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Editors

Phil Keown
Mark D. Aubele
James E. Bennett
Louise Belak

From the Chair

The Baseline Checklists for NDT are nearing completion having been accepted by the Task Group and the Supplier representatives present at the January Task Group meeting in California, USA. During the sometimes spirited discussions that were reminiscent of meetings from the early 90's, there was little, if any, dissent from the Supplier representatives numbering close to 50 during the week. It was agreed upon by most that the time for the Baselines had come and those issues considered raising the bar were not significant enough to overshadow the fact that we were finally nearing a single aerospace standard for NDT. There will be Prime supplements to address those items where consensus could not be achieved but these supplements are anticipated to be few in number and short in content. There was positive feedback from all involved, lauding the process, the outcome, and the fact that we were bringing the Baseline initiative to fruition.

Also included in this meeting was the second edition of the Supplier Symposium. Again, the feedback was very positive from the Supplier representatives and the Task Group members in attendance. There were many suggestions for the next round showing that there is definite backing for this to become a regular agenda item for future meetings. As it is, there are plans for symposia at the April meeting in Beijing and the July meeting in Madrid. The content is adjusted for the anticipated audience to try to make the presentations meaningful whether the attendees are first time participants or veterans of the program. We look for Supplier feedback to help us ensure that relevant topics are presented and the content answers the most frequently asked questions. My sincerest thanks to Mark Aubele and Jim Bennett for, as expected, presenting a world class session. Their knowledge, patience and enthusiasm made for a most enjoyable and informational symposium.

I know that the meeting being held in Beijing will be a challenge for many Suppliers, but it is important to maintain continuity as we bring the Baselines to completion. Also, it will be a great help to have a strong Supplier contingent to help introduce the Chinese base to the Nadcap process. I look forward to seeing as many of you as possible in Beijing, and thanks for the strong support at the Redondo Beach meeting.

Phil Keown – Chairman NDT Task Group

Nadcap Meeting Schedule

Nadcap Meetings until 2007 updated as of 2/15/2006

Month	2006	2007
January	-	TBD Phoenix, AZ 22-26
April	Hotel Nikko New Century Beijing, Beijing, China 24-28	Europe TBD 16-20
July	Madrid, Spain 17-21	Asia TBD 16-20
October	Marriott Downtown Pittsburgh, PA 13-20	Marriott Downtown Pittsburgh, PA 19-26

NDT Newsletter – News to you?

Are you a new reader of the NDT Newsletter? If so, here is some information:

The NDT Newsletter is published four times a year prior to the quarterly Task Group meetings.

The newsletters are read by the subscribing Primes, Suppliers, Auditors and anybody that happens to click on the latest NDT Newsletter on the PRI website (www.pri-network.org).

The aim of the newsletter is to communicate information relating to NDT within the Nadcap program to improve our process and to promote the sharing of best practices at all levels. If you have any articles that you feel would benefit the program, feel free to forward these to one of the NDT Staff Engineers (contact details at the end of the newsletter) for future inclusions.

Jim Bennett – NDT Staff Engineer

Nadcap Non-Film Radiographic Audit Program

Editorial note: In the last edition of the NDT Newsletter, Ron Rodgers gave an article on the above subject, unfortunately Ron's contact details were incorrect. To ensure we address Ron's issues and obtain the necessary response, the article is republished below in its entirety.

The ad hoc group is still working the issue of Non-Film Radiographic Testing (NFRT). Based on a teleconference meeting held towards the end of 2005, it was decided to obtain further input by pursuing a number of avenues, this newsletter article being one. If you either use or approve such installations, please take a moment to email such information to the undersigned. The group is asking only five questions, but this information will help us structure an audit program for NFRT. The questions are:

- 1) 1) What modalities or equipment types are used for image detection and how many installations are in use?
 - a. Image Intensifiers
 - b. Phosphor Plates
 - c. Digital Arrays
 - d. Other
- 2) 2) What radiation sources are used?
 - a. Isotopes
 - b. X-ray
 - i. KV
 1. 0-50
 2. 0-160
 3. 0-320
 4. 0-420
 - ii. MEV
 1. 1
 2. 2
 3. 4
 4. Other
- 3) 3) What display and image enhancement modes are in use?
- 4) 4) What archive modes are in use?
- 5) 5) What personnel certification program is used for inspectors?

