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worldwide JF VARIATION MANAGEMEN KEY CHARACTERISTICS

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	Document Identifier.	Variation Management of Key Characteristics
	Date:	Latest Revision Date
	Project:	Customer, Unique ID, Part Number
i alt	Document Status:	Draft, Redline, Released, Obsolete
Secr	Document Link:	Location on Server (if used)

© Jult St Abstrac document describes the process for variation management of key This characteristics.

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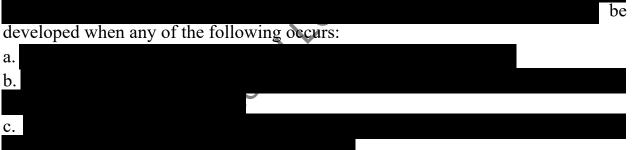
1.0 Scope

1.0 Scope
This procedure shall be applicable to all production processes that influence the variation of Key Characteristics. This procedure applies to
2.0 Applicable Documents
3.0 Requirements
3.1 Variation management activities must be real.

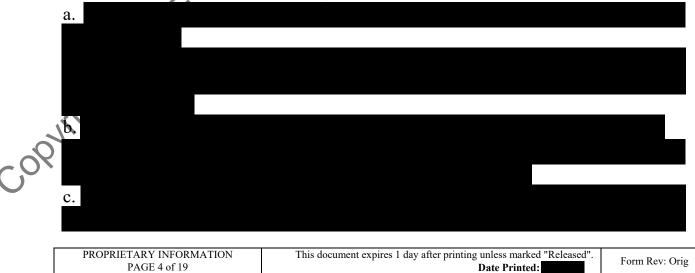
3.1 Variation management activities must be performed on identified Key Characteristics and processes

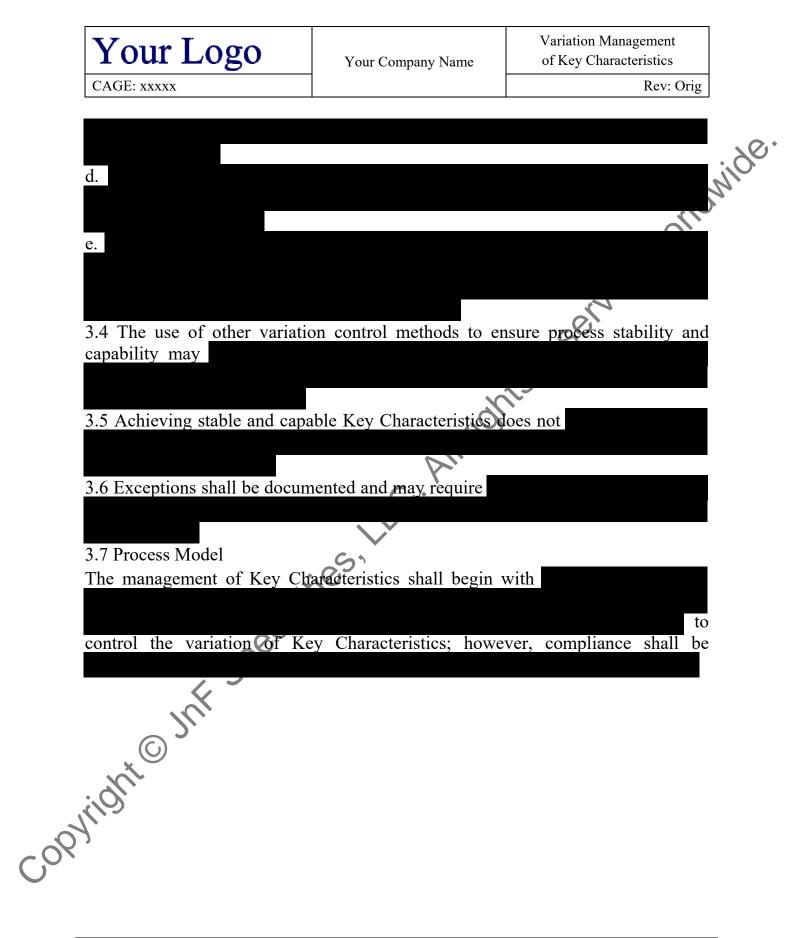
to ensure continued performance.

