

## **InspectionXpert OnDemand for PDF tip sheet – Out of Sequence Ballooning**

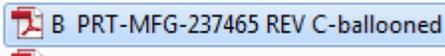
### **Pratt and Whitney Suppliers using InspectionXpert OnDemand and Net-Inspect**

**The purpose of this tip sheet is to provide best practice examples for out of sequence ballooning. Though the specific functions are included via the help section of the software, this tip sheet provides steps for how the functionality meets the intended process. For questions regarding content or requirements please contact your Pratt & Whitney Supplier Quality Representative.**

## To create and add balloons starting from already ballooned pdf that includes original ballooned documentation, created prior to InspectionXpert OnDemand.

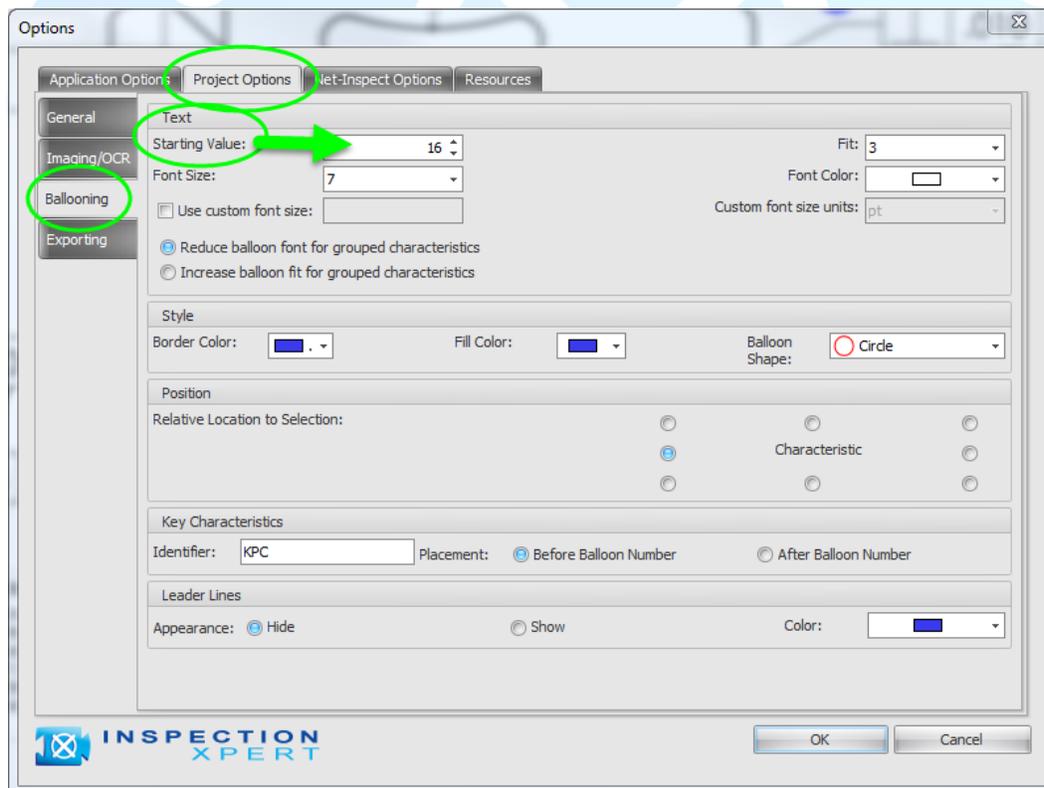
- This allows traceability by including the ballooned documentation from your previously created ballooned documentation to balloon new features starting with a consecutive numbering scheme.

