

NATIONAL TRANSPORTATION SAFETY BOARD
Investigative Hearing

Alaska Airlines Flight 1282

Boeing 737-9, N704AL

Left Mid Exit Door Plug Separation in Portland, OR

January 5, 2024

Docket No.	SA-543
EXHIBIT	
11C	

**Manufacturing Records and Human
Performance - Attachment 2
NCR N1450293199 and NCO 145-
8789-RGEN-RSHK-001NC
(16 Pages)**

DCA24MA063

**MANUFACTURING RECORDS AND HUMAN
PERFORMANCE**

Group Chair's Factual Report

Attachment 2 - NCR N1450293199 and NCO 145-8789-RGEN-RSHK-001NC

July 1, 2024

NCR N1450293199	Rev 0	Record-Sub-Record Type Rework - General	Initiated 09/07/2023	Shop R38F1	ACC/Pos/WL 941/1/UAB	MR
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MES Company 145 JI/WBJ/FBJ-Rtn	ERP Company NON None	Item ID	Item Description
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NCR: 22T N1450293199

Model 737	Line 08789-1D762	A/P	Right Left NONE	Multi Unit NO	FAA NO	BFE NO	Cust Sens NO	Line Check NO	Stock Check NO	Tool Check NO	I/R NO	JASIT NO	SRL	Maint Manua	IPC	FTA
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Job ID 145-8789-RSHK-1296-002NC	Related Order 145-8789-RSHK-1296-002NC	Opr/Step	Job Qty	Disc Qty 1
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Physical Item Location	STA	WL	BL	Other	Serial ID	RMVD From LN
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Supplier Code 701882	Supplier Name SPIRIT AEROSYSTEMS INC	Purchase Order Number	Purchase Order Position	Receipt
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Supplier Origination Date	Supplier Nonconformance Type	Purchase Contract	Contract Date	Authorize to Ship No
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Printed: 02/13/2024 15:26:50

by XXXXXXXX, XXXXX

Export Control: COM

NCR N1450293199	Status Complete	Page 1
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Corrective	Responsible Group	Current Task

Parent NCR	Current NCR	Child NCRs	Type	Coverag
No	Not A Child	None		

REVISION 0 SECTION--Complete

SIGNATURES	Task	Name	Org	Phone	Date
	Initiation	XXXXXX	XXXXXX	XXXXXX	09/07/2023 13:34

Discrepancy
 Defect No: 1
 STA: 0
 WL: 0
 BL: 0.0
 Feature: U06 - Unauthorized
 Description: W41 - Work
 Defect Count: 0
 SUPPLIER STAMPED ALL INSPECTION POINTS STATING
 REMOVED AND REPLACED RIVETS PER ██████████ RIVETS
 WERE NOT REPLACED AND WAS JUST PAINTED OVER. THERE
 WAS NO ACCESS ON THE OTHER SIDE OF THE PART TO
 REPLACE THOSE RIVETS AND NO REMOVALS WERE MADE. See
 attachments
 Name: XXXXXX
 Revision: 0 Phone: XXXXXX Org: XXXXXX
 Date: 09/07/2023 13:34

Disposition

COVERAG	Line	A/P	Type	ACC/Pos/WL	NC Order ID	Plan	Last Order Rev	Status	Interim
	08789-1D762		New	941/1/UAB	145-8789-RGEN-RSHK-001NC	0001	09/07/2023 13:34	Complete	Final

NCR N1450293199	Status Complete	Page 2
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PLAN 0001 SECTION: UNAUTHORIZED REWORK

Line	A/P	ACC/Pos/WL	Details	Last Order Rev	Status
08789 - 1D762		941/1/UAB	NC Order Id : 145-8789-RGEN-RSHK-001NC WORK WITH: WORK TYPE: RELATED REVS: 0	09/07/2023 13:34	Complete

Oper#	Task/WCC	Narrative
010		Defect No: 1 STA: 0 WL: 0 BL: 0.0 Feature: U06 - Unauthorized Description: W41 - Work Defect Count: 0 SUPPLIER STAMPED ALL INSPECTION POINTS STATING REMOVED AND REPLACED RIVETS PER [REDACTED]. RIVETS WERE NOT REPLACED AND WAS JUST PAINTED OVER.THERE was NO ACCESS ON THE OTHER SIDE of the part to replace those rivets and no removals were made. See attachments
998		Assure all foreign objects are removed from work areas common to this order.
999		FINAL BUYOFF

CODES SECTION

NCR Item ID	Item Description	Model Description	Serial ID
		737	

MES Company 145 JI/WBJ/FBJ-Rtn	ERP Company NON None
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Shop	ACC/Pos/WL	Job ID	Job Qty	Operation No	Line	A/P	Last Revised
R38F1	941/1/UAB	145-8789-RSHK-1296-002NC			08789 - 1D762		09/07/2023

