Work Instruction

MES-NC OASIS Training (SMRRs)

MES-NC

Purpose

Use this procedure to submit an electronic nonconformance document.

Trigger

Perform this procedure when a nonconformance requires Aerospace Systems Program MRB disposition.

Prerequisites

OASIS user name and password with access to MES-NC

Menu Path

- OASIS; Aerospace Systems, MES-NC.

Application MES-NC

Helpful Hints

For questions on usage, please contact
your Northrop Grumman Buyer

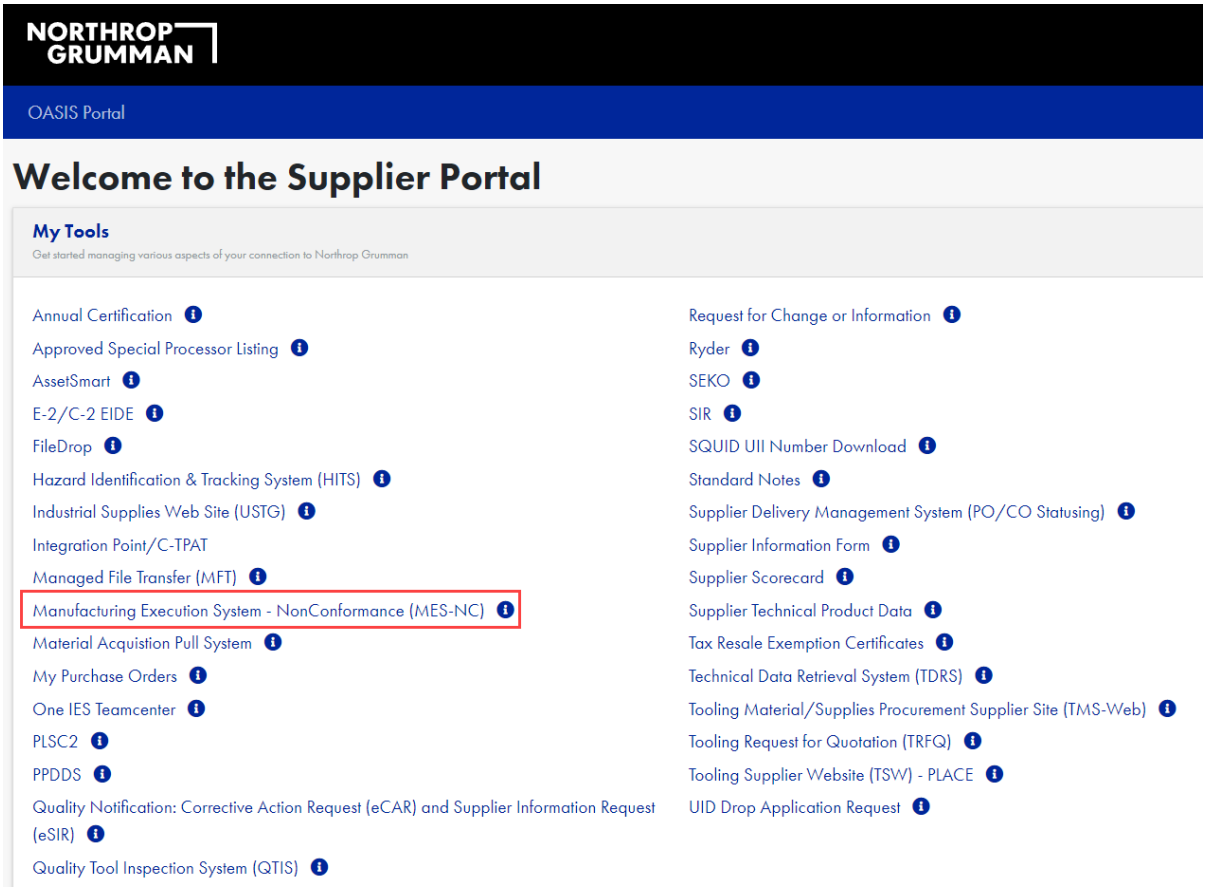
Changes to OASIS MES-NC Effective 11/24/2014: Project ID instead of Model Process Code is defaulted to X90 for Airborne sites

Procedure

1. Start the process by logging into the OASIS portal.

Please reference OASIS_Portal_FAQ.pdf (northropgrumman.com) for portal login and supplier onboarding instructions.

OASIS Portal



MES NC Home Page

2. Select the Site based on product.

Product and Site can be determined by locating the Project ID on the NGAS PO line item, and then looking it up on the Definitions and Project ID document on OASIS.

3. Select **Create NC Tag** to initiate a tag or **View Existing Tag** to see previously submitted tags.

The following steps have tables with a column titled **'R/O/C'**. The definitions are:

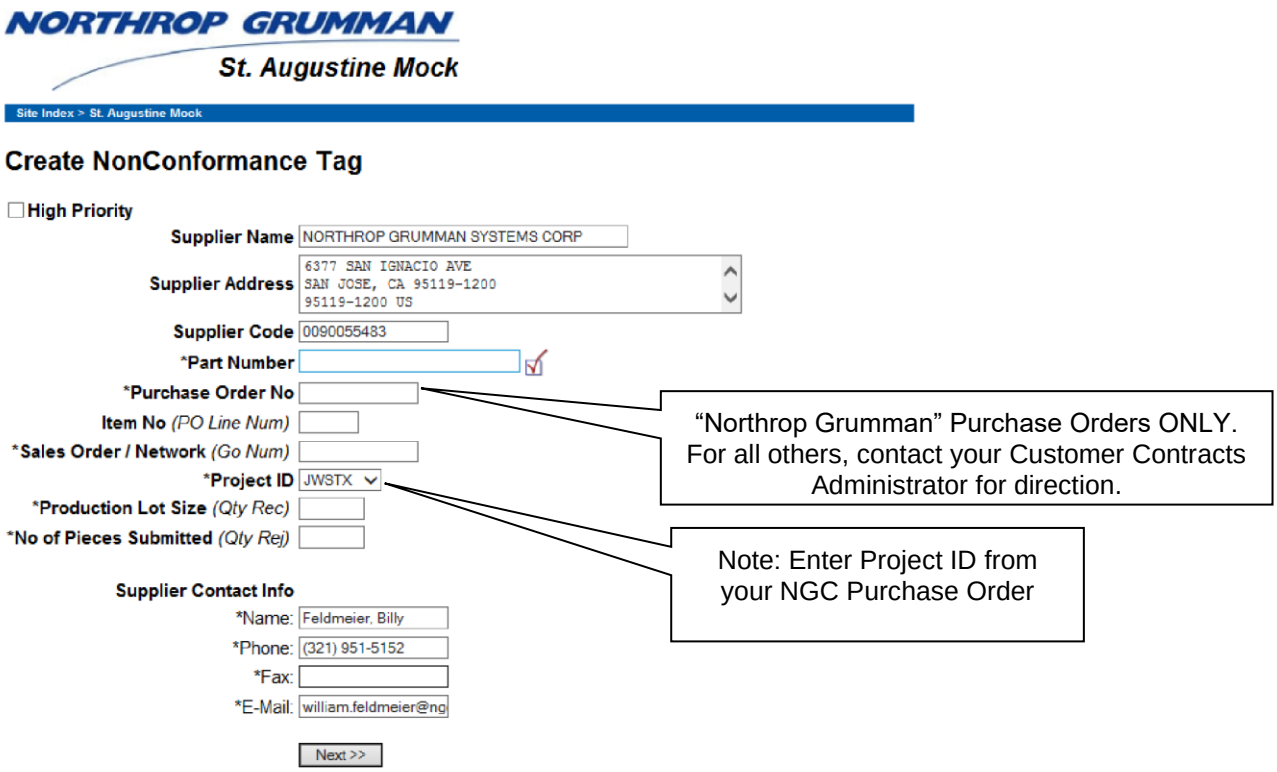
R = Required

O = Optional

C = Conditional

Additionally, all required fields are identified with an asterisk on the screen

Create Non Conformance Tag -



4. As required, complete the following required fields:

Field Name	R/O/C	Description
Part Number	R	Enter the AS Part Number from the PO. **Example:** 123BM50003-11 **Note: PO part number may be substituted with <u>detailed part</u> number with MRB Chair authorization.** **Candice Hessian (310) 332-8278 candice.hessian@ngc.com**
PO Number	R	Enter the AS PO Number. **Example:** 2846228 **Note:** "Northrop Grumman" Purchase Orders ONLY. For all others, contact your Customer Contracts Administrator for direction.