3.2 Appropriate documentation of Key Characteristics and manufacturing process elements that influence variation in Key Characteristics shall

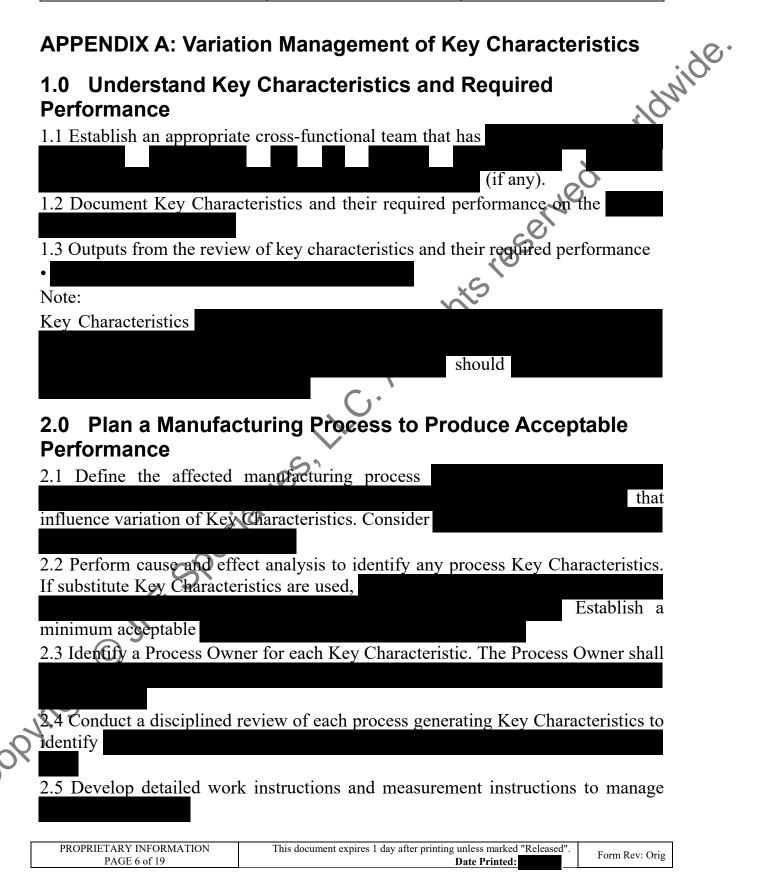


3.3 The following requirements must be met if statistical process control is chosen as the method of control for the Key Characteristic:

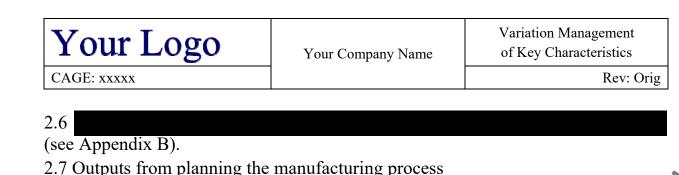


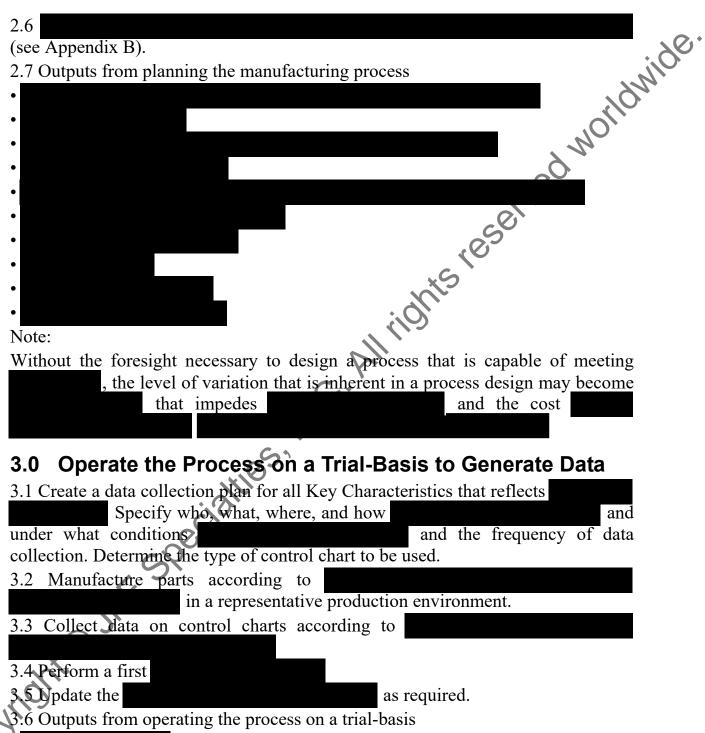


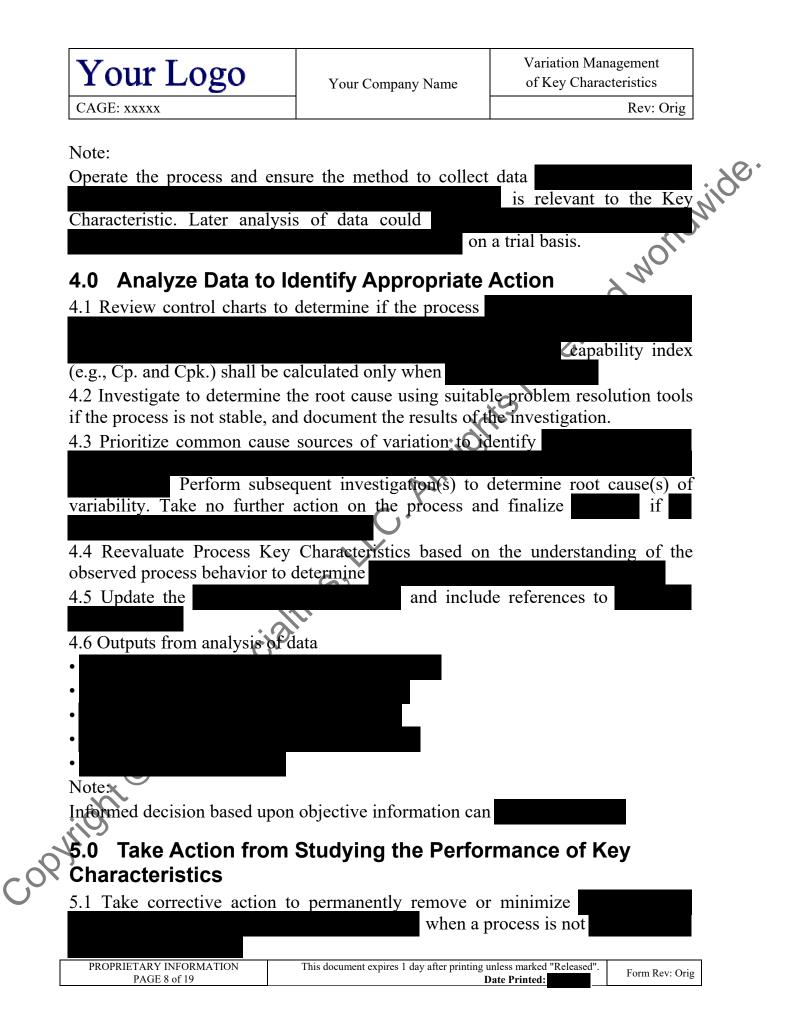
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5.2 Investigate gage variatio and	n when verify the results if		
5.3 Investigate centering of the	he process if		. 2
5.4 Take appropriate action	-	n that influence	
5.5 Implement a Product/Pro	cess protection plan until	such time	N
			after
performing5.6 A first article inspection	(FAI) may be performed	unless	
57 Talta annomista acti		that she	an a sta
5.7 Take appropriate action	on whenever actions a	ire taken that cha	ange the
5.8 Finalize the	as	soon as	
5.9 Outputs from study of the	e performance of Key Cha	racteristics	
•			
•			
•		_	
Note:			
Act upon information	that appld is	atus das as	
	that could in	troduce	
6.0 Continue to Mon	itor the Performanc	ce	
6.1 Period cally verify that the			ter a Key
Characteristic meets performance to identify	Cor	ntinue to measure	process
	. 1.	• , ,	
6.2 Continually review busin	which may resu		
and adding			
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(2 Outunts from continuing	to monitor the measure	
6.3 Outputs from continuing	to monitor the process	orld
•		
•		5
Note:		
Understanding the performa	ance of a continuous proce	ess is
	-	rimental to
	Managanant	e,
7.0 Process Change		S
7.1 Document any planned c	•	
7.2 Follow the requirements	s of paragraph 1.0 to 5.0	
Key Characteristics.		as related to the affected
7.3 Outputs from process cha	ange management	
• •		
•	C_{1}	
Note:		
	ated with data	
	if the p	rocess
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Decisions must be substantia		

