

CFN Supplier Flow Down: End user SPP

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 SPP contract and the requirements of “AQ-112 Quality Management System Requirements for Supplier” (latest revision) applies.

The following SPP special program specific quality requirements also apply:

CRJ and Gulfstream programs – “AQ-833 SUPPLIER QUALITY REQUIREMENT FOR THE PARTS OF CRJ AND G650 PROGRAM” (latest revision).

Honda Jet – “AQ-838 SUPPLIER QUALITY REQUIREMENTS FOR HONDA JET PROGRAM” (latest revision).

Supplied item/process/services shall be to the latest specification. For Boeing specifications refer CFN-QA-SQR-0006, refer CFN website www.cfnprecision.com suppliers tab.

For Special process suppliers:

Special process shall be approved by SPP_QA and/ or SPP’s customer prior to processing. Special processes to be approved are shown in AQ-125 Table-1.

When the Nadcap accreditation is required by SPP’s customer, supplier shall be Nadcap accredited. The following table shows special process and SPP’s customer who is requiring Nadcap accreditation.

顧客 Customer	適用機種 Applicable Project	Nadcap Commodity								
		HT	CP	NMSE	NDT	WLD	CMSP	MTL	MI	
Collins Aerospace - Goodrich - Hamilton Sundstrand	- CRJ-700/900/1000 - ERJ170/190, MRJ(Heat Exchanger), MA700	適用 Required	適用 Required	適用 Required	適用 Required	適用 Required	適用 Required	適用 ^{※1} Required	適用 Required	-
Rolls-Royce - Rolls-Royce plc. - Rolls-Royce Deutsland	- TRENT (All), <i>RB3069</i> - BR(All), RB3043	適用 Required	適用 Required	-	適用 Required	適用 Required	-	-	-	適用 ^{※3} Required
SAFRAN - Safran Landing Systems - Safran Aero Boosters	- CL601/605, M184, BD100 - Passport20	適用 Required	適用 Required	適用 ^{※2} Required	適用 Required	適用 Required	-	適用 Required	-	-
Pratt & Whitney Canada - B787(APU)	- B787(APU)	適用 Required	適用 Required	適用 Required	適用 Required	適用 Required	-	適用 Required	-	-

※1 抗張力180ksiを超える鋼上の表面皮膜(クロムメッキ及びHVOF)の研削加工に限る
Limited to grinding of coatings (chrome plate and HVOF) applied to components composed of high-strength steel which has been heat treated above 180ksi UTS

※2 ショットピーニングのみ
Shot Peening

※3 製品の最終測定に3D 構造化光(3DSL)を使用する場合、AC7130/4 のNadcap 認証を受けること
All suppliers manufacturing Production Product and utilising 3-Dimensional Structured Light (3DSL) for final product measurement shall be accredited to Nadcap AC7130/4

(Nadcap Commodity)

HT: Heat Treating

CP: Chemical Processing

NMSE: Nonconventional Machining & Surface Enhancement

NDT: Non Destructive Testing

WLD: Welding

CMSP: Conventional Machining as Special Process

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.

CFN Supplier Flow Down: End user SPP

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 SPP approval shall be submitted prior to start of manufacturing in accordance with AQ-112 (latest revision). Any manufacturing performed prior to MPS approval is performed at the Supplier's risk.

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 SPP.

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 periodic raw material verifications are conducted. Verification shall be performed by an accredited lab.
- 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.