PO Item	R	Enter the PO Item number **Example:** 1

PO view of Sales Order/ Network

Item	Material/Description	Contract Delivery Date	Quantity	UM	Net Price	Extended Amount
1	123BM50003-11 SHIM		0	EA	127.50	765.00

Priority Rating: DOA1

Shipping Instructions: SCATS

Material Revision Level: 123BM50003-11,B01

SQAR CODE:
E

MATERIAL TEXT:
Go to OASIS and Retrieve the Appropriate Technical Data Package (TDP)

PROJECT ID: E2DXX - E-2D

US Government Prime Contract Number: N00019-13-C-9999

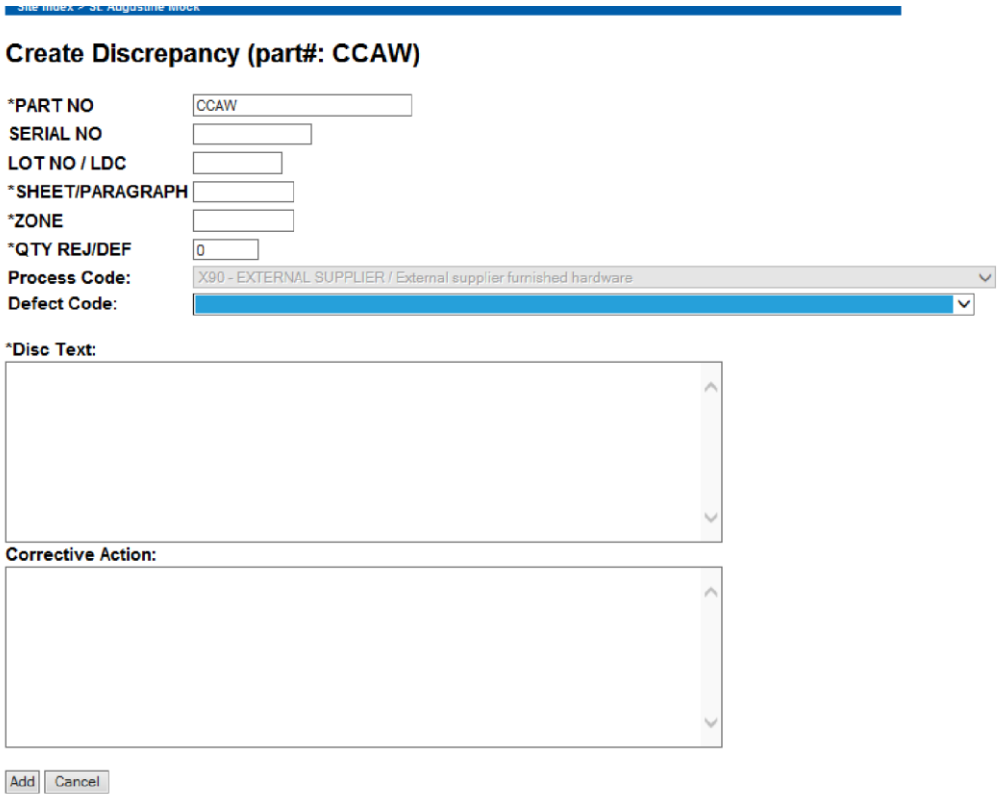
CHARGE NUMBER TEXT:
CONTRACT:N00019-13-C-9999
NETWORK:KB2260701
ACTIVITY:3360
QUANTITY: 1.000
CONTRACT:N00019-13-C-9999

Sales Order/ Network (Go Num) Network	R	Enter the Network from the PO line item (see picture above, underlined in red) Example: **KB2260701**
Project ID	R	Select the Project ID from PO (see picture above) Example: **E2DXX**
Production Lot Size	R	Enter the number of parts on the shop order or your lot size Example: **1**

No. of Pieces Submitted	R	Enter the total quantity of discrepant parts being submitted for NGAS Material Review Example: **1**

Supplier Contact Info		
Name	R	Enter the name of person to contact if there is a question from NGAS MRB Example: **John Smith**
Phone	R	Enter the phone number of person to contact if there is a question from NGAS MRB Example: **(999) 999-9999**
Fax	R	Enter the FAX number of person to contact if there is a question from NGAS MRB or if documents need to be transmitted Example: **(888) 888-8888**
E-Mail	R	Enter the email of person to contact if there is a question from NGAS MRB or if documents need to be transmitted Example: **jsmith@somewhere.com**

Create Discrepancy #1



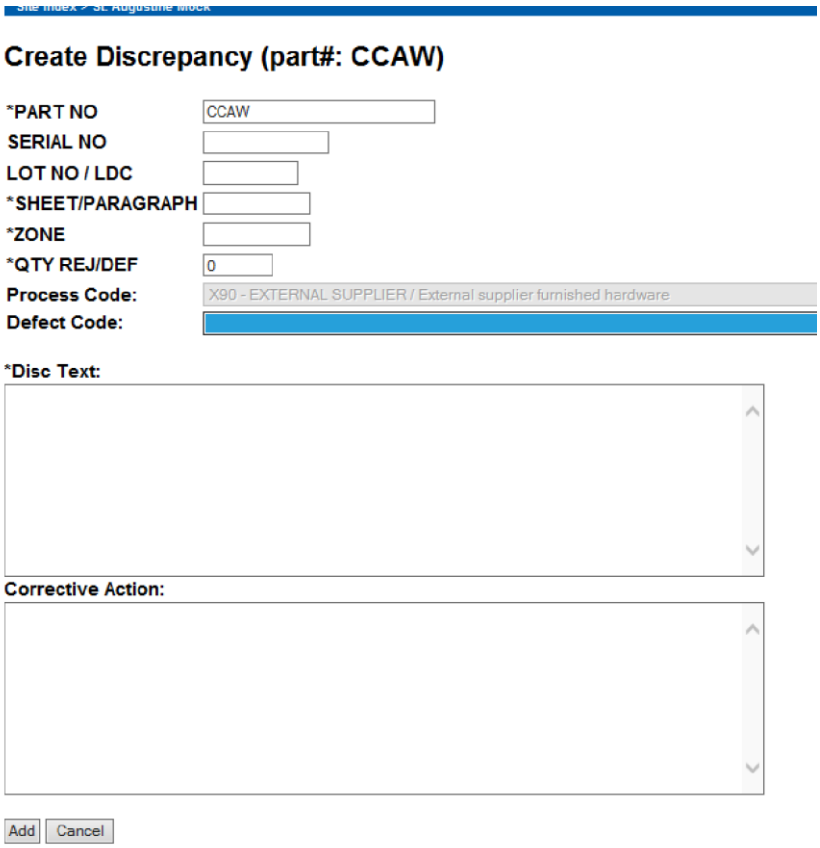
5. As required, complete/review the following fields:

Field Name	R/O/C	Description
Part No.	R	This field will be filled with the part number from the first screen. If the hurt part is different, then enter it here. Each discrepancy may have a different part number, as long as it is a detail of the PO part number on the first screen

Serial No.	O	Enter serial number; if applicable This field is small. If you are submitting the same nonconformance for all serial numbers, then put the serial numbers in Disc. Text. If each serial number has a different discrepancy, then load serial numbers individually; per discrepancy **Example:** S0001 or N/A

Field Name	R/O/C	Description
Lot No.	O	Enter Lot Number; if applicable If multiple lots, see comments on Serial Number above for input strategy. **Example:** 444444 or N/A

