail.

Basically, ASTM E 1417-05e and AC7114/1 require dryer oven controllers and temperature indicators to be calibrated quarterly, unless extension/reduction of that time can be substantiated by actual technical/reliability data.

Specific parameters for what constitutes a successful dryer oven calibration are very clearly stated in ASTM E 1417-05e, para. 6.6.2, "The temperature

shall be controlled with a calibrated device capable of maintaining the oven temperature at +/- 15°F (+/- 8.3° C) of the temperature for which it is set. The oven shall not exceed 160°F (71°C). The temperature indicator shall be accurate to +/- 10°F (+/- 5.6° C) of the actual oven temperature." Neither of these calibration requirements is difficult to meet.

I do not recall reviewing any oven calibration certifications not reporting the results of the comparison of a temperature indicator to a potentiometer or master thermometer, but seen numerous certifications of oven calibration compliance, which included no record of the minimum/maximum temperatures that represent the controller capability. This is the source of most of the dryer oven NCR's that are written up.

The capability of a controller is always based on "worst case" conditions. For a dryer oven, the verification of the maximum temperature attained, for a given set-point, is the peak temperature during ramp-up from the ambient oven temperature at start-up. The initial cycling around the set-point will also identify the low end of the controller capability. The following example should be explanatory:

If the controller set-point is 150°F and the indicated temperature climbs to 157°F before the temperature begins to fall

back, then the oven overshoot is 7°F. As the oven cools the temperature indicator might drop to 146°F before there is an indication of the temperature beginning to rise again. This hysteresis tells us the controller capability is +7°F and -4°F, and is within specification. It also tells us that use of any set-point higher than 153°F probably would have us processing out of specification, at least part of the time.

If the company does not know these numbers, they have not satisfied the calibration requirements. Further, if they are not recorded, the company cannot take advantage of extending the calibration frequency as outlined in the Nadcap checklist (AC7114/1).

This calibration need not be as complex a process as that required of heat treating. Once the oven temperature indicator has been determined to be accurate to a given tolerance, it is a simple matter to set the oven to the desired temperature and then watch the temperature as it peaks and then drops to its low point before beginning to climb again. Record these high and low values and the controller capability has been verified.

See you in October.

Ed Alloway – Nadcap NDT Lead Auditor

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eQuaLearn – A Year of Learning

In 2008, PRI's professional development program, eQuaLearn responded to customer needs and provided training courses, localization of services, new technology and created new partnerships to ensure that the workforce of today is ready for the challenges of tomorrow.

eQuaLearn was created to offer solutions to the current global crisis of shortage of personnel. As the largest population of the workforce nears retirement, a shortage of qualification is being seen throughout the engineering community – in all industries, and the aerospace industry is not immune. In addition to engineering, shortages are also being felt in many skilled trades, machinists/operators, production operators, quality management, and others. These skills are in demand by ALL industries, so the aerospace community must poise itself to compete with the high-tech industry, healthcare, and other attractive industry sectors.

eQuaLearn exists to ensure personnel are qualified to perform key functions in the quality industry. In 2008, eQuaLearn reached several milestones:

- eQuaLearn website, www.eQuaLearn.com was launched. This learning portal provides customers the ability to register and pay for courses online, participate in webinar events, provide course feedback, and eQuaLearn members can also track their learning, create e-learning, create staff development plans, receive a customized learning website, and receive exclusive access to training events.
- Problem Solving – a new instructor-led course was launched and offered in the Americas, Europe and Asia
- New Partnerships were created; Goodrich Corporation and Honeywell Aerospace joined with eQuaLearn and became eQuaLearn Partner Members. Their partnership affords them the opportunity to participate in customize course development, receive a personalized learning portal to track and create employee learning and receive substantial course discounts.
- Over 2,000 students participated in an eQuaLearn program in 2008
- Courses were held in 13 countries and in 7 languages
- New regions of the world were supported; in Mexico over 50 students participated in classes and in India over 60 participants attended training
- Webinar programs were launched with the first three events focused on the topic of Pyrometry. Additional webinar and e-learning programs will be offered in 2009 to allow those interested in learning the ability to access the information needed in a convenient setting and eliminating the expense and time of travel.

eQuaLearn programs continue to be well-received, with participants reporting overall that the programs are excellent and the instructors are responsive to questions and industry experts.

In 2009, eQuaLearn will continue to respond to customers and offer new programs, in new regions, and additional languages. Some of the courses that will be offered in 2009 include; AS9100 Rev C – a full day course, AS9100 Rev C – What Changes you NEED to know now; Process FMEA, Introduction to Quality and many more. Programs will be offered in the traditional instructor-led model and also available in new modalities such as webinar and e-learning.

eQuaLearn is designed as a solution to business problems and is available to assist any company with its' professional development services.

Farewell Louise...Welcome Rhonda

Of course you are aware that Louise Belak retired at the end of 2008, and Kellie O'Connor, who started back in early 2007 and trained under Louise's tutelage, has taken over Louise's role in the NDT department as Committee Service Representative. Our best wishes to her as she endeavors to fill some pretty big shoes. One of her first assignments will be to train our new Committee Service Representative, Rhonda Joseph, who is our most recent addition to the NDT and PRI family.

Rhonda has training as a computer programmer and also has expertise in several of the latest computer programs that will take us into the future as we develop new and more helpful reporting tools. She has been employed by several major companies including; Fedex, Verizon Wireless and LSI to name a few. We hope her coming days at PRI in the NDT Group are exciting.

We are all very excited about working with Rhonda and don't worry, she has been warned about the NDT group, both here at PRI and the Task Group overall. She will get her first chance to interact with the entire group at the auditor training, October 2009. Please feel free to welcome her to our little family.



Rhonda Joseph

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