



AEROSPACE STANDARD	AS7115™	REV. A
	Issued 2001-10 Cancelled 2017-06	
	Superseded by PRI AC7115	
National Aerospace and Defense Contractors Accreditation Program Requirements for Elastomer Seals		

RATIONALE

AS7115A is being cancelled and superseded by PRI AC7115.

CANCELLATION NOTICE

This document has been declared "CANCELLED" as of June 2017 and has been superseded by PRI AC7115. By this action, this document will remain listed in the Numerical Section of the Aerospace Standards Index noting that it is superseded by PRI AC7115. Cancelled specifications are available from SAE.

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1. SCOPE:

This Aerospace Standard (AS) establishes the requirements for manufacture of Elastomer Seals to be accredited by the National Aerospace and Defense Contractors Accreditation Program (NADCAP). NADCAP accreditation is granted in accordance with SAE AS7003 after demonstration of compliance with the requirements herein. The requirements may be supplemented by additional requirements specified by the NADCAP Elastomer Seals Task Group. Using the corresponding Audit Criteria (PRI Acs) will ensure that accredited Elastomer Seals suppliers meet all of the requirements in this standard and all applicable supplementary standards.

The purpose of this audit program is to assess a supplier's ability to consistently provide a product or service that conforms to the technical specifications and customer requirements. The corresponding audit criteria are also structured to obtain information relevant to management practices and processes that directly or indirectly affect the product or service. This information will be used in the determination of accreditation status and may be used by the supplier to guide improvements in the product or service and the associated processes.

2. REFERENCES:

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15086-0001.

AS7001 National Aerospace and Defense Contractors Accreditation Program (NADCAP)
 Program Description

2.1 (Continued):

- AS7002 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Rules for Implementation
- AS7003 National Aerospace and Defense Contractors Accreditation Program (NADCAP) – Program Operation
- AS9000 Aerospace Basic Quality System Standard
- AS9100 Quality Systems - Aerospace - Model for Quality Assurance in Design, Development, Production, Installation and Servicing

2.2 PRI Documents:

Available from Performance Review Institute, 161 Thornhill Road, Warrendale, PA 15086-7527.

- AC7115 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Audit Criteria for the Manufacture of Elastomer Seals

2.3 ISO Publications:

Available from ANSI, 11 West 42nd Street, New York, New York 10036.

- ISO 9001 Quality systems -- Model for quality assurance in design/development, production, installation and servicing
- ISO 9002 Quality systems -- Model for quality assurance production, installation and servicing

2.4 AIAG Publications:

Available from AIAG, 26200 Lahser Road, Suite 200 - Southfield, MI 48034.

QS-9000

2.5 Definitions:

AOQL: Average Outgoing Quality Limit

AQL: Average Quality Limit

BATCH: The quantity of compound run through a mill or mixer at one time.

CpK: Capability Index for a Stable Process

GQS: General Quality System

LOT: All the product from the same batch of compound processed in one continuous run and presented for manufacturer's inspection at one time.

LTPD: Lot Tolerance Percent Defective

2.5 (Continued):

MSDS: Material Safety Data Sheet

PROCEDURE: A written document under document control that defines the specific steps, processes, or services to be performed. The purpose of a procedure is to assure reproducibility of results. Procedures may reference supporting documentation in meeting this objective.

SPC: Statistical Process Control

3. QUALITY SYSTEM:

The manufacturer's quality system shall be approved to:

SAE AS9000.

4. QUALIFICATION OF PERSONNEL:

Operators and inspectors shall be qualified by at least one of the following:

- a. Training by personnel with documented training procedures
- b. Initial technical examination
- c. Periodic technical examination
- d. Periodic overcheck of work

5. WORK INSTRUCTIONS:

Work instructions shall be adequate to control the manufacturing process for the following:

- a. Function to be performed
- b. Sequence of operations
- c. Inspection points
- d. Accept/Reject criteria
- e. Tools, gauges, and inspection equipment
- f. Drawing number and revision level
- g. Workmanship criteria
- h. Inspection methods
- i. Tolerance limits
- j. Sampling plans
- k. Special drawing notes
- l. Part identification

6. STATISTICAL PROCESS CONTROL:

6.1 The supplier shall comply with Appendix A for statistical process control methods.

6.2 Key personnel and specific SPC functions shall be identified.