Create Discrepancy #1



6. As required, complete/review the following fields:

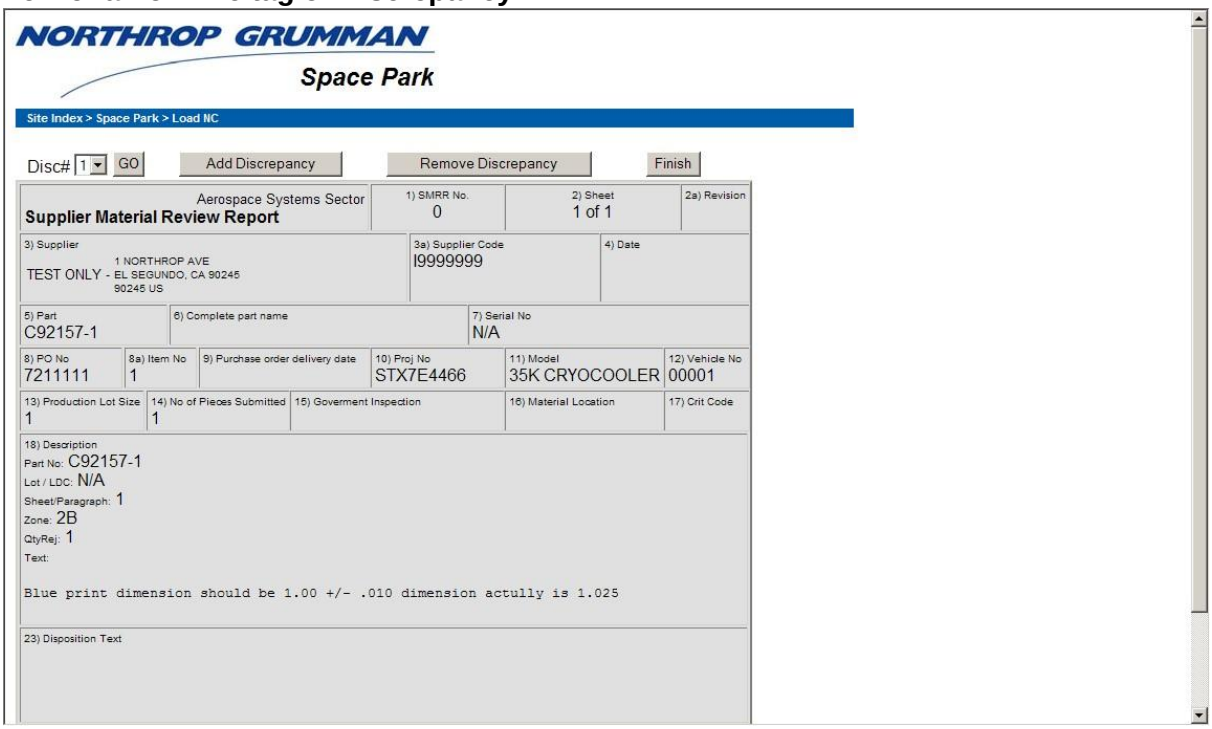
Field Name	R/O/C	Description
Sheet/ Paragraph	R	Enter the drawing sheet number where discrepant dimension appears **Example:** 1 **Note:** Enter N/A if not applicable
Zone	R	Enter drawing zone of above sheet **Example:** 2B **Note:** Enter N/A if not applicable

QTY REJ/DEF	R	Enter quantity of parts for this discrepancy. Remember the input strategy being used, one per or multiple parts **Example:** 1
Field Name	**R/O/C**	**Description**
Process Code	R	Airborne Sites are defaulted to “X90 External Supplier”. For Space Products select the appropriate category **Note:** Based on the Site selection from the home page Airborne or Space Process Codes will be presented.
Defect Code	R	Select the appropriate defect code from the pull down list using the defect definitions provided. **Example:** 2130-Dimensional/ Part characteristics are out of tolerance
Disc. Text	R	Enter the discrepancy using the Should Be per drawing dimension and **Example:** S/B 1.000 +/- .010 IS condition of part(s) 1.025 **Note:** Appendix A contains guidance on Discrepancy Definition and Information Needed for NG engineering to perform the analysis and disposition determination.
Corrective Action	O	Add a corrective action statement specifying the root cause and actions taken to prevent recurrence.

7. Click on 

for the first discrepancy.

View of an on-line tag of Discrepancy #1

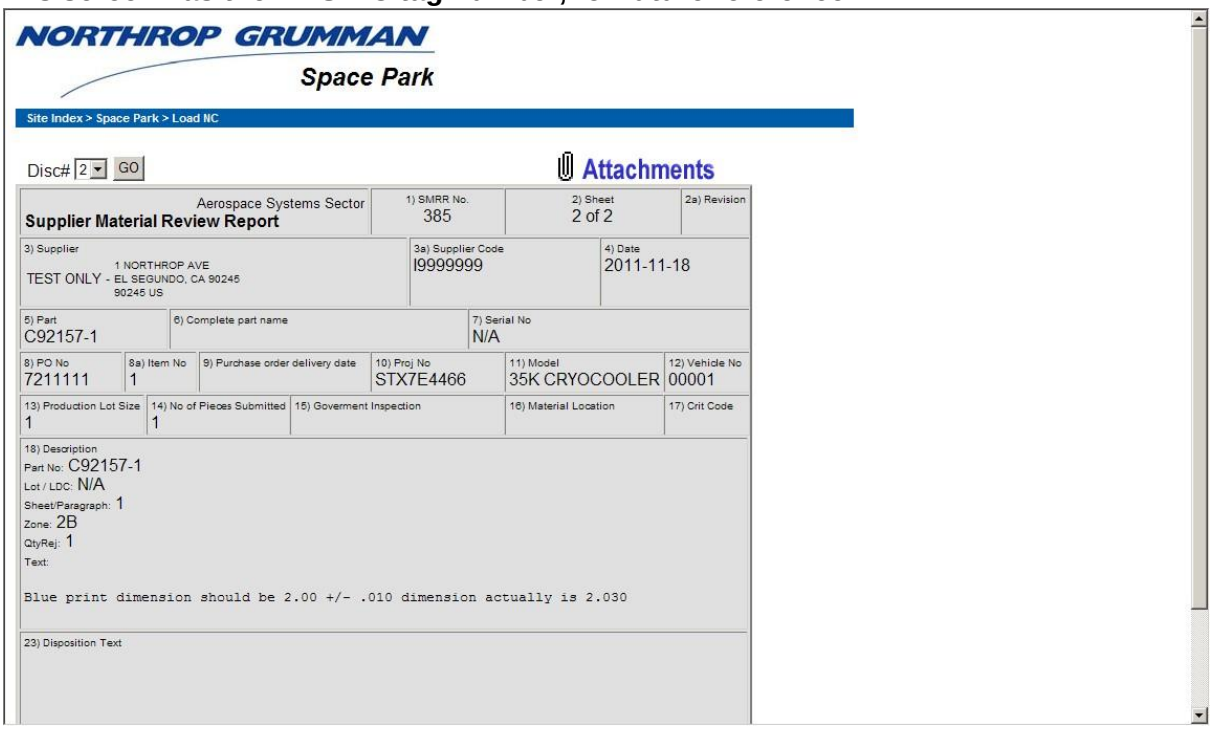


8. Click on the appropriate button to create each additional discrepancy (repeat steps 5 & 6) or remove one with the Remove Discrepancy button.