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by XXXXXXXX, XXXXX

Export Control: COM

NCR N1450293199	Status Complete	Page 3
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CODES SECTION (continued)

Engineering Codes							
Model	Line	A/P	SRL	Maint Manual	IPC	FTA	Cust Sens
737	08789	- 1D762					No

Defect Number: 1	Summation of 1 of 1 Internal
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Initiating Company - Where Defect Was Found

Item Qty * Defects Per Item = Defect Count 1 * 0 = 0	MBU/RC	Date of Mfg	Paper Form ID	Paper Form Type	
Option	Module		Product TBS	Process TBS	Shop ID NO
STA 0	WL 0	BL 0.0	Other		Removed From Line
Feature U06 - Unauthorized	Description W41 - Work		Process	Sub-Process	
Location	Sub-Location		Component	Sub-Component	
Air Transport Association Code	Grief		Defect Unique 1	Defect Unique 2	Defect Unique 3

CAUSE - Where Defect Was Produced

Defect Supplier 701882 - SPIRIT AEROSYSTEMS INC			Defect Item ID		MBU/RC	Repeat Failure NO	I/R Failure NO
Raw Material Item		Option	Module		Date of Manufacturing		
Machine ID	Shop R38F1	Defect Job ID 145-8789-RSHK-1296-002NC		Self Inspection And Acceptance			
ACC/Pos/WL 941/1/UAB	Operation No		UOM	Product TBS	Process TBS		

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NCR N1450293199	Status Complete	Page 4
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CODES SECTION (continued)

Feature U06 - Unauthorized		Description W41 - Work	Process	Sub-Process		
Summary Disposition			Defect Unique 1	Defect Unique 2	Defect Unique 3	
RESOLUTION						
CAR	Cause Group:	S11 - SM&P Supplier Manufacturing	Multi-Level Escapement 1			
	Root Cause:	U02 - Unauthorized Rework	Multi-Level Escapement 2			
	Resolution Group:					
	Action Taken:					

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NCR N1450293199	Status Complete	Page 5 LP
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NON CONFORMANCE ORDER

ACC/POS WRK	LINE/CVN	ORDER ID				REV	ORDER TITLE				
941/1/UAB	8789/1D762	145-8789-RGEN-RSHK-001NC				0	UNAUTHORIZED REWORK				
PROGRAM	LAST REVISION		EXP	I/R	PROD STAT	ORDER STATUS	REL REC		ORDER SUB-TYPE		
737	09/07/2023		COM	N	COMP	Completed	145-8789-RSHK-1296-002NC		RGEN		
NCR		JOB/SERIAL COVERAGE					DISPOSITION TYPE		NCM REVISION		
N1450293199							FINAL				
Company			Area			Sub-Area			Queue ID		
145-JI/WBJ/FBJ-Rtn											
STA			WL			BL			Other		



Order Id: 145-8789-RGEN-RSHK-001NC

OPERATION SECTION

OPERATIONS WITHOUT AN "*" IN THE OPERATION COLUMN MAY BE WORKED IN ANY ORDER.

Oper	Step	Narrative	Links	Exceptions	Shop Acceptance	Quality Acceptance
10	10	Defect No: 1 STA: 0 WL: 0 BL: 0.0 Feature: U06 - Unauthorized Description: W41 - Work Defect Count: 0 SUPPLIER STAMPED ALL INSPECTION POINTS STATING REMOVED AND REPLACED RIVETS PER ██████████ RIVETS WERE NOT REPLACED AND WAS JUST PAINTED OVER. THERE WAS NO ACCESS ON THE OTHER SIDE OF THE PART TO REPLACE THOSE RIVETS AND NO REMOVALS WERE MADE. See attachments ----- APPLY SUPPLIER ACCEPTANCE XXXXXX 09/10/2023 09:11 SHOULD HAVE BEEN STAMPED IN THIS MANNER.	No	No	XXXXXX 09/19/2023 Supl Accpt	XXXXXX 09/19/2023 Sup Q Acpt

Date/Time 01/10/2024 09:45:50 By : XXXXXXXXXXXX Order Key+Campus: 99605292 01/10/2024 09:45:50 ECV: COM

ACC	POS/WL	Line	CVN	Order ID	Rev	Order Title	H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC	0	UNAUTHORIZED REWORK	N	1

