Nonconformity management

IATF 16949:2016
Certified by IRQS

Organization name	AIRCRAFT FACTORY (ACF) – ARAB ORGANIZATION FOR INDUSTRIALIZATION (AOI)
Audit start date	24.Nov.2025
Audit end date	27.Nov.2025
Audit type	Stage 2
CB identification no.	A/9853/IATF
IATF USI (Unique site identifier)	LCL2S9

Additionally to this report a digital NC management report file will be provided by the auditor which has to be completed in IATF NC CARA at https://nc-cara.iatfglobaloversight.org. All information about the software and use is provided in the documentation accessible at the provided link.

Nonconformity management

NC no.	NC identification no.	Auditor´s name	Standard	Standard clause	Classification	Due date max. 15 days	Due date max. 60 days	Reviewer decision	Date reviewed	Nonconformity observed in process
1	SA-01	Sally Ahmed	IATF 16949:2016	7.2.3	minor		26.Jan.2026			Quality Assurance (Internal Audits, MR, Follow up of Objectives, Risk Assessment, & Document Control)
2	SA-02	Sally Ahmed	IATF 16949:2016	9.2.2.4	minor		26.Jan.2026			Quality Assurance (Internal Audits, MR, Follow up of Objectives, Risk Assessment, & Document Control)
3	SA-03	Sally Ahmed	IATF 16949:2016	6.1.2.3	minor		26.Jan.2026			Production (Cutting, Water Jet, Numbering and Oiling Processes), Contingency Plans & Maintenance of IT Programming of Machines
4	SA-04	Sally Ahmed	IATF 16949:2016	8.3.5.2	minor		26.Jan.2026			Production (Cutting, Water Jet, Numbering and Oiling Processes), Contingency Plans & Maintenance of IT Programming of Machines
5	SA-05	Sally Ahmed	IATF 16949:2016	8.5.1.1	minor		26.Jan.2026			Process Planning of Production (Planning Process, & Manufacturing Process Design)

NC & actions

Nonconformity 1

To be completed by the CB auditor

NC header

NC identification no.	SA-01
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	26.Jan.2026
Nonconformity observed in process	Quality Assurance (Internal Audits, MR, Follow up of Objectives, Risk Assessment, & Document Control)
Standard clause	7.2.3 Internal auditor competency

Requirement

The organization shall have a documented process(es) to verify that internal auditors are competent, taking into account any requirements defined by the organization and/or customer-specific requirements. For additional guidance on auditor competencies, refer to ISO 19011. The organization shall maintain a list of qualified internal auditors.
Quality management system auditors, shall be able to demonstrate the following minimum competencies:
a) understanding of the automotive process approach for auditing, including risk-based thinking;
b) understanding of applicable customer-specific requirements;
c) understanding of applicable ISO 9001 and IATF 16949 requirements related to the scope of the audit;
d) understanding of applicable core tool requirements related to the scope of the audit;
e) understanding how to plan, conduct, report, and close out audit findings.
At a minimum, manufacturing process auditors shall demonstrate technical understanding of the relevant manufacturing process(es) to be audited, including process risk analysis (such as PFMEA) and control plan. At a minimum, product auditors shall demonstrate competence in understanding product requirements and use of relevant measuring and test equipment to verify product conformity.
If the organization's personnel provide the training to achieve competency, documented information shall be retained to demonstrate the trainer's competency with the above requirements.
Maintenance of and improvement in internal auditor competence shall be demonstrated through:
f) executing a minimum number of audits per year, as defined by the organization; and
g) maintaining knowledge of relevant requirements based on internal changes (e.g., process technology, product technology) and external changes (e.g., ISO 9001, IATF 16949, core tools, and customer specific requirements).

Statement of nonconformity

The Internal Auditor Competency process is not fully effective

Objective evidence

While Auditing the Internal Audit Process for 2025, which conducted at 2025, for System, Process & Product Audits, found that the Internal Auditor Qualifications requirements mentioned at the Training Procedure code No. ACFQ/EHSP 73-01, issued at 2 /8/ 2025, No. 3 & Internal Audit Procedure code No. ACFQ/E/HSP 53-04, issued at 1/11/ 2020, No. 2, comply with the IATF Requirements, IATF SI Requirements & CSR, but the List of Qualification of Internal Auditor dated 1.1.2025, on form no. ACFQ/E/HSP 53-04 (F-53-220) is not contain in details this Qualifications for each approved Auditor in each scheme.

Justification for classification

Minor NC, because it is single Laps, the Qualifications identified at the Internal Audit Procedure in details, and not raised any customer Compliant for this Issue

Sally Ahmed **Auditor´s name**	6-AUD-C-2505-4019-5982 **Auditor ID no.**	27.Nov.2025 **Audit closing meeting date**	**This document is valid without a signature**

To be completed by the organization

S1 Containment action, including timing and responsible person:

S2 Evidence of implementation

S3 Root cause analysis

Does the root cause impact other similar processes or products?

Please describe how the root cause does not impact other process?