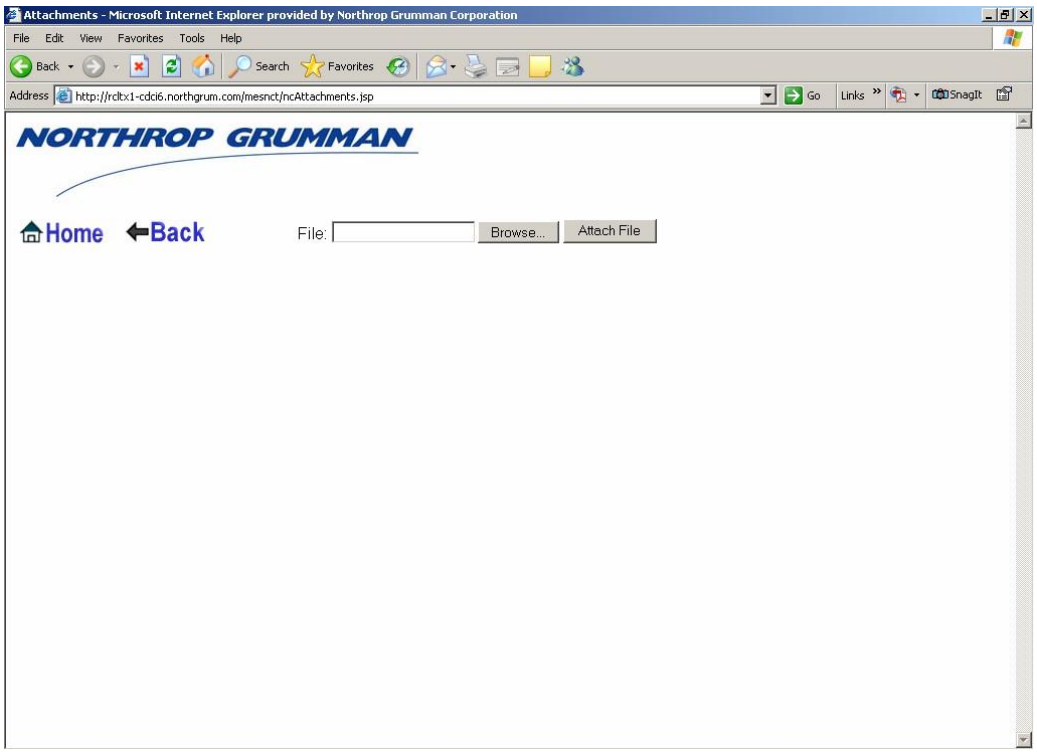
Click on the Finish button when you are done entering data.

System message displays. Click OK to continue.

This screen has the MES-NC tag number, for future reference

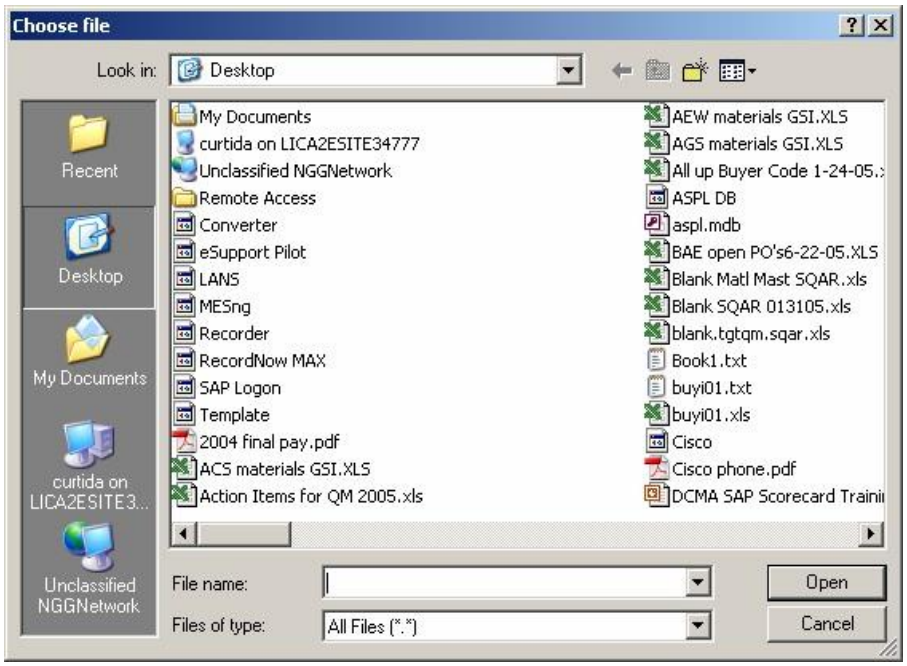


9. If you have an attachment to submit, click Attachments to include sketches/graphical files. The file types allowed in MES-NC are; .gif, .bmp, .jpg, .tif, .tiff and .pdf.

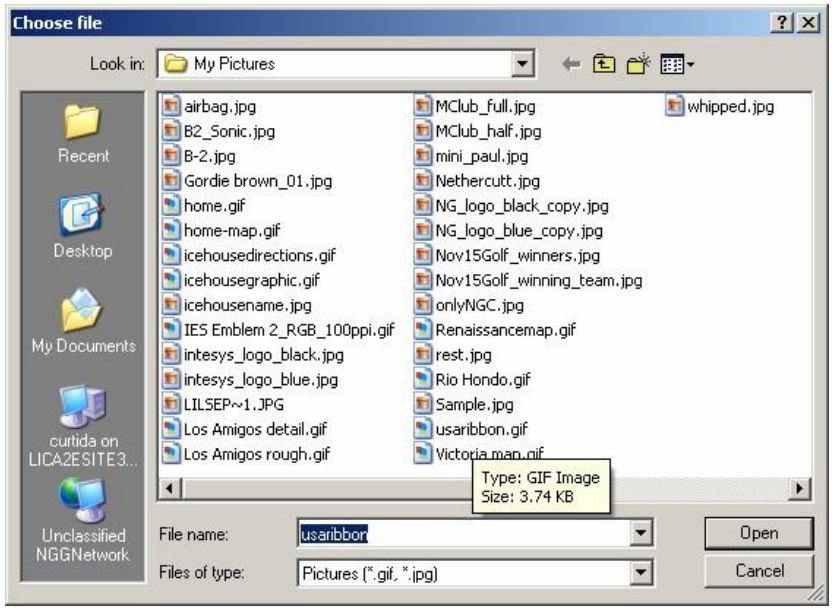

Attachments - Microsoft Internet Explorer provided by Northrop Grumman Corporation
File Edit View Favorites Tools Help
Back Search Favorites
Address http://rcltx1-cdci6.northgrum.com/mesnct/ncAttachments.jsp
Go Links SnagIt
NORTHROP GRUMMAN
Home
Back
File:
Browse...
Attach File