As stated earlier, this information will help shape a program useful to all who use or approve NFRT installations, so any feed back is welcomed.

Thanks,
Ron Rodgers, RT Method Chair
ron.rodgers@ae.ge.com

Supplier Perspective – Attending the NDT Task Group Meeting

I arrived at my first Nadcap meeting with the full intention of giving someone a piece of my mind. As a veteran NDT examiner who had only recently been indoctrinated in the ways of Nadcap, I had come to the conference with some preconceived notions of how things were and how they should be.

The company I work for, MetalTek International, Wisconsin Centrifugal Division, supplies centrifugal castings for ASME Boiler and Pressure Vessel Code, NAVSEA Technical Publication 271, Aerospace and other ASTM applications covering several NDT methods. I wondered if this group understood how difficult it was to organize an NDT department, write procedures with specific customer addendums, as well as train and test the inspectors, in order to encompass all of the different customer requirements. I knew that I was going into a meeting that included representatives from the major Aerospace Primes and a wide assortment of Suppliers from all over the world and frankly, I expected chaos. Over the years I have seen firsthand how difficult it could be to get a large group of people to agree on anything and I had my doubts that this conference would be any different.

After my first day, I realized I was sitting in a room filled with highly qualified and respected NDT experts who felt the same way that I did and were right on track to streamline the process. I understood immediately that there were a vast array of circumstances and problems that I had never thought of. I was impressed at how well the Suppliers and Primes worked together to identify and resolve problems. That is not to say that it was a love fest! There were many “spirited” discussions, but on the whole, everyone involved had the same goal in mind and everyone’s voice was heard. Every aspect of the process was reviewed and everyone’s concerns were aired.

I left with a new awareness of the vast undertaking of this committee and gained a wide range of tools to train and organize my NDT department in a more efficient and effective way. I met several of my colleagues that are going through the same process and was able to share process and procedure ideas. I was also able to talk to the Primes directly and ask question about their requirements and procedures. It was a valuable experience to share knowledge with some of the best NDT minds in the business.

I want to thank Mark Aubele and the entire staff of the NDT Task Group for an exciting and informative first experience. I encourage everyone who is involved in the Nadcap certification process to get involved, so that we may all create satisfied customers and meet every requirement on time and at competitive prices. Success comes by continual improvement of what we do and how we do it.

Kurt J. Steinhagen, NDT Supervisor - MetalTek International, Wisconsin Centrifugal Division

“Who You Gonna Call”?

Have a question regarding posting your corrective action responses? What about clarifications regarding Nadcap in general? What is the status of your accreditation certificate? Who has availability to cover the world for nearly 14 hours a day? Who has a team of knowledgeable personnel to quickly answer your questions? If you haven’t guessed by now you really aren’t trying very hard!! Of course...it is the NDT Staff at the Performance Review Institute. Whether it is a Staff Engineer or Committee Service Representative, the goal is to provide our Supplier customers a high level of support.

PRI NDT Staff think of themselves as the “Information Focal Point” for all Nadcap related NDT activities. In 2006 the emphasis is on the Nadcap NDT Supplier. The NDT Staff are focusing on reducing Supplier cycle time and number of cycles for responding to nonconformances and ultimately timely issuance of the accreditation. The bottom line is that NDT Staff want to reduce the strain on two of your most valuable resources, time and people.

How can NDT Staff do that, you ask? As good as it is we have found that only so much can be explained in the eAuditNet system, sometimes it requires a teleconference to really go into the detail needed to explain a situation or the need for additional data. If you are not sure what is being asked, pick up the phone and call the NDT Staff, or at least email requesting a time to discuss an issue. We have made a commitment to get back with you within 24 hours.

You can find NDT Staff contact data at the PRI website (www.pri-network.com), or for your convenience at the end of every newsletter. The website also provides you access to Nadcap NDT meeting minutes, agendas, upcoming events and the NDT Newsletter.

P Michael Gutridge – NDT / Weld Senior Staff Engineer

NDT Supplier Perspective - Supplier Involvement - Where Are We Now?

With an ever increasing number of Primes and Suppliers being involved Nadcap is here to stay like it or not! So what is the system? Well it is not difficult to review the available documentation to read that it is an **"Industry Managed"** scheme, intended to objectively assess special processes in operation. In our case **"industry"** is specifically the Aerospace NDT Industry. That is the entire industry, not just the Primes! Obviously the Primes have played a major role in developing the scheme to date but for it to operate and continue to operate equitably, judiciously and efficiently there is a need for the Supplier and customer to work together.