S4 Root cause result

S5 Systemic corrective actions, including timing and responsible person

S6 Evidence of implementation

S7 Action taken to verify effective implementation of corrective actions

Submission(s)

Organizations representative

date

Nonconformity 2

To be completed by the CB auditor

NC header

NC identification no.	SA-02
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	26.Jan.2026
Nonconformity observed in process	Quality Assurance (Internal Audits, MR, Follow up of Objectives, Risk Assessment, & Document Control)
Standard clause	9.2.2.4 Product audit

Requirement
The organization shall audit products using customer-specific required approaches at appropriate stages of production and delivery to verify conformity to specified requirements. Where not defined by the customer, the organization shall define the approach to be used.

Statement of nonconformity

The process of Product audit is not fully effective

Objective evidence

While Auditing the Product Audit Process, for Cover Plates of Filter Box Product, conducted at 14.7.2025, No NCRs Raised, the result was 100%, the Audit conducted for all Manufacturing Processes, as the PFD, by Ms. Bosina Sayed, Ms. Samer Mosad & Ms. Menna Gamal, found all IATF requirement was addressed, such as the checking of Specifications of Product according to the Drawings, Manufacturing Steps, ...etc.., but not clear enough for the Delivery requirements or how to check the implementation of the delivery requirements.

Justification for classification

No Direct Risk to customer and other internal audit found effective such as system, Manufacturing Process audit and Product Audits for the Other Products

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S1 Containment action, including timing and responsible person:

S2 Evidence of implementation

S3 Root cause analysis

Does the root cause impact other similar processes or products?

Please describe how the root cause does not impact other process?

S4 Root cause result

S5 Systemic corrective actions, including timing and responsible person

S6 Evidence of implementation

S7 Action taken to verify effective implementation of corrective actions

Submission(s)

Organizations representative

date

Nonconformity 3

To be completed by the CB auditor

NC header

NC identification no.	SA-03
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	26.Jan.2026
Nonconformity observed in process	Production (Cutting, Water Jet, Numbering and Oiling Processes), Contingency Plans & Maintenance of IT Programming of Machines
Standard clause	6.1.2.3 Contingency plans

Requirement
The organization shall:
a) identify and evaluate internal and external risks to all manufacturing processes and infrastructure equipment essential to maintain production output and to ensure that customer requirements are met;
b) define contingency plans according to risk and impact to the customer;
c) prepare contingency plans for continuity of supply in the event of any of the following, but not limited to: key equipment failures (also see Section 8.5.6.1.1); interruption from externally provided products, processes, and services; recurring natural disasters; fire; pandemics; utility interruptions; cyber-attacks on information technology systems; labour shortages; or infrastructure disruptions;
d) include, as a supplement to the contingency plans, a notification process to the customer and other interested parties for the extent and duration of any situation impacting customer operations;
e) periodically test the contingency plans for effectiveness (e.g., simulations, as appropriate);
cybersecurity testing may include a simulation of a cyber-attack, regular monitoring for specific threats, identification of dependencies and prioritization of vulnerabilities. The testing is appropriate to the risk of associated customer disruption;
Note: cybersecurity testing may be managed internally by the organization or subcontracted as appropriate
f) conduct contingency plan reviews (at a minimum annually) using a multidisciplinary team including top management, and update as required;
g) document the contingency plans and retain documented information describing any revision(s), including the person(s) who authorized the change(s).
h) include in contingency plans the development and implementation of appropriate employee training and awareness.
The contingency plans shall include provisions to validate that the manufactured product continues to meet customer specifications after the re-start of production following an emergency in which production was stopped and if the regular shutdown processes were not followed.

Statement of nonconformity

The Simulation process for Contingency plans in not fully effective

Objective evidence

Contingency plan was established and implemented contains all potential situation , checked the Simulation Records for several Situations, such as, Cyber Attack, and Solo Supplier, but for the Key Equipment Breakdown Simulation recorded on the Contingency plan test record on form no. N/53/291, which conducted at 20.2.2025, needs to be more clear and contains all the actions and techniques taken in clearly manner, for the Software program, the QC Checking Points & Criteria for the temporary machine Laser Cutting M/C.

Justification for classification

Minor NC, because it is single Laps, checked the contingency plan already exist and Solo Supplier is identified also many other cases are defined such as cyber attack, Electricity shortage and natural disaster, and not raised any customer Compliant for this Issue

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To be completed by the organization

S1 Containment action, including timing and responsible person:

S2 Evidence of implementation

S3 Root cause analysis

Does the root cause impact other similar processes or products?

Please describe how the root cause does not impact other process?