9.1 Click on 
Browse...

Choose file from your computer or server



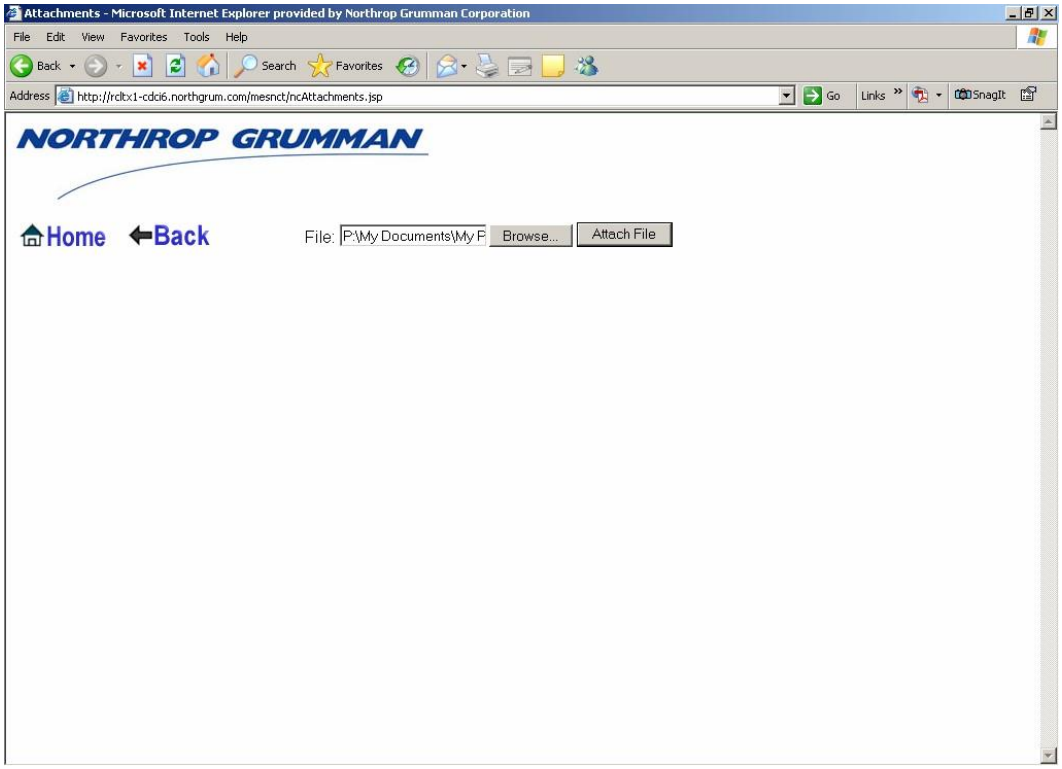
Choose file



Click on a file to attach, 

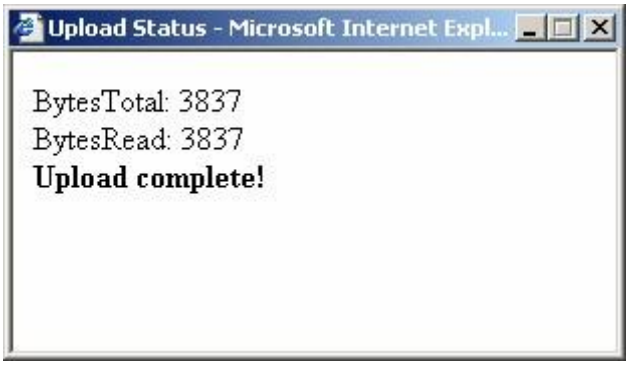
10. Click 

Attachments



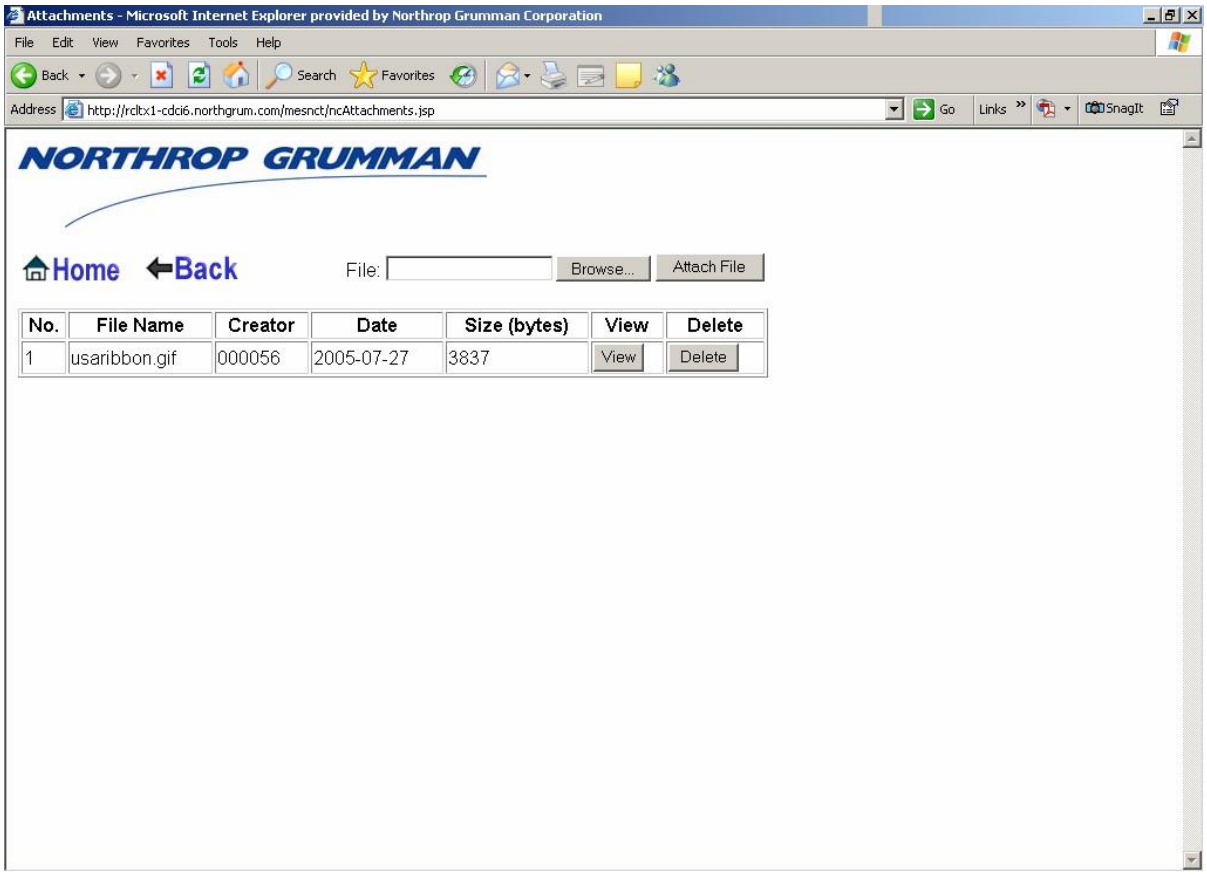
11. Click 

Upload Status will display when completed



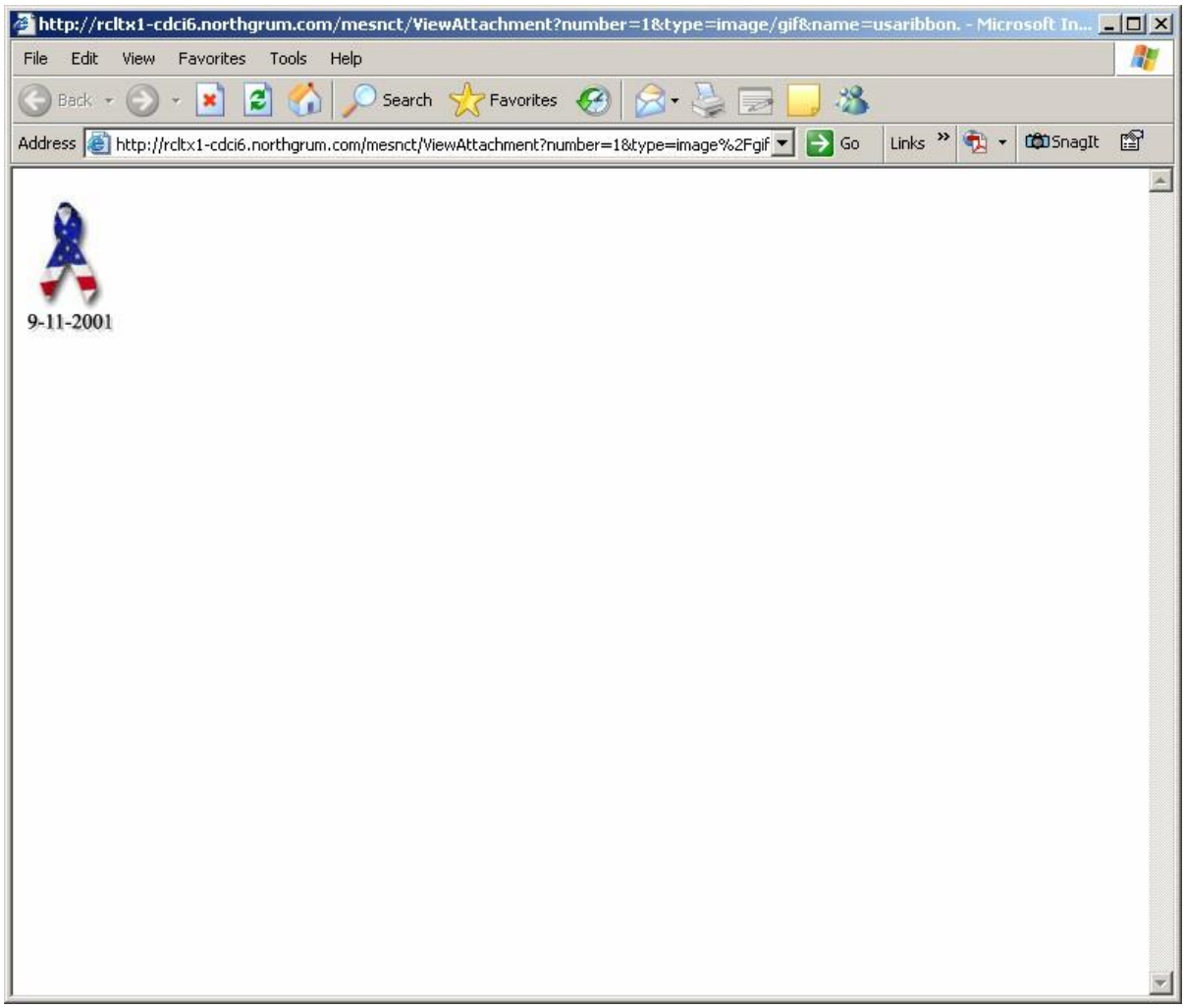
12. Click X to close

Attachments



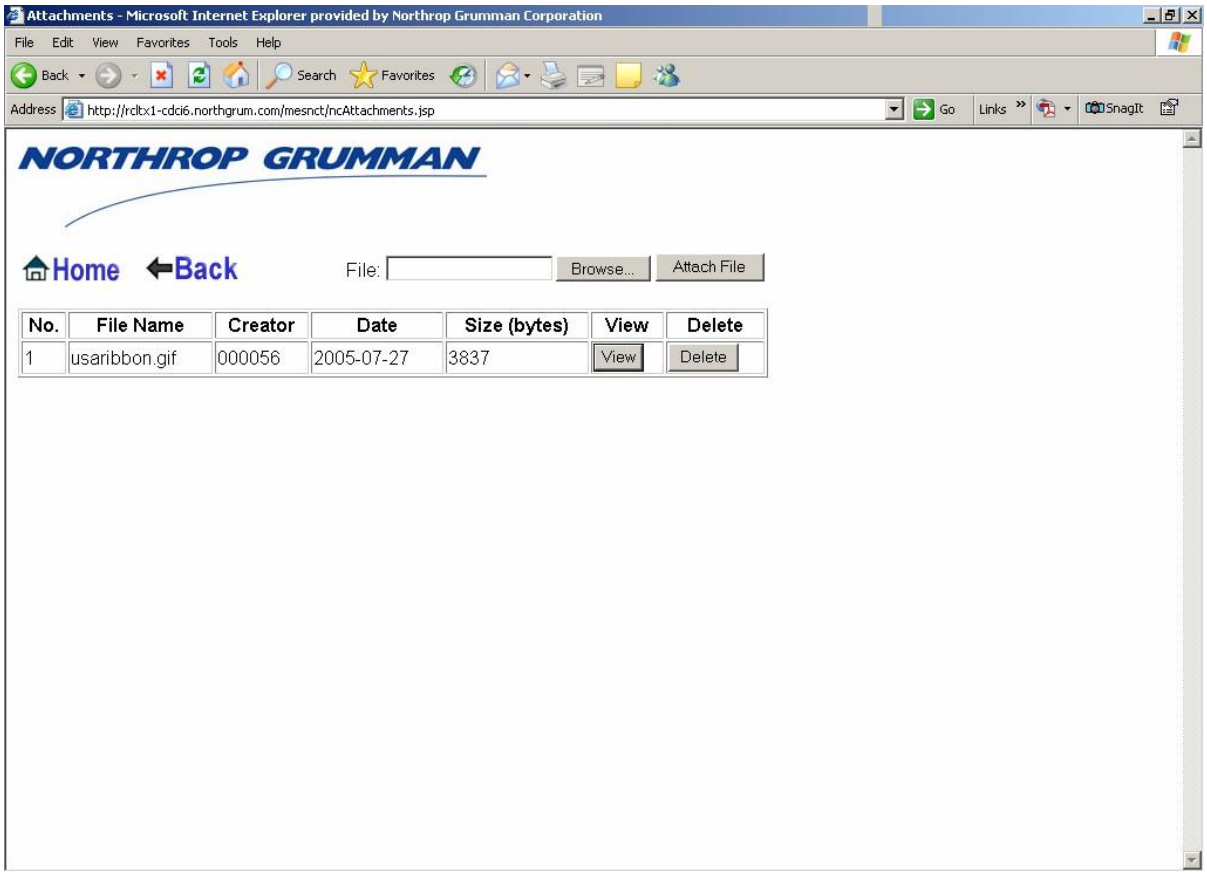
13. Click View To verify the correct file is attached. If any other files require attaching, repeat steps to add additional attachments.

View of attached file



14. Click X to close view window.

Attachments



15. When done attaching all files; Click Back

SMRR

NORTHROP GRUMMAN
Space Park

Site Index > Space Park > Load NC

Disc# 1 GO

Attachments

Aerospace Systems Sector **Supplier Material Review Report**	1) SMRR No. 385	2) Sheet 1 of 2	2a) Revision