1. Create a new InspectionXpert project using your already ballooned pdf document.

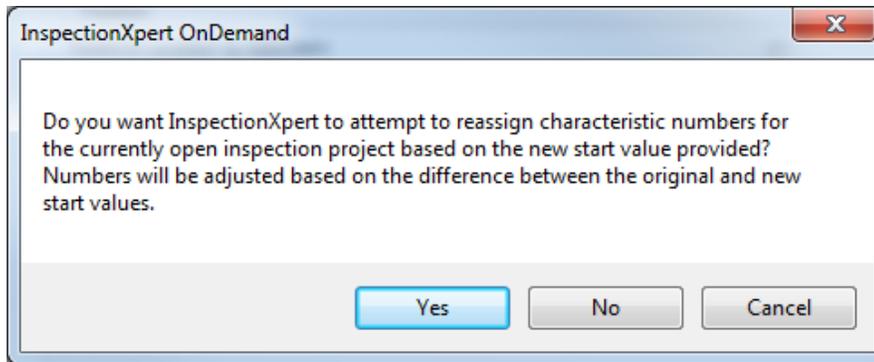


**Note:** Take note of ending balloon number. Where you would like the and on balloons to pick up from.

2. Go to the home tab and choose the selection for options
3. Go to Project Options
4. Choose Ballooning Tab on the left hand side
5. Within the Text section
6. Choose balloon number Starting Value to start with the and on balloon number e.g.16



7. Select OK



8. At the reassign characteristics numbers box click "Yes" (note there should not be any balloons created yet).
9. Extract type e.g. Dimension and balloon features as required e.g. 16 and on  
Note: Characteristic Properties will display 1/1 for the first characteristic created, your starting number chosen will be displayed on the print and also in the Table Manager.

Characteristic 1/1

3X  $\phi$ .125

General

Type: Dimension  
Sub-Type: Diameter  
Units: in  
Quantity: 3  
Value: .125

+ Tolerance: +.030  
- Tolerance: -.030  
Upper Limit: 0.155  
Lower Limit: 0.095

Inspection  
Ballooning  
Custom

Table Manager

Balloon #	Char #	Comments	Qty	Value	Type	Sub-Type	Plus Tolerance	Minus Tolerance
16	16		3	.125	Dimension	Diameter	+.030	-.030

10. Once finished ballooning, Publish to Net-Inspect

Note: Form 3 will only include and on balloon numbers e.g. 16 and on.

**To create balloons as a partial and delta in Net-Inspect (from a non-conformance) starting from already ballooned InspectionXpert OnDemand FAIR, published to Net-Inspect.**

- This allows you create a partial first article that links as a Delta with the original first article that had non-conforming features (failed) to perform a partial FAI for all affected characteristics on the next production run. Form 3 will only contain prior non-conforming features on form 3 with same original characteristic numbers.
1. Within Net-Inspect, from a previously submitted, FAIR, click the Generate Delta link in the top right hand corner of Form 1.

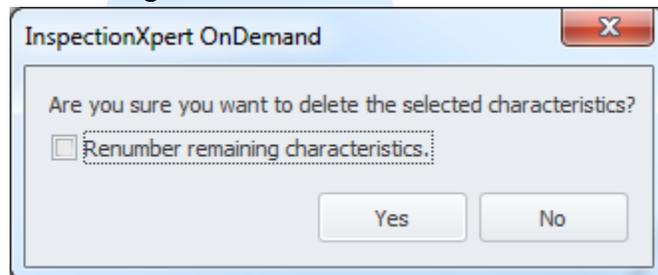


**Note:** Skip to Step 5 if the FAI form 1 within Net-Inspect does not have the “Generate Delta/Follow-up E-FAI Report” link available.

2. This will create new blank FAI with the same part number and corresponding information within Net-Inspect.

**Note:** The FAIR may need to be un-locked by P&W before proceeding.

3. Complete any required information within Net-Inspect e.g. partial information
4. Within InspectionXpert open the already ballooned project
5. Select all balloons that were **not** found to be non-conforming
6. Delete all conforming characteristics
7. Deselect “Renumber remaining characteristics” check box, to not re-number. Unchecking this box will keep the same characteristic numbering for the non-conforming balloons.