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OPERATION SECTION

Oper	Step	Narrative	Links	Exceptions	Shop Acceptance	Quality Acceptance
10	10	<p>NOTED RIVET BUCKTAIL DAMAGE IS ACCEPTABLE AS IS PER BAC5004-1 SECTION 11. 2. 2(C)</p> <p>APPLY SUPPLIER QUALITY ACCEPTANCE XXXXXX 09/10/2023 09: 35 REMOVE SUPPLIER QUALITY ACCEPTANCE XXXXXX 09/11/2023 07: 20 Damaged rivets are not acceptable and need to be removed and replaced per ██████████ talks about damaged rivet heads and it's a different discrepancy. painting rivets and saying that it was removed and replaced is not acceptable</p> <p>REMOVE SUPPLIER ACCEPTANCE XXXXXX 09/11/2023 07: 21 Damaged rivets are not acceptable and need to be removed and replaced per ██████████ talks about damaged rivet heads and it's a different discrepancy. painting rivets and saying that it was removed and replaced is not acceptable</p> <p>APPLY SUPPLIER ACCEPTANCE XXXXXX 09/19/2023 15: 06 Rivets have been removed and replaced per ██████████ rework accomplished on NCR: N1450292531</p> <p>APPLY SUPPLIER QUALITY ACCEPTANCE XXXXXX 09/19/2023 15: 13 in concurrence with mechanic. Rivets have been removed and replaced per ██████████ rework accomplished on NCR: N1450292531</p> <p>-----</p>	No	No		
998	10	<p>Assure all foreign objects are removed from work areas common to this order.</p> <p>-----</p> <p>APPLY SUPPLIER ACCEPTANCE XXXXXX 09/10/2023 09: 11 REMOVE SUPPLIER ACCEPTANCE XXXXXX 09/11/2023 07: 17 Damaged rivets are not acceptable and need to be removed and replaced per ██████████</p> <p>APPLY SUPPLIER ACCEPTANCE XXXXXX 09/19/2023 15: 07</p>	No	No	XXXXXX 09/19/2023 Supl Accpt	XXXXXX

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WORK COPY- REFERENCE ONLY

Date/Time 01/10/2024 09:45:50 By : XXXXXXXXXXXX Order Key+Campus: 99605292 01/10/2024 09:45:50 ECV: COM

ACC	POS/WL	Line	CVN	Order ID	Rev	Order Title	H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC	0	UNAUTHORIZED REWORK	N	2

OPERATION SECTION

Oper	Step	Narrative	Links	Exceptions	Shop Acceptance	Quality Acceptance
998	10	-----	No	No		
999	10	Final Acceptance ----- APPLY FINAL SUPPLIER ACCEPTANCE XXXXXX 09/10/2023 09: 11 APPLY FINAL QUALITY ACCEPTANCE XXXXXX 09/10/2023 15: 19 REMOVE FINAL QUALITY ACCEPTANCE XXXXXX 09/11/2023 07: 16 Damaged rivets are not acceptable and need to be removed and replaced per [REDACTED] REMOVE FINAL SUPPLIER ACCEPTANCE XXXXXX 09/11/2023 07: 17 Damaged rivets are not acceptable and need to be removed and replaced per [REDACTED] APPLY FINAL SUPPLIER ACCEPTANCE XXXXXX 09/19/2023 15: 07 Rivets removed and replaced, now are per [REDACTED] requirements APPLY FINAL QUALITY ACCEPTANCE XXXXXX 09/19/2023 18: 11 Final quality acceptance per [REDACTED]. All prior inspection and work performed by supplier. -----	No	No	XXXXXX 09/19/2023 Final Supl	XXXXXX 09/19/2023 Final QA

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Date/Time 01/10/2024 09:45:50 By : XXXXXXXXXXXX Order Key+Campus: 99605292 01/10/2024 09:45:50 ECV: COM

ACC	POS/WL	Line	CVN	Order ID	Re	Order Title	H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC	0	UNAUTHORIZED REWORK	N	3

ATTACHMENTS

ATTACHMENT ID 1.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR XXXXXXXXXX
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PRODUCTION

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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	4

ATTACHMENTS

ATTACHMENT ID 2.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR [REDACTED]
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PRODUCTION

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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	5

ATTACHMENTS

ATTACHMENT ID 3.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR [REDACTED]
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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	6

ATTACHMENTS

ATTACHMENT ID 4.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR XXXXXXXXXX
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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	7

ATTACHMENTS

ATTACHMENT ID 5.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR [REDACTED]
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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	8

ATTACHMENTS

ATTACHMENT ID 6.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR <div style="background-color: black; width: 100px; height: 15px;"></div>
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PRODUCTION

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Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	9

ATTACHMENTS

ATTACHMENT ID 8.jpg	TASK ADDED	Rev 0	EXP CNTRL COM	ATTACH TYPE Graphic	ATTACHMENT AUTHOR <div style="background-color: black; width: 100px; height: 15px;"></div>
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PRODUCTION

WORK COPY- REFERENCE ONLY

Date/Time		01/10/2024 09:45:50		By : XXXXXXXXXXXX		Order Key+Campus: 99605292 01/10/2024 09:45:50			
ACC	POS/WL	Line	CVN	Order ID		Order Title		H	Page
941	1/UAB	8789	1D762	145-8789-RGEN-RSHK-001NC		UNAUTHORIZED REWORK		N	10 LP