3) Supplier	3a) Supplier Code	4) Date
1 NORTHROP AV TEST ONLY - EL SEGUNDO, CA 9024 90245 US	I9999999	2011-11-18

5) Part	6) Complete part name	7) Serial No
C92157-1		N/A

8) PO No	8a) Item No	9) Purchase order delivery date	10) Proj No	11) Model	12) Vehicle No
7211111	1		STX7E4466	35K CRYOCOOLER	00001

13) Production Lot Size	14) No of Pieces Submitted	15) Goverment Inspection	16) Material Location	17) Crit Code
1	1			

18) Description
Part No: C92157-1
Lot / LDC: N/A
Sheet/Paragraph: 1
Zone: 2B
Qty/Rej: 1
Text:

```
INITIATOR: Casey, John
PHONE: (321) 951-6038
FAX: (321) 752-8500
E-Mail:
john.casey@ngc.com

Blue print dimension should be 1.00 +/- .010 dimension actully is
1.025
```

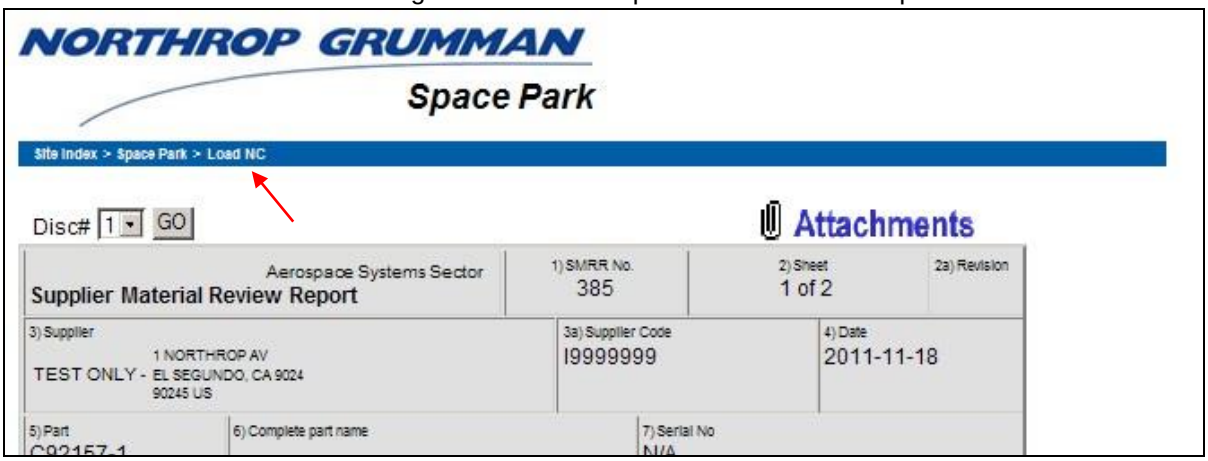
23) Disposition Text

25) Corrective Action

29) Disposition Accomplished (Supplier Inspection Supervisor)