For Primes the system has the advantage that technical surveillance of a worldwide Supplier network can be achieved by participation in the scheme. In order to maintain control of Suppliers and demonstrate that control to airworthiness authorities, Primes are required to actively participate in the scheme and typically this will be achieved by nomination of representatives to management groups and the various commodity Task Groups within Nadcap. Hence the maintenance of a wide Supplier base is achieved by sending a small number of representatives to regular, quarterly meetings.

For Suppliers the system is helping with the harmonisation and standardisation of technical requirements that they have been striving for. However it is difficult to compare that cost effective "control of Suppliers" that Primes achieve by participation with any similar benefit to Suppliers.

It could be argued that an equitable system should provide each participant, Prime or Supplier, with representation at each Task Group meeting. It is effectively a requirement that Primes attend regularly as user members, however the need for Supplier representation does not exist and it is my experience that, for understandable reasons, Supplier attendance tends to be sporadic and uncoordinated.

It is important that all Suppliers have the opportunity to channel comments, questions and other input to Task Group in an affordable and accessible way and for that reason I believe that there is a need to develop a shared resource Supplier representation system. So I am actively looking for ways that Supplier representation and involvement can be improved including the possibility of regional representation and I would be pleased to hear from anyone with constructive comments.

Andy Bakewell, Supplier Voting Member
(andy.bakewell@emcol.co.uk)

An Auditor's Perspective – AC7114

Have you ever stood and watched an auditor going through your systems and procedures and wondered what they are actually looking for? Have you ever been through the Nadcap checklist prior to the audit, found very little wrong and then been surprised by the things the Nadcap auditor has discovered? Have you ever had an audit where the non-conformances have been mainly against the quality system rather than the NDT methods themselves? If the answer to any of these questions is yes, then this article might help you.

The list below gives a flavour of the types of things I check when auditing to the Nadcap NDT quality system checklist AC7114. It is not an exhaustive list by any means but it might help you when carrying out your own audit preparation. Good Luck!

AC7114 Paragraph number	Some Questions to ask	AC7114 Paragraph number	Some Questions to ask
3.1	Quality Manual <ul style="list-style-type: none"> Is there a Quality manual in place? Is the Quality manual approved? By whom? Is it in accordance with quality system accreditation? 	3.5	Customer Flow Down <ul style="list-style-type: none"> Is there evidence of a system which takes customer information e.g. from purchase order, supplementary purchasing conditions, specifications, drawings etc. and flows it down to the operators at shop floor level? (Typically a planning system). Is there evidence that this system includes appropriate technical input for NDT? Is there evidence that this system has worked for a number of part numbers i.e. the customer's requirements are correct at the point of processing/manufacture? Is there evidence that flow down includes, not only processing instructions, but also peripheral information such as calibration frequencies/ tolerances where specified by the customer or personnel certification requirements?
3.2	Management Review <ul style="list-style-type: none"> Is there documented evidence of management review at the intervals stated in the quality manual? Is there an agenda showing items covered – is it an effective review? Outputs from several previous meetings – have they been acted on? 		
3.3	Specifications <ul style="list-style-type: none"> Are the specifications needed for the NDT work in place? Do they including both processing specifications and e.g. personnel certification specifications? 	3.6	Internal Audit <ul style="list-style-type: none"> Is there evidence that there is a system for Internal NDT audit? What is the scope of the audit? Is there evidence that the NDT audit is scheduled at required intervals? Is there evidence that NDT audits have been carried out as scheduled? Do audits meet any specific customer requirements for frequency, auditor, content etc? How is the audit documented? What areas has the audit covered? Who carried out the audit? What are their qualifications – do these meet requirements? Have any findings been acted on? How is this accomplished? (Do the findings get put into the company corrective action system? Does this information feed into the management review?)
3.4	Specification Control <ul style="list-style-type: none"> Is there evidence that external specifications are at the correct issue? Is there evidence that there is a robust system for finding out when issue numbers of specifications change – for all customers? For all specifications? Has it worked in practice? Is there evidence that appropriately qualified people are conducting specification review for technical changes? Is there evidence that review is happening in a timely manner and according to internal procedure? 		
	Internal Document Control <ul style="list-style-type: none"> Is there evidence that internal documents are at correct issue, date etc.? Is there evidence that changes to documents are controlled? Is there evidence that the master list is up to date and matches the in use documents? Are only controlled copies available to be used? 		

