

CFN Supplier Flow Down: End user MHICA

Supplier must comply with [CFN Standard Purchase Order Terms and Conditions](#) and [CFN-QA-SQR-0001 Supplier Quality Requirements Manual](#). Refer CFN website www.cfnprecision.com, suppliers tab.

This purchase order is for a MHI Canada Aerospace Inc. (MHICA) contract and the requirements of “MAC1000 Supplier Quality Requirements Manual” (latest revision) applies.

Supplied item/process/services shall be to the latest specification.

Special process suppliers shall be listed on Bombardier approved supplier database and/or MHI Canada Approved Controlled Special Process suppliers list (latest revision) for the process and specification being performed. **Note: processing materials that are specification controlled or that require Procurement or Monitoring controls when specified in BAPS are to be procured and tested in accordance with Bombardier Engineering Material Control Manual, EMCM-001. Verification shall be performed by an accredited ISO/IEC 17025 laboratory**

For machining suppliers;

Coolants used per specification controls must be identified, in compliance and documented on the submitted plan when required.

Calibrated functional gauges shall be utilized on splines. 100% inspection shall be performed.

Calibrated functional gauges shall be utilized on threads. 100% inspection shall be performed.

The Supplier and all sub-tiers shall prepare documented work instructions and/or MPS (a detailed sequential document that defines all operations required to produce product), as necessary, for all employees having responsibilities for the operation of processes that impact product quality. These instructions shall be maintained, current and accessible for use at the work station. MPS requiring approval shall be submitted prior to start of manufacturing in accordance with MAC1000 (latest revision). Any manufacturing performed prior to MPS approval is performed at the Supplier's risk.

For material requirements please refer next page

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For Raw Material Suppliers or sub-tier suppliers that procure material for product supplied to CFN:

Special requirements apply to material produced in company(s) located in a country other than the United States or Canada and the country does not have a Bilateral Airworthiness Agreement (BAA) for the product being supplied. If the Supplier intends to purchase raw material stock, forgings, castings and standard hardware from sources outside North America or from a country that does not have a BAA, the Supplier shall notify SPP and obtain concurrence from SPP prior to commencing the procurement activity.

The Supplier shall only use forgings and castings produced by companies approved by MHICA.

In those cases where the Supplier elects to use more than one lot of raw material, the Supplier shall ensure, document and furnish positive traceability of each individual product to the raw material certification/test report that represents the raw material from which each of the products was manufactured. Traceability shall be provided by identifying the raw material heat, lot, batch or melt number from the certification/test report on the product and/or on packaging (when used), or the products segregated and identified.

The Supplier shall comply with the following requirements and flow them down onto all sub-tiers including raw material manufacturers and distributors:

- Test results shall be listed on the Certificate of Compliance/Conformance
- [The Supplier shall ensure material is procured and that periodic raw material verifications are conducted in accordance with Bombardier Engineering Material Control Manual, EMCM-001. Verification shall be performed by an accredited ISO/IEC 17025 laboratory](#)
- The Supplier shall have a method to test each batch/ heat/ lot of material.
- All forgings, castings and swaging's shall be identified with a vendor code or logo, which shall be specific to that particular manufacturer and/or per drawing requirements.
- Serialization of forgings and castings is required.
- The Supplier's raw material sources shall have a process control methodology in place for identifying tracking and trending for the following key characteristics Ultimate Tensile Strength (UTS), yield strength (VS), Elongation, and Reduction of Area (RoA). Results and actions taken shall be made available upon request.