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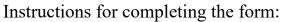
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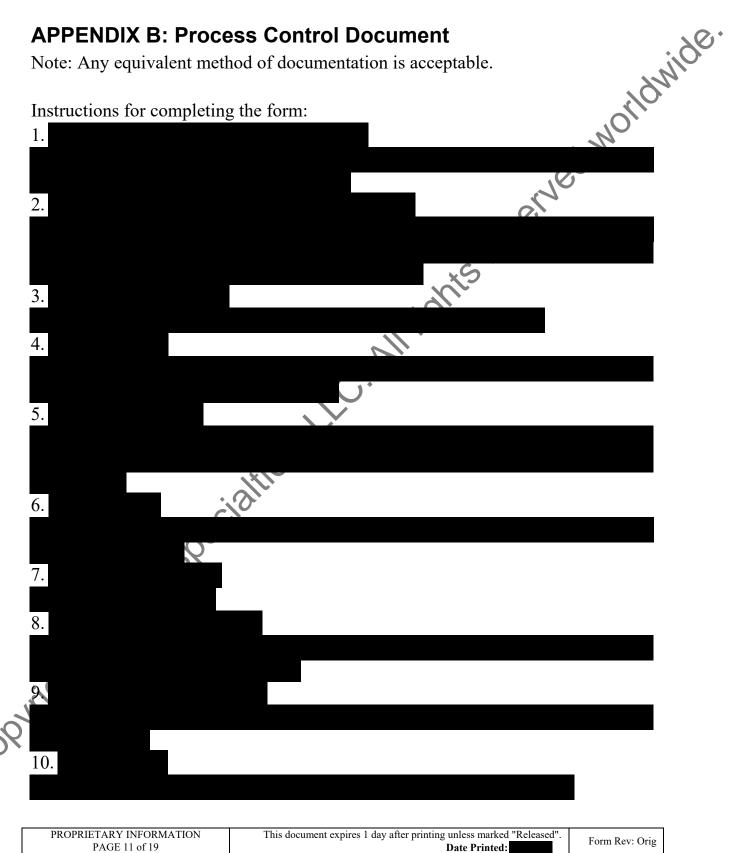
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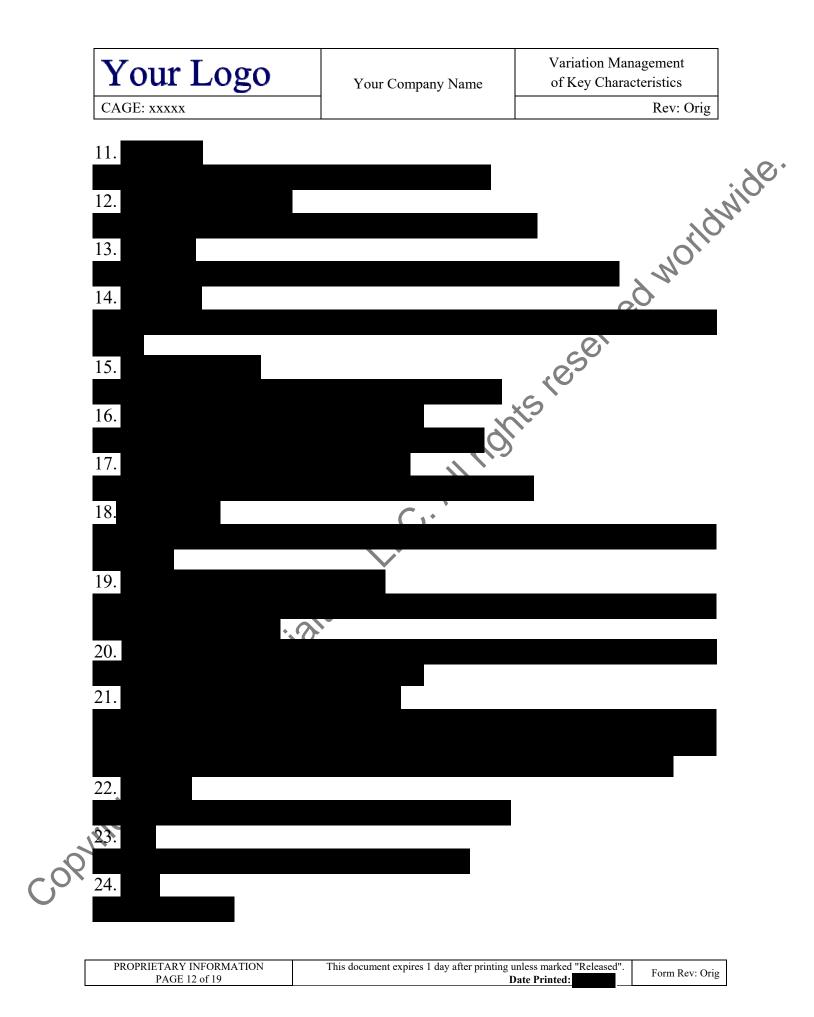