AC7114 Paragraph number	Some Questions to ask	AC7114 Paragraph number	Some Questions to ask
3.7	Nonconformance Control <ul style="list-style-type: none"> Is there evidence of a system for dealing with non-conformances including responsibilities and possible dispositions? Is this system being followed in practice? Look to see if parts actually labelled, quarantined, destroyed as appropriate. Is information recorded traceable throughout the system? (e.g. part numbers, rejection notes) Are descriptions of non-conformances adequate? Is there evidence to show that re-worked items are re-inspected when required? Is documentation authorised by appropriate personnel? 	3.10	Receiving Inspection <ul style="list-style-type: none"> Is there receiving inspection of NDT related items e.g. consumables, calibration certificates? Does practice match procedure? How do people know what to check? What happens if they find something wrong?
		3.11	Purchasing <ul style="list-style-type: none"> Are requirements for NDT related purchases clearly communicated? E.g. calibrations – equipment, specification, tolerance required, calibration label/report required? Does approved Supplier list include NDT related Suppliers? How are training courses/ level III services etc controlled? What about sub-contractors for NDT?
3.8	Stamp Control <ul style="list-style-type: none"> Is there a register – are all the NDT operators on the register? Are the operators using their stamps? Are they legible? Are stamps meeting customer requirements? Are stamps kept carefully? (i.e. not left lying about) If operators sign off tests using signature/initials are these also registered/ controlled? If an electronic system is used does it include safeguards to ensure that tests are traceable? 	3.12	Inspection Records <ul style="list-style-type: none"> Retrievable? Legible? Includes sub-contractor records? Are any changes properly authorised?
		4.0	Personnel Records Written practice <ul style="list-style-type: none"> Is written practice approved by L3? Does it state in the specifications it complies with? Are these correct with respect to the customer base? Are the various levels of qualification and certification defined? Is the written practice part of the quality system? Do the details of this written practice meet the customer requirements?

AC7114 Paragraph number	Some Questions to ask	AC7114 Paragraph number	Some Questions to ask
	<p>Operator records</p> <ul style="list-style-type: none"> • Are operator training, experience, eye test and certification records available? Correct dates, approvals etc. • Is experience properly documented? • Is there employer certification? • If operators not always working in NDT, what system ensures they do not have a significant break? • Do examinations contain appropriate subject matter, number of questions, number of test pieces, correctly marked? • Are any customer specific requirements addressed? (e.g. specific exams, e.g. pass marks) • Are eye tests carried out by appropriate personnel and approved if required? How do the people know how to carry out the test? • Is there evidence that an operator stops carrying out NDT if his eye test is overdue? • Is there a training syllabus and does it cover the specific procedures and equipment in use.? <p>Level III</p> <ul style="list-style-type: none"> • Has the company officially nominated a Level III? • Are there records for the Level III? Who has certified the Level III? • Documentation to show that the Supplier has verified adequacy of outside agencies used? • Evidence of Prime approval of Level IIIs where required? (e.g. letters, certificates etc.) • Evidence that the Level III is actually sufficiently involved in the company? If an external LIII is there a contract or similar? 	8	<p>Corrective Action</p> <ul style="list-style-type: none"> • Are non-conformances dealt with? • Is there analysis of problems, trends etc? • How is preventive action determined? • How do they ensure that corrective actions which are put in place are effective and continue to be effective?
		9	<p>Calibration</p> <ul style="list-style-type: none"> • Is there a calibration register? • Is all the NDT related equipment included? Are the details (e.g. model nos, serial nos, dates) correct? • Are there procedures/ work instructions for internal calibrations? • Are the exact requirements for calibration defined in purchase orders or other means for external calibrations? (e.g. specification, calibration standard, need for a report/label) • Do the calibrations carried out meet customer requirements? How do people know what these requirements are? • Do calibration measurements cover the range of use? Is equipment appropriate to the range of use? Is it capable of the necessary precision/ accuracy? • Does anyone check the incoming calibration records? What do they check for? Do they understand the calibration report/results? • If equipment is out of tolerance what do they do? How do people know what to do? • If equipment has been adjusted at the time of calibration, have previous measurements made with this equipment been checked for validity? • Is there a system for periodic review of calibration frequency? • Is equipment carefully stored and handled so it is not damaged? • Do calibration labels on equipment match calibration dates held in record system?
6	<p>Personnel</p> <ul style="list-style-type: none"> • Are all personnel correctly certified for the work they are doing? • Are all eye tests and approval dates within correct time period? 		
7	<p>Inspection/Records/Procedures</p> <ul style="list-style-type: none"> • Are all records traceable to part, inspection method and operator? • Are they correctly completed? • Are they properly authorised? 		