8. Click Yes
9. Once finished ballooning, Publish to Net-Inspect

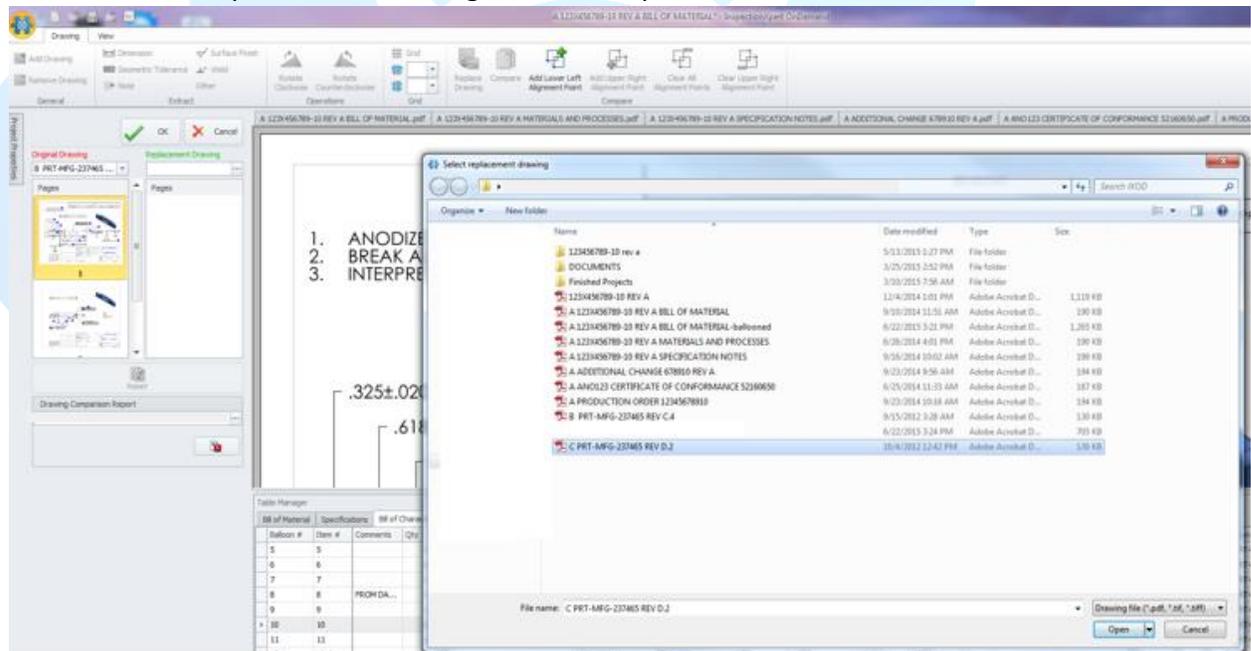
**Note:** Form 3 will only include balloon numbers that were previously found to be non-conforming.

**To create a new revision, a new full or a partial/delta from an already ballooned similar to part.**

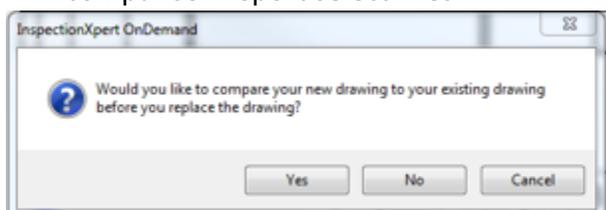
- This allows you create a first article that may have minimal changes or similar features, new drawing revision, compares changes from one drawing to the next without having to balloon a new project i.e. keeps the data you have already ballooned and puts that on a new drawing.

**Note:** Copy the folder of the FAI you are going to use to replace, add the documents specific to the replacement FAI to the new folder.

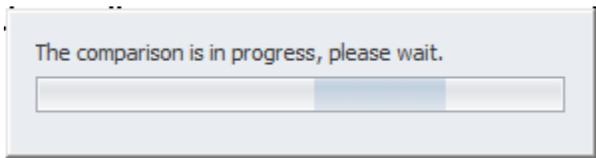
1. Open a previously ballooned project (from within the copied folder)
2. On the tab of the drawing/document you would like to replace with
3. Go to the tab named "Drawing"
4. Choose "Replace Drawing"
5. Select the replacement drawing and click "Open" or double click the document



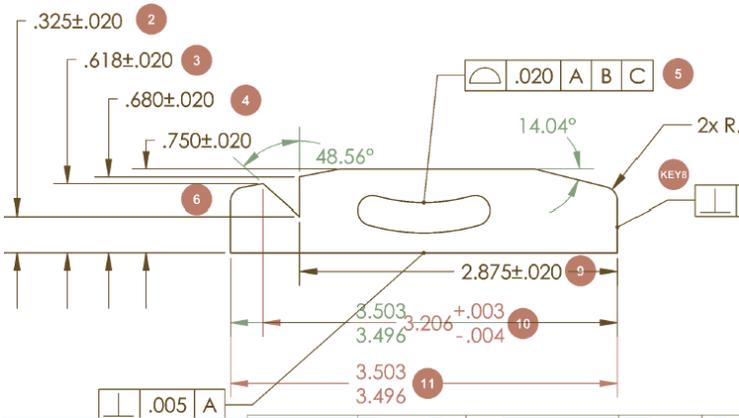
6. If you would like the drawings compared to show you the changes and to create a comparison report select "Yes"