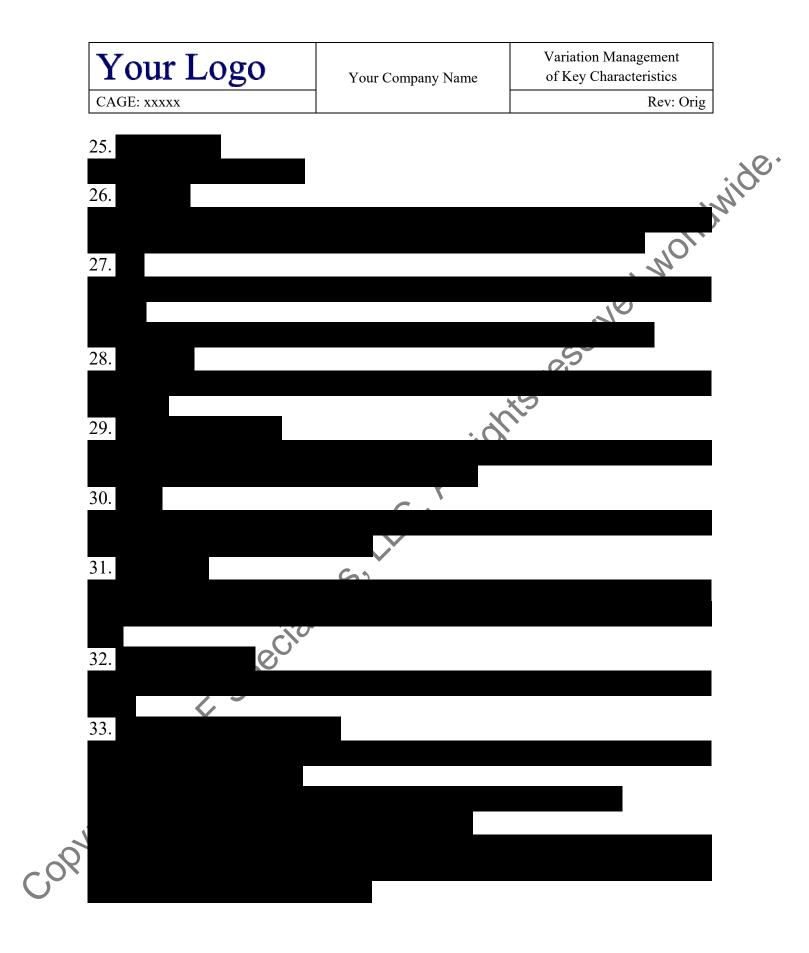
APPENDIX B: Process Control Document

Note: Any equivalent method of documentation is acceptable.