Karen Reader - Consultant NDT Auditor

Supplier Notification Of Change/Request For Revised Certification

Is your company moving to a new location? Will someone else be the new point of contact for your facility in eAuditNet? Are you planning on changing the name of your company in the near future? All of these questions are frequent issues that Suppliers experience. In order to create a smooth transition in accurately updating company information, we ask that Suppliers submit a completed Notification of Change/Request for Revised Certification (t frm-11) to the PRI Scheduling Department.

This form will need to be completed by the Supplier requesting any of the following issues:

- Any revision to certification (other than extensions)
- A change to Supplier database information (e.g. key personnel changes or facility location)
- To notify the appropriate Task Group(s) of any significant change that affects processing, the quality organization or system

Once Scheduling receives the completed form, they will administer the necessary steps of obtaining the required information in order to complete the process, which includes obtaining the approval from the applicable Staff Engineer. Once approved, Scheduling will arrange for the appropriate eAuditNet profile changes to be made. If applicable, Scheduling will notify the appropriate department administrative staff who will then issue the revised certification. This information was referenced from PRI/Nadcap Internal Procedure NIP 7-04, Post Audit Process, Paragraph 5.4. The Notification of Change/Request for Revised Certification (t frm-11) can be found in eAuditNet under Public Documents, General Documents. These completed forms are to be returned to Linda Novak (America's and Asia) at lindab@sae.org or David Alexander (Europe) at david.alexander@pri-europe.org.uk.