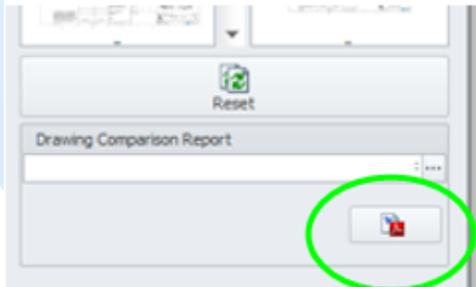
7. The comparison will be performed to show you the changes



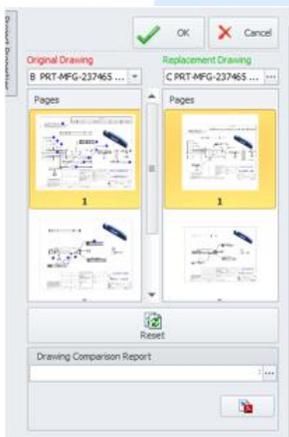
8. A Comparison report will be displayed



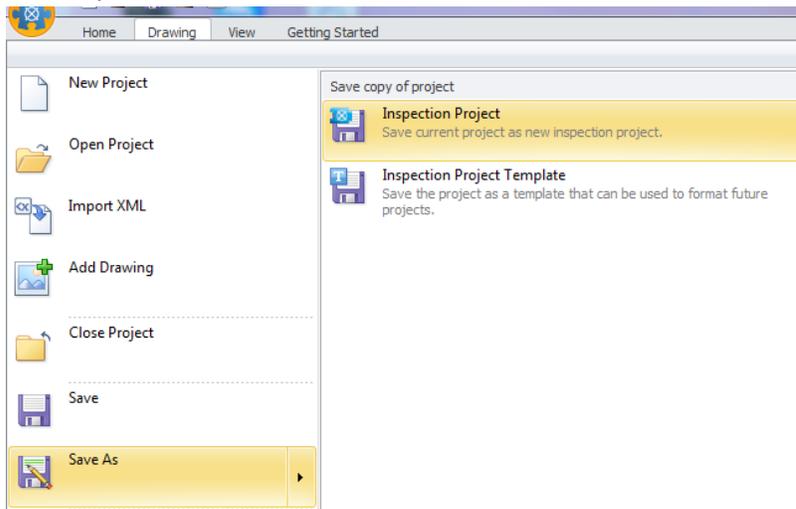
9. To create a pdf copy of the comparison the comparison report/pdf icon



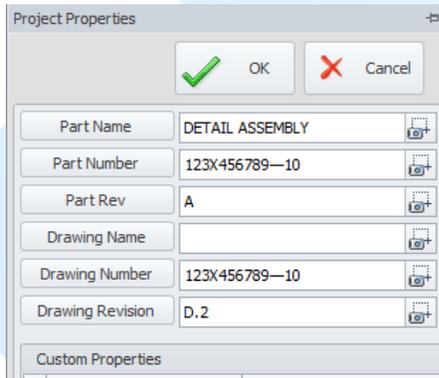
10. Click "OK" to accept the replacement to have the ballooned data applied to the replacement drawing



11. Go to Start Menu and choose "Save As" to save this as a new project save in your copied folder from above.



12. Update Project Properties



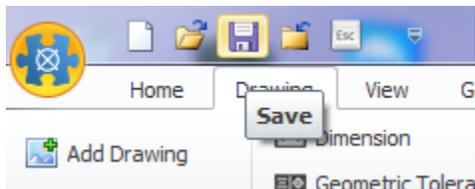
13. Select OK

14. Save project



15. Edit project as needed to account for any changes, remove any documents that are no longer specific to the newly created FAI or replace if they contain ballooned data.

16. Save



17. Once finished ballooning, Publish to Net-Inspect