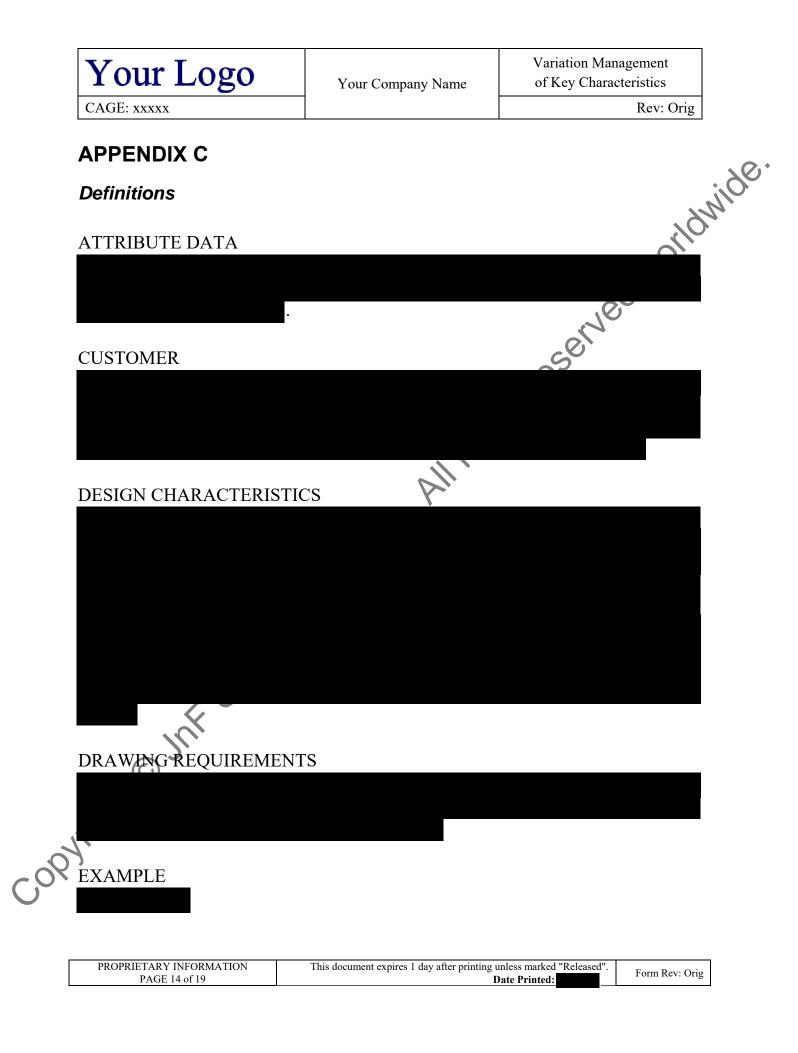








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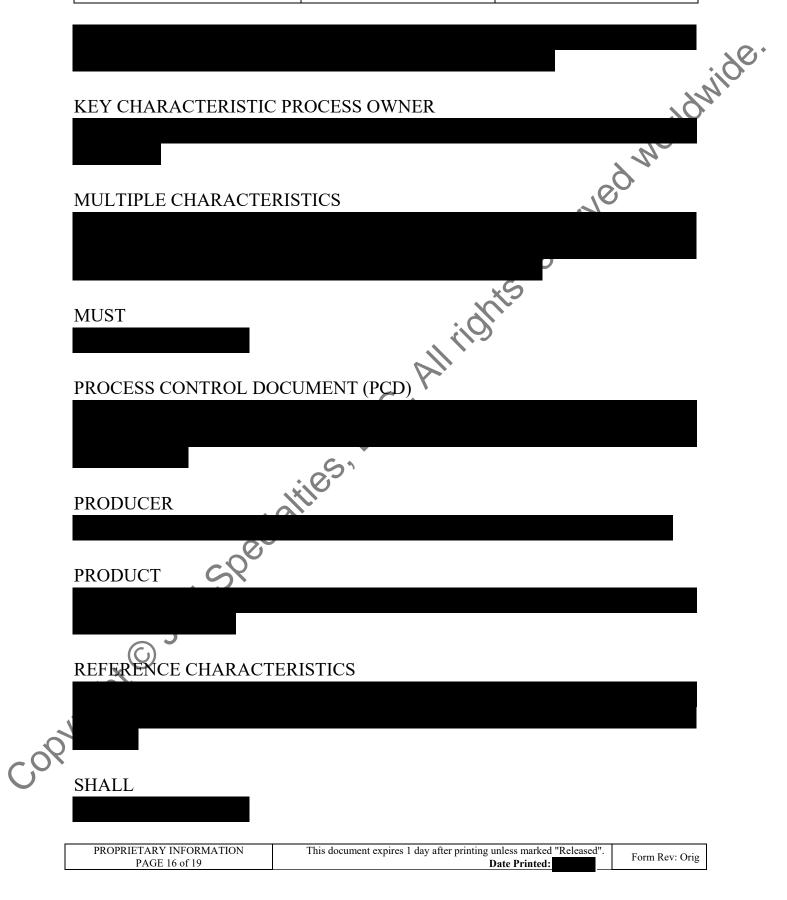