Samantha Jeswald – NDT / Welding CSR

Prime Representatives of the NDT Task Group

Prime	Representative	Status	E-mail contact
Airbus SAS Toulouse Cedex, France	Yves Esquerre	User / Voting Member	yves.esquerre@airbus.com
Airbus SAS Bremen, Germany	Juergen Krueger	Alternate / User / Voting Member	juergen.krueger@airbus.com
Airbus SAS Filton Bristol, UK	Trevor Hiscox	User / Voting Member	trevor.hiscox@airbus.com
Bell Helicopter Textron Ft. Worth, TX	Jim Cullum	Alternate / User / Voting Member	jcullum@bellhelicopter.textron.com
Bell Helicopter Textron Ft. Worth, TX	Tyler Ribera	User / Voting Member	tribera@bellhelicopter.textron.com
Boeing Mesa, AZ	Bob Reynolds	User / Voting Member	bob.s.reynolds@boeing.com
Boeing Seattle, WA	Peter Torelli	User / Voting Member	peter.p.torelli@boeing.com
Boeing Military Airplanes St. Louis, MO	Douglas Ladd	User / Voting Member	douglas.l.ladd@boeing.com
Bombardier Belfast, UK	Bobby Scott	User / Voting Member	bobby.scott@aero.bombardier.com
Cessna Aircraft Company Wichita, KS	Greg Hall	User / Voting Member	ghall2@cessna.textron.com
Eaton Aerospace Jackson, MS	Steven Garner	User / Voting Member	stevewgarner@eaton.com
GE Aviation Lynn, MA	Phil Keown	Chairman / Alternate / User / Voting Member	philip.keown@ae.ge.com
GE Aviation Cincinnati, OH	Ron Rodgers	User / Voting Member	ron.rodders@ae.ge.com
Goodrich Aerostructures Group Riverside, CA	Chuck Alvarez	User / Voting Member	chuck.alvarez@goodrich.com
Goodrich Turbomachinery Products Chandler, AZ	Jerry Stutzman	User / Voting Member	jerry.stutzman@goodrich.com
Hamilton Sundstrand Windsor Locks, CT	Michael Mitchell	User / Voting Member	mike.mitchell@hs.utc.com
Hamilton Sundstrand Rockford, IL	Roger Eckart	Alternate / User / Voting Member	roger.eckart@hs.utc.com
Honeywell Aerospace Tempe, AZ	Keith Fightmaster	User / Voting Member	keith.fightmaster@honeywell.com
Honeywell Aerospace Phoenix, AZ	D. Scott Sullivan	Alternate / User / Voting Member	dscott.sullivan@honeywell.com
Honeywell Aerospace Phoenix, AZ	Robert Hogan	User / Voting Member	robert.hogan@honeywell.com
Lockheed Martin Corp Sunnyvale, CA	Ron Levi	User / Voting Member	Ron.levi@lmco.com
MTU Munich, Germany	Manfred Podlech	User / Voting Member	manfred.podlech@muc.mtu.de
Northrop Grumman Corporation	Stephen Bauer	User / Voting Member	stephen.bauer@ngc.com
Pratt & Whitney UTC East Hartford, CT	David Royce	Secretary / User / Voting Member	david.royce@pw.utc.com
Pratt & Whitney UTC East Hartford, CT	Jim Fowler	Alternate / User / Voting Member	fowlerj@pweh.com
Raytheon Aircraft Company Wichita, KS	Brian D. Young	User / Voting Member	brian_d_young@rac.ray.com
Rolls-Royce Corporation Indianapolis, IN	Andrea Steen	User / Voting Member	andrea.m.steen@rolls-royce.com
Rolls-Royce PLC Derby, UK	Andy Statham	Vice Chair / User / Voting Member	andy.statham@rolls-royce.com
Rolls-Royce PLC Derby, UK	Chris Stevenson	Alternate / User / Voting Member	christopher.stevenson@rolls-royce.com
SAFRAN Group France	Alain Bouchet	User / Voting Member	alain.bouchet@sneema.fr
Sprit AerSystems Wichita, KS	David H. Vaughn	User / Voting Member	david.h.vaughn@boeing.com
Textron Systems Wilmington, MA	Carl Roche	User / Voting Member	croche@systems.textron.com
Vought Aircraft Industries, Inc. Dallas, TX	Greg Rust	User / Voting Member	rustgr@voughtaircraft.com

Supplier Voting Members of the NDT Task Group

Supplier	Representative	Status	E-mail contact
E. M. Inspection Leicester, United Kingdom	Andy Bakewell	Secretary/Supplier Voting Member	andy.bakewell@emcol.co.uk
West Penn Non-Destructive Testing Inc. New Kensington, PA	N. David Campbell	Supplier Voting Member	ndcampbell@westpenntesting.com
AAA Plating & Inspection Inc. Compton, CA	Robert Custer	Supplier Voting Member	bob@aaaplating.com
NDT Inspection & Testing Ltd Worcester, United Kingdom	Paul Evans	Supplier Voting Member	paul.evans@ndt-inspection.co.uk
New Hampshire Ball Bearings, Inc. Peterborough, NH	Richard King	Supplier Voting Member	rking@nhbb.com
Mitchell Labs Pico Rivera, CA	David Mitchell	Chair/Supplier Voting Member	david.mitchell@mitchell-labs.com
West Penn Non-Destructive Testing Inc. New Kensington, PA	Mark Pompe	Alternate Supplier Voting Member	mpompe@westpenntesting.com
Team Cooperheat MQS Cincinnati, OH	Cindy Roth	Supplier Voting Member	croth@teamindustrialservices.com
Howmet Research Ctr Whitehall, MI	Ryan Soule	Vice Chair/Supplier Voting Member	rsoule@howmet.com
Orbit Industries Inc. Middleburg Heights, OH	Gary White	Supplier Voting Member	gwhite@orbitndt.com
Alcoa Fastening Systems Portet sur Garonne France	David Yates	Supplier Voting Member	David.yates@alcoa.com

Past NDT Newsletter Articles

During the past 24 months, the Nadcap NDT newsletters have covered a multitude of topics in order to keep everyone involved in the Nadcap NDT program up to date with what is happening at Nadcap Management Council, NDT Task Group, Supplier and PRI Staff level. As the number of subscribing Primes mandating Nadcap increases and so to the number of overseas Suppliers especially in the Asia region embracing the Nadcap system, it is an opportune time to look back at some of the articles previously published in the NDT Newsletter as in the majority of cases are still current:

Article	Newsletter Edition
Auditor Perspective – Drying Oven Controller Calibration	July 2005
Auditor Perspective – Preparing for your Audit	January 2006
Auditor Perspective – The Contracted Level 3	October 2005
Categorizing an NCR – Major or Minor	January 2005
Enhancements to eAuditNet – Observations Forum	September 2004
Enhancements to eAuditNet – NCR Response Guidelines	September 2004
Failed Compliance Data	July 2004
From the First Asian Auditor	April 2004
GE Requirement – Etching after Benching	March 2004
Hall Effect Gauss Meter Practice	January 2005
In Step with the Staff Engineer – Jim Bennett	July 2005
In Step with the Staff Engineer – Mark Aubele	September 2004
In Step with the Staff Engineer – Mike Guttridge	April 2005
In Step with the Staff Engineer – Phil Ford	January 2005
In Step with the CSR – Louise Belak	October 2005
In Step with the CSR – Samantha Jeswald	April 2006
ISO 17025 Accreditation	September 2004
Nadcap NDT Auditor – What does it take?	October 2005
Nadcap Non-Film Radiographic Audit Program	January 2006
Nadcap Users Compliance and Audit Program (NUCAP)	July 2005
National Aerospace NDT Boards and Developments in the UK	April 2005
NDT's Failure Policy	September 2005
NDTSTSTG	July 2005
P3TF2 & P3TF47	January 2005
Paper Audits	September 2004
Prepare for the Nadcap Audit	January 2005
Prime Perspective – Clarification of Boeing NDT Issues	July 2005
Suppliers – Checklist Review	September 2004
Supplier Merit	April 2005
Systemic NCR's	July 2004
The Role and Approval of on-the-job Training	January 2005
What is the NANDTB?	July 2004

Want to review previous NDT Newsletters? Use the following address to direct you to the NDT Commodity web page:
<http://www.pri-network.org/Nadcap/supplier/commodities/NDTesting.htm>

Jim Bennett – NDT Staff Engineer

In Step with the CSR

Name: Samantha Jeswald

Title: NDT & Welding Committee Service Representative (CSR)

Duties: Provide administrative support to the NDT & Welding Staff Engineers, Task Groups, Suppliers, Committees and Councils. Process audit reports upon submittal and issue certificates upon audit review completion. Assist in coordinating meeting planning in a timely and accurate manner. Train new Task Group Members in Nadcap policies, procedures, eAuditNet and Task Group Initiatives. Other daily tasks include documenting ballots, process NCR response extensions and maintaining projections.

Background: I began working for PRI in October 2004 as the Heat Treating CSR. Due to company reorganization, I became the NDT & Welding CSR in May 2005. Prior to working for PRI, I received my Bachelor of Science Degree from Indiana University of Pennsylvania where I majored in Child Development / Family Relations with a minor in Psychology. After completing an internship at the Shriners Hospital for Children in Erie, Pennsylvania, I became a Preschool Teacher for a year. I can honestly say I enjoy what I do for PRI as it is quite a change from my previous field.

Personal: Engaged to Dan, the greatest guy in the whole world. We do not have a date set for our big day yet, but we know it will be sometime next year. I also have two wonderful, supportive parents. I love to be active. I enjoy rollerblading, running, aerobics and biking. My new goal this winter is to learn how to ski.



PRI Staff Contact Details - NDT Group

Name	Position	Location	e-mail Contact	Telephone
Mark Aubele	Senior Staff Engineer	Warrendale, PA, USA	maubele@sae.org	(1) (724) 772-1616 ext 8127
Louise Belak	Committee Service Representative	Warrendale, PA, USA	belak@sae.org	(1) (724) 772-1616 ext 8115
Jim Bennett	Staff Engineer	Warrendale, PA, USA	bennet@sae.org	(1) (724) 772-1616 ext 8122
Phil Ford	Staff Engineer	Wales, UK	phil.ford@pri-europe.org.uk	(44) (0) 20 7483 9010
Mike Gutridge	Senior Staff Engineer	Granville, OH, USA	mikeg@sae.org	(1) (740) 587-9841
Samantha Jeswald	Committee Service Representative	Warrendale, PA, USA	samanthajeswald@sae.org	(1) (724) 772-1616 ext 8161