Now would be a good time to print the document for future reference. The document will not be

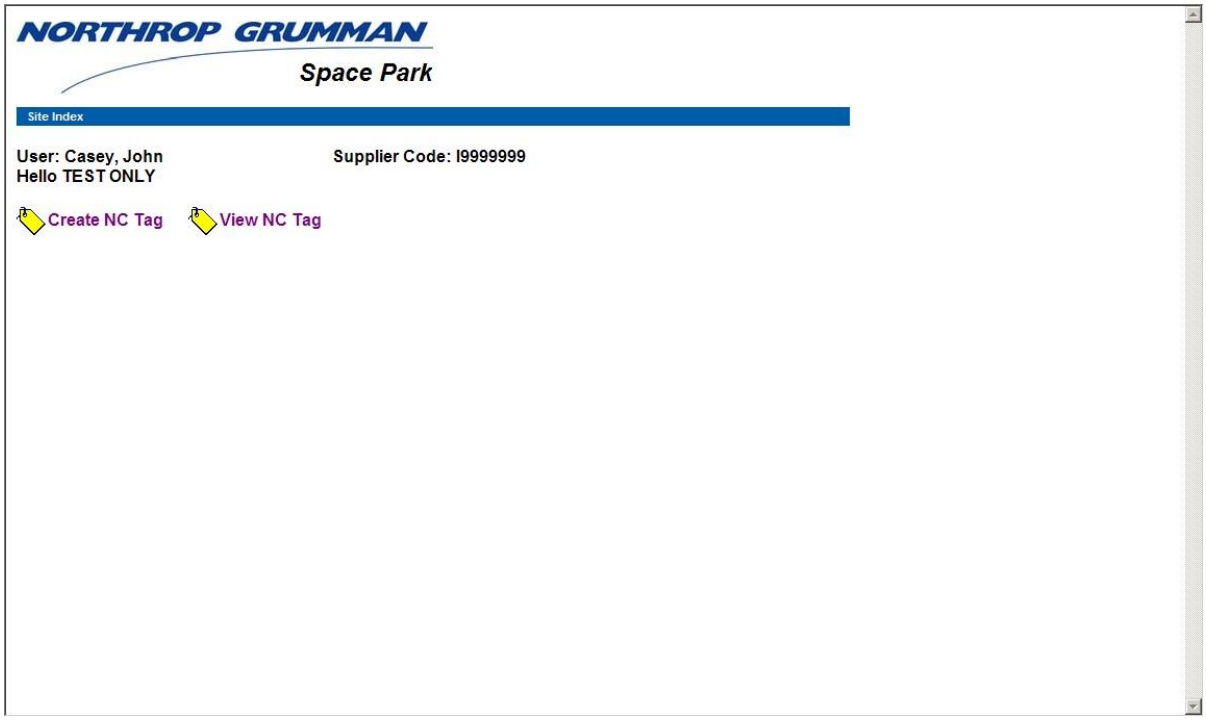
viewable once NGAS starts working on it and until disposition has been completed.



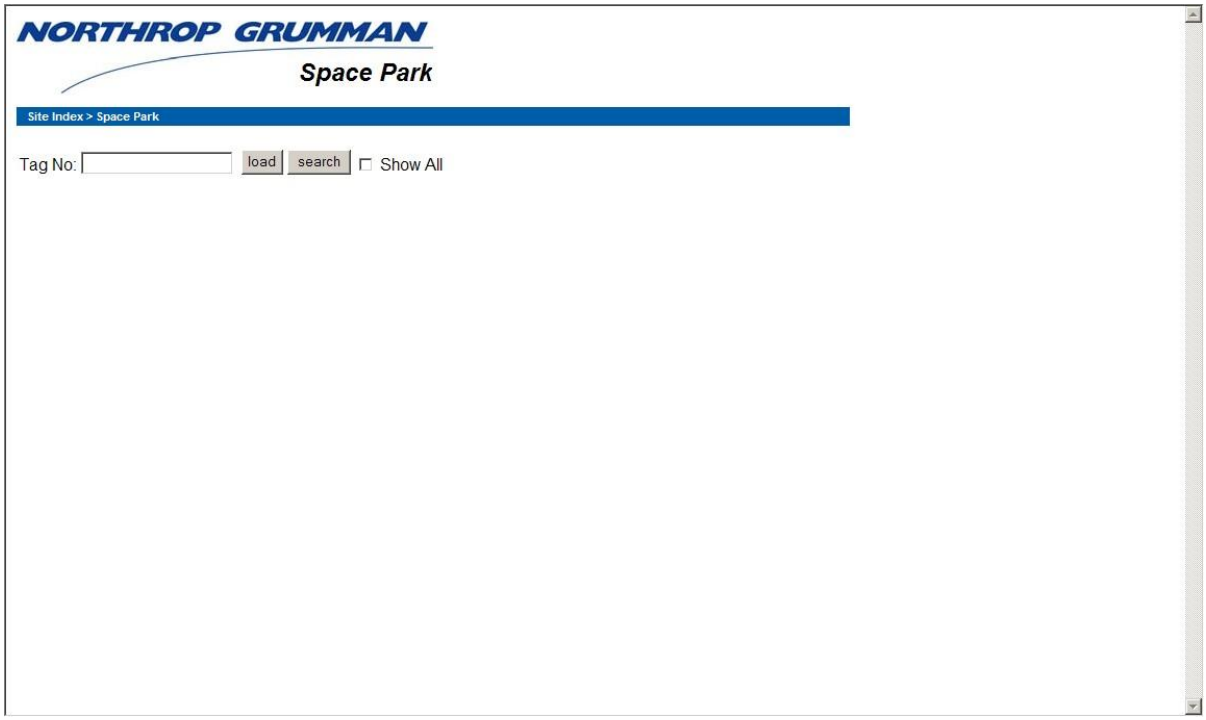
16. Use Hyperlinks on Title bar to navigate

MES NC Home Page

The following are instructions for viewing a previously submitted tag and statuses.
Click the Site where tag was submitted.