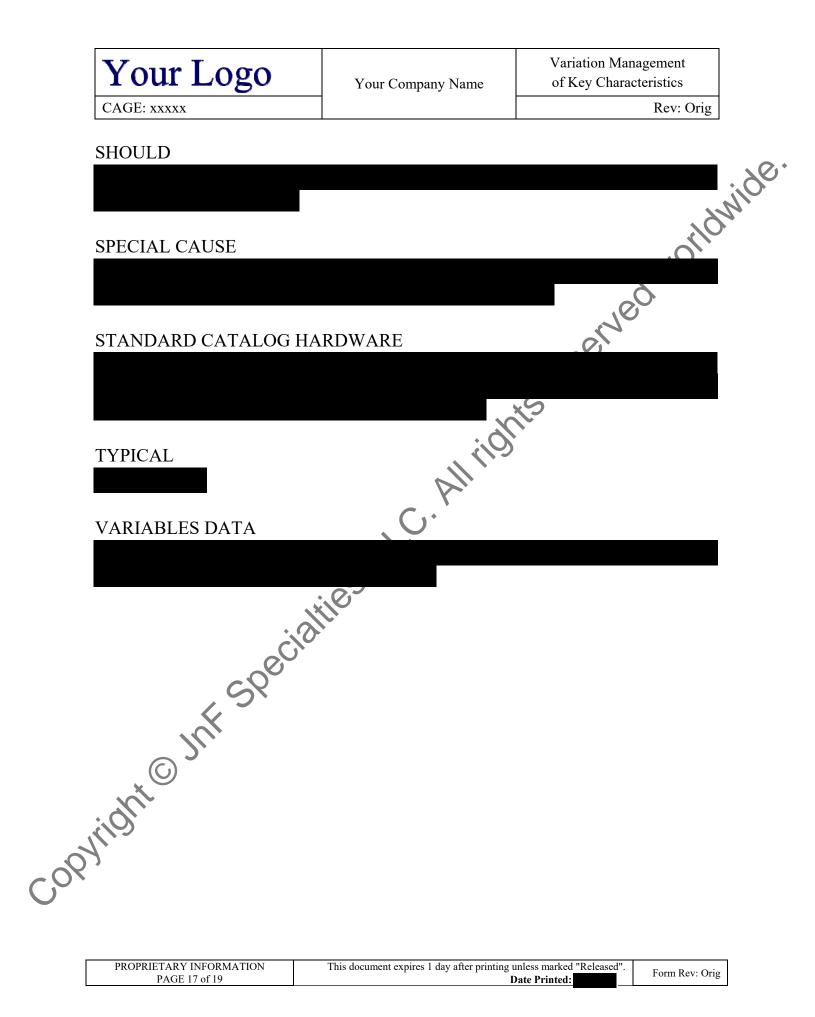
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FIRST ARTICLE INSPECTION (FAI)

