

ROUSH ENTERTAINMENT SYSTEMS INSPECTION SAMPLING PLAN

FIRST ARTICLE PARTS
100% inspection of all dimensions are required for ALL First Article Parts.*
A First Article part or assembly with supporting documentation shall be submitted to Roush Entertainment Systems for approval prior to a production run.

* If First Article contains multiple pieces of the same part number, it should be treated as a production run – first and last piece 100% inspected with the remainder following the sampling plan for inspection.

NOTE: Roush is transitioning to a new set of Inspection Part Classifications. The part classification determines the sample size of the parts to be inspected in each lot of parts and has not changed. Drawings may contain either the “Old” or “New” inspection part classification. Use the chart below to identify the equivalent “New” part classification if the drawing has not been updated yet.

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

NOTE: If a part drawing does not include a Roush Inspection Part Classification note in the notes section (legacy or customer prints), the default inspection part classification to use is “CLASS C” Parts.

PRODUCTION PARTS				
Roush “CLASS A” or “CLASS 1” Parts	Production Lot Size	Roush “CLASS B” Parts	Roush “CLASS C” Parts	Inspection Plan
For prints marked as a “CLASS A” or “CLASS 1 PART”, default inspection shall be 100% of all dimensions on all parts, unless a sampling plan is approved by the Customer and/or cognizant engineer. Inspection reports shall carry the part serialization number of each part.		Sample Size in Lot to Inspect **	Sample Size in Lot to Inspect **	
	2 - 8	2	2	First and Last Production 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. ***See below for Roush machined and flat laser cut components.
	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.

*** Machined Components and Flat Laser Cut Components manufactured by Roush will be inspected to a reduced level of inspection according to the chart below or as specified by Requestor.

PRODUCTION PARTS – Roush Machined and Flat Laser Cut Components				
Roush “CLASS A” or “CLASS 1” Parts	Production Lot Size	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 sampling plan is approved by the Customer and/or cognizant engineer. Inspection reports shall carry the part serialization number of each part.	2 - 8	2	2	First and Last Production 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.
	9 - 15	2	2	
	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.

Partial Production Shipment Sampling (continuous production run or one set-up):

Partial shipments of a Production Lot are to be inspected as follows – First, Last and a proportional percentage of the total required parts to be inspected based on the overall Production Lot size.

“CLASS B” PART EXAMPLE: Production Lot Size = 100 parts, shipped in 2 shipments of 30 and 70 parts each. Based on the chart above, 8 parts total are required to be inspected (First, Last and 6 additional parts).

Shipment 1 – Inspect First, Last, and 3 parts (30% of 8 = 2.4 parts)

Shipment 2 – Inspect First, Last and 6 parts (70% of 8 = 5.6 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 Customer.