

INSPECTION PART CLASSIFICATIONS

NOTE: RES is transitioning to a new set of Inspection Part Classifications. The Inspection Part Classification determines the sample size of the parts to be inspected for each lot of parts. Inspection Part Classifications are identified on the Purchase Order / MSR or a note on a drawing. If the Inspection Part Classification on the Purchase Order / MSR does not match the Inspection Part Classification on the drawing, the Inspection Part Classification on the Purchase Order / MSR takes precedence. In the future, Inspection Part Classifications will be identified only on the Purchase Order / MSR, not on the drawing. Legacy drawings may contain either the “Old” or “New” Inspection Part Classification. Use the chart below to identify the equivalent “New” Inspection Part Classification if the drawing lists an “Old” Inspection Part Classification.

Old Inspection Part Classification	New Inspection Part Classification
CLASS 1 PART	CLASS 1 PART (Customer specific)
CLASS 1 PART	CLASS A
Special Care Part	CLASS B
General Use Part	CLASS C

RES Inspection Sampling Plan – Normal Inspection				
Rough “CLASS A” or “CLASS 1” Parts	Total Lot Size or Each Partial Shipment	Rough “CLASS B” Parts	Rough “CLASS C” Parts	Inspection Plan
		Sample Size in Lot to Inspect **	Sample Size in Lot to Inspect **	
For prints marked as a “CLASS A” or “CLASS 1 PART”, default inspection shall be 100% of all dimensions on all parts, unless a different sampling plan is approved in advance by Roush. Inspection reports shall carry the part serialization number of each part.	1	1	1	First and Last parts are to be inspected 100% of all dimensions. 100% inspection of all dimensions are required for the sample size of parts in the lot specified in this plan.
	2 - 8	2	2	
	9 - 15	3	2	
	16 - 25	3	3	
	26 - 50	5	5	
	51 - 90	13	5	
	91 - 150	20	8	
	151 - 280	32	13	
	281 - 500	50	20	
	501 - 1,200	80	32	
1,201 - 3,200	125	50		
3,201 - 10,000	200	80		

** Includes First and Last Part in sample size. Parts should be randomly selected throughout the lot of parts.

NOTE: If a dimension/characteristic is found to be out of compliance during inspection, that dimension/characteristic needs to be inspected in the entire lot, and all nonconforming units must be removed, corrected or accepted with a deviation or waiver prior to submitting the parts to Roush.

Rough Internally Machined and Flat Laser Cut Components

Machined Components and Flat Laser Cut Components manufactured internally by Roush will be inspected to a reduced level of inspection according to the chart below or as specified by the Requestor. All other internal and external suppliers providing parts to RES are to comply with the RES Inspection Sampling Plan (normal inspection) on page 1 of this document.

RES Inspection Sampling Plan – Reduced Inspection (for Roush Internally Machined and Flat Laser Cut Components Only)				
Roush “CLASS A” or “CLASS 1” Parts	Total Lot Size or Each Partial Shipment	Roush “CLASS B” Parts	Roush “CLASS C” Parts	Inspection Plan
		Sample Size in Lot to Inspect **	Sample Size in Lot to Inspect **	
For prints marked as a “CLASS A” or “CLASS 1 PART”, default inspection shall be 100% of all dimensions on all parts, unless a different sampling plan is approved in advance by Roush. Inspection reports shall carry the part serialization number of each part.	1	1	1	First and Last parts are to be inspected 100% of all dimensions.
	2 - 8	2	2	
	9 - 15	2	2	100% inspection of all dimensions are required for the sample size of parts in the lot specified in this plan.
	16 - 25	2	2	
	26 - 50	3	2	
	51 - 90	5	2	
	91 - 150	8	3	
	151 - 280	13	5	
	281 - 500	20	8	
	501 - 1,200	32	13	
	1,201 - 3,200	50	20	
3,201 - 10,000	80	32		

**** Includes First and Last Part in sample size. Parts should be randomly selected throughout the lot of parts.**

NOTE: If a dimension/characteristic is found to be out of compliance during inspection, that dimension/characteristic needs to be inspected in the entire lot, and all nonconforming units must be removed, corrected or accepted with a deviation or waiver prior to submitting the parts to the Roush.

REVISION HISTORY

Rev #	Revision Description	Author	Approver	Date
R00	<ul style="list-style-type: none"> • New Doc. Release – Doc. Number change - Previously ENGR-08-PM. • Removed references to First Article and Production parts, incorporated qty of “1” into tables. • Clarified differences between two Inspection Sampling plans and labeled. • Deleted note with regard to partial shipments, incorporated into table. 	L. Purtill	K. Wayne	4/13/2023
R01	Updated “Inspection Part Classification” info with regard to Purchase Orders / MSRs and drawing notes.	L. Purtill	K. Wayne	10/23/2023
R02				---
R03				---
R04				---
R05				---
R06				---
R07				---
R08				---
R09				---
R10				---
R11				---
R12				---
R13				---
R14				---
R15				---
R16				---
R17				---
R18				---
R19				---