d worthwide. FIRST ARTICLE INSPECTION REPORT (FAIR) reser FIRST PRODUCTION RUN PARTS C_{1} **KEY CHARACTERISTIC (KC):** This definition is further explained as follows: KEY CHARACTERISTIC OWNER









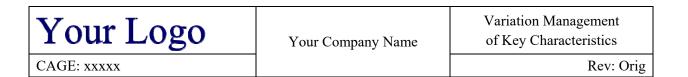
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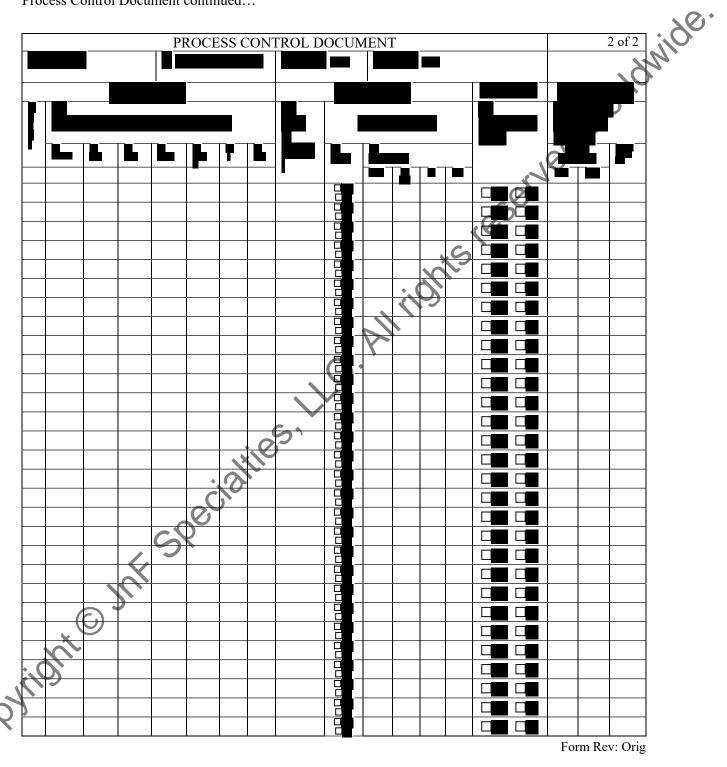
1 of 2 hide **Appendix D: Process Control Document** PROCESS CONTROL DOCUMENT Jed W \$, 35 C ٠ Г <u>É</u>Ó 0 Г Ī С

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Process Control Document continued...



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