17. Click “View NC Tag”



18. Enter Tag Number or click search button search all active tags

Search Results

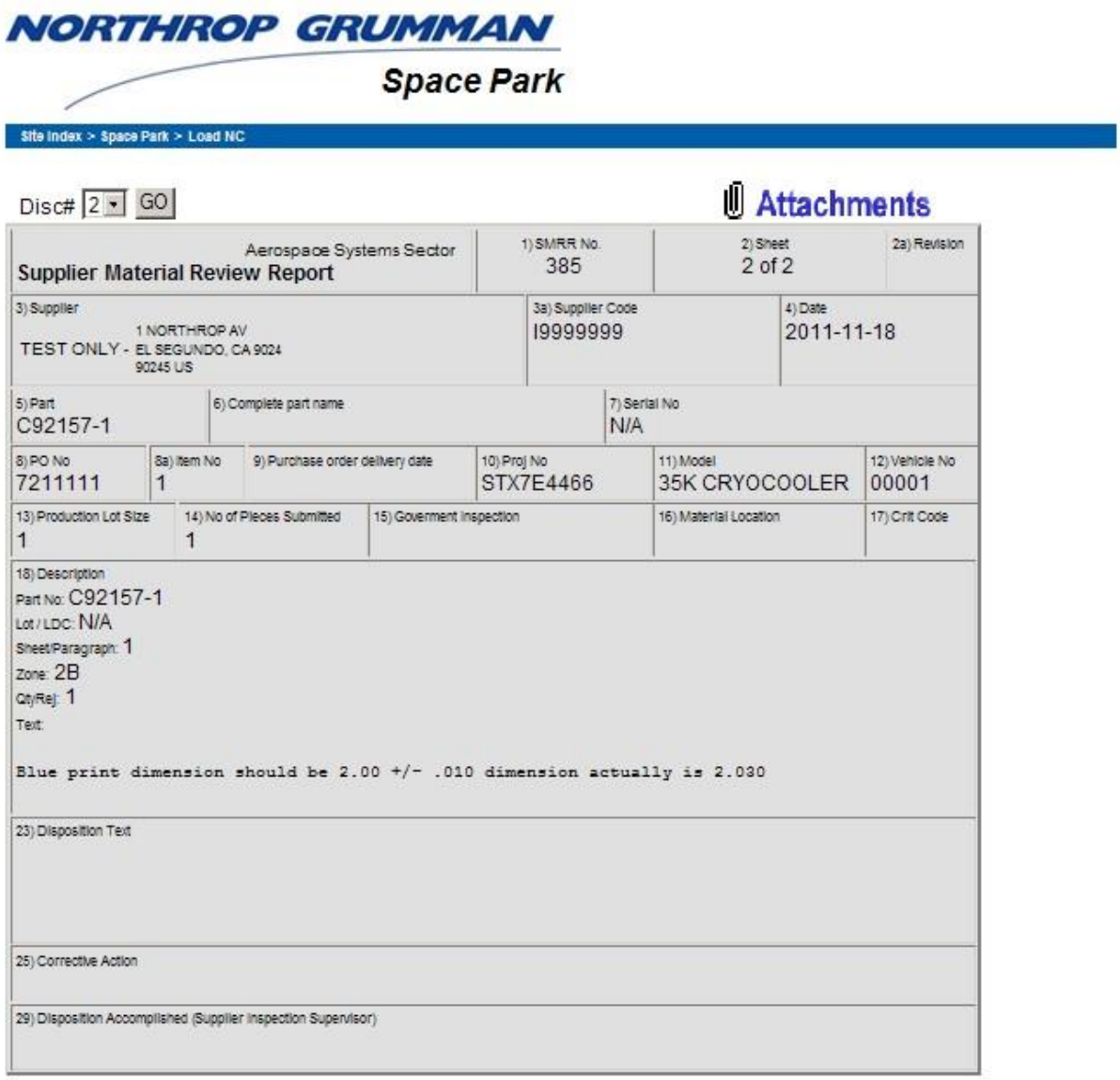
NORTHROP GRUMMAN
Space Park

Site Index > Space Park

Tag No: load search Show All

Tag No	Status	Date	Model	Part No	Callboard	Call Date
124	MF	2011-10-18	DSV	2A142-221V-001	SUPPLIERWEB	2011-11-07
143	PR	2011-10-20	DSV	2A142-221V-001	PQE PR	2011-11-18
201	EN	2011-10-28	ARGON	C923157-1	ENGINEERING	2011-11-22
233	PR	2011-10-31	4171	C923157-1	SUPPLIERWEB	2011-11-15
237	EN	2011-11-01	P982	ALH545-011K-001-802	ENGINEERING	2011-11-01
238	PR	2011-11-01	B2	ALH545-011K-001-802	PQE PR	2011-11-18
263	EN	2011-11-02	P982	FI80969-2	ENGINEERING	2011-11-08
271	EN	2011-11-02	P982	DC931015-1	ENGINEERING	2011-11-14
274	PR	2011-11-02	JAGUAR	FI80969-2	PQE MRB	2011-11-21
276	MR	2011-11-02	P982	F180969-2	PQE MRB	2011-11-22
277	EN	2011-11-02	JWST	FI80969-2	ENGINEERING	2011-11-04
278	EN	2011-11-02	JWST	000066	ENGINEERING	2011-11-05
284	PR	2011-11-04	AEHF	ALH545-011K-001-802	PQE PR	2011-11-21
305	MR	2011-11-07	AEHF	01AN00102N01-800	PQE MRB	2011-11-21
321	PR	2011-11-08	AEHF	775705-3-200	PQE PR	2011-11-21
322	MR	2011-11-08	AEHF	2A142-221V-001	PQE MRB	2011-11-21
345	EN	2011-11-09	AEHF	1A124-001U-001	ENGINEERING	2011-11-10
351	PR	2011-11-10	P982	DC931015-1-900	ENGINEERING	2011-11-10
385	II	2011-11-18	35K CRYOCOOLER	C92157-1	SUPPLIERWEB	2011-11-18

19. Select tag to review **Tag is displayed**



When a tag has a disposition applied it will be displayed in the Disposition Text field

Definition of tag status for each tag is displayed. An error will occur stating ‘cannot load’ for any status as indicated below with a No.

Code	Definition	Viewable by supplier	Acceptable to Ship
II	Inspection Initiate	Yes	No

MC	Manufacturing concurrence	No	No
PR	Preliminary Review	No	No
MR	Material Review	No	No
EN	Engineering Material Review	No	No
CU	Customer	No	No
MF	Manufacturing rework	Yes	No
CL	Closed	Yes	Yes
IS	Inspection supersede	No	No
VD	Void	Yes	No
ID	Interim Disposition	Yes	No
SI	Special Installation	No	No

Note: supplier is only authorized to ship with a CL "Closed" status unless directed by MRB and/or Buyer

Result

You have a permanent record in OASIS/ MES-NC for this deficiency. You may inquire this record at any time.

Comments

None

Appendix A- Guidance on Discrepancy Definition and Information Needed

General Requirements for Discrepancy Definition

Part Number

Part Title

Part Description

LH / RH

Upper / Lower

The following supplemental information will aid in the analysis for a proper disposition and enhance the tag turnaround time. Sketches and photographs with clear accurate annotations are encouraged and may be necessary to adequately transmit a through description of discrepancies.

Location

- Dimension from Drawing Hole
- Dimension from Cut-Out
- Station and Chord (Composites)
- OML / IML (Wing-Composites)
- Dimension from EOP (Composites)
- Dimension from Ply Drop (Composites)

Photographs

- Focus
- Clear
- Axes/Orientation

Sketches

- Clear
- Axes
- Reference Points/Orientation
- Scale (as necessary)

Appendix A- Guidance on Discrepancy Definition and Information Needed

Additionally, for the defect types highlighted below the specific information needed is also key in expediting the proper disposition:

Defect Type	Defect-Specific Information Needed			
HOLES				

Extra Hole	Actual Size	Minimum Edge distance and Pitch distance		
Short edge distance	Minimum Edge distance and Pitch distance	Actual part thickness		
OOT Holes	Elongated or True and Round?	Actual Size (Max/Min for elongated)	Minimum Edge distance and Pitch distance	
Double Drilled Holes	Pitch distance or Max width if intersected		Minimum Edge distance and Pitch distance	
Deep countersink	De pth	Fastener	Actual part thickness	
COMPOSITE SPECIFIC				
Delamination	Length X Width X Depth	Distance to edges	Distance to nearest fasteners	
Fiber Splitting	Length X Width	Ply Depth		
Unbonds	Length X Width X Depth	Distance to edges	Distance to nearest fasteners	
Fiber orientation error	Ply type	Ply # affected and/or OML vs. IML		
Missing plies	Ply type	Ply # affected and/or OML vs. IML		
Torn Copper Mesh	Length X Width	Distance to edges	Distance to nearest fasteners	Is NDI acceptable?
Porosity	Length X Width	Depth, if determinable	dB level to penetrate, if subsurface	
GENERAL				
Gouges	Length X Width X Depth	Distance to edges	Distance to nearest fasteners	Is NDI acceptable?
Indentations	Length X Width X Depth	Distance to edges	Distance to nearest fasteners	Is NDI acceptable?
Misplaced parts	Amount and direction of mis-location	Edge distances and pitch distances		
Electrical Conductivity OOT	Actual conductivity			
OOT Trim	Edge distances on affected fasteners			

Interference	Length X Width X amount of interference			