S4 Root cause result

S5 Systemic corrective actions, including timing and responsible person

S6 Evidence of implementation

S7 Action taken to verify effective implementation of corrective actions

Submission(s)

Organizations representative

date

Nonconformity 4

To be completed by the CB auditor

NC header

NC identification no.	SA-04
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	26.Jan.2026
Nonconformity observed in process	Production (Cutting, Water Jet, Numbering and Oiling Processes), Contingency Plans & Maintenance of IT Programming of Machines
Standard clause	8.3.5.2 Manufacturing process design output

Requirement
The organization shall document the manufacturing process design output in a manner that enables verification against the manufacturing process design inputs. The organization shall verify the outputs against manufacturing process design input requirements. The manufacturing process design output shall include but is not limited to the following:
a) specifications and drawings;
b) special characteristics for product and manufacturing process;
c) identification of process input variables that impact characteristics;
d) tooling and equipment for production and control, including capability studies of equipment and process(es);
e) manufacturing process flow charts/layout, including linkage of product, process, and tooling;
f) capacity analysis;
g) manufacturing process FMEA;
h) maintenance plans and instructions;
i) control plan (see Annex A);
j) standard work and work instructions;
k) process approval acceptance criteria;
l) data for quality, reliability, maintainability, and measurability;
m) results of error-proofing identification and verification, as appropriate;
n) methods of rapid detection, feedback, and correction of product/manufacturing process nonconformities.

Statement of nonconformity

The identification of process input variables Process is not fully effective

Objective evidence

While Auditing the Water Jet cutting Process, for Operation No. (20) at the control Plan, for Cover Back CNC, using Water Jet M/C, checked the Work instruction of operation no. T.A/42/35 dated 5.8.2019, found that it is not clearly identify the change process of the Jets devices in a specific manner according to the customer's requirements and the experience, that is to have to be changed after 300 working hours, but Actually it is done in a specific way and in a specific time but not recorded or has a specific documented record to control the Working Hours , checked during the Cutting Operation by water Jet,

Justification for classification

Minor, because by interviewing the operator and the inspector, they were aware of these control methods, and implement it effectively and there were no customer complaint raised about this issue

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S1 Containment action, including timing and responsible person:

S2 Evidence of implementation

S3 Root cause analysis

Does the root cause impact other similar processes or products?

Please describe how the root cause does not impact other process?

S4 Root cause result

S5 Systemic corrective actions, including timing and responsible person

S6 Evidence of implementation

S7 Action taken to verify effective implementation of corrective actions

Submission(s)

Organizations representative

date

Nonconformity 5

To be completed by the CB auditor

NC header

NC identification no.	SA-05
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	26.Jan.2026
Nonconformity observed in process	Process Planning of Production (Planning Process, & Manufacturing Process Design)
Standard clause	8.5.1.1 Control plan

Requirement
The organization shall develop control plans (in accordance with Annex A) at the system, subsystem, component, and/or material level for the relevant manufacturing site and all product supplied, including those for processes producing bulk materials as well as parts. Family control plans are acceptable for bulk material and similar parts using a common manufacturing process.
The organization shall have a control plan for pre-launch and production that shows linkage and incorporates information from the design risk analysis (if provided by the customer), process flow diagram, and manufacturing process risk analysis outputs (such as FMEA).
The organization shall, if required by the customer, provide measurement and conformity data collected during execution of either the pre-launch or production control plans. The organization shall include in the control plan:
a) controls used for the manufacturing process control, including verification of job set-ups;
b) first-off/last-off part validation, as applicable;
c) methods for monitoring of control exercised over special characteristics (see Annex A) defined by both the customer and the organization;
d) the customer-required information, if any;
e) specified reaction plan (see Annex A); when nonconforming product is detected, the process becomes statistically unstable or not statistically capable.
The organization shall review control plans, and update as required, for any of the following:
f) the organization determines it has shipped nonconforming product to the customer;
g) when any change occurs affecting product, manufacturing process, measurement, logistics, supply sources, production volume changes, or risk analysis (FMEA) (see Annex A);
h) after a customer complaint and implementation of the associated corrective action, when applicable;
i) at a set frequency based on a risk analysis.
If required by the customer, the organization shall obtain customer approval after review or revision of the control plan.

Statement of nonconformity

The process to develop control plan is not fully effective

Objective evidence

While Auditing the Production Line for Water Jet CNC M/C for Automotive Sector, for Cover Plates of Filter Box, E5708-30-180-01, part No. 8045770, checked the Drawing with No. E5708-30-180-01, found at the Final Inspection Station, there is control the special characteristics' points for Outer & inner Dimensions, at the Operation No. 30, the inspector take the first sample each batch to measure these diameters, and measure it with Vernier caliper, Micrometer & Tap Meter, then the inspector inspect 100% of the batch by Visual, but it wasn't mentioned in this details for the specifications / characteristics checked in each method, at operation No. 30 & 40 at Control Plan on form no. 262/41/N, version # 4, Last revision dated 26.10.2025, for part Cover Plates of Filter Box, C/P coded CP4
Also, the reaction plan for this operation no. 30 need to be in more details for the reaction methodology will be followed in case of that the dimension is not correct

Justification for classification

minor, because by interviewing the operator and the inspector, they were aware of these control methods, and implement it effectively and there were no customer complaint raised about this issue.

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S1 Containment action, including timing and responsible person:

S2 Evidence of implementation

S3 Root cause analysis

Does the root cause impact other similar processes or products?

Please describe how the root cause does not impact other process?

S4 Root cause result

S5 Systemic corrective actions, including timing and responsible person

S6 Evidence of implementation

S7 Action taken to verify effective implementation of corrective actions

Submission(s)

Organizations representative

date