

CFN Supplier Flow Down: End user Heroux Devtek

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.

Heroux Devtek Quality Assurance Requirements HPS-010 applies.

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.

Special process suppliers shall work to Heroux Devtek approved MPS/Technical Plan/Technique sheet and revision as applicable and shall quote the "Supplier Data Review (SDR)" number and revision on their certificate of conformance. No changes shall be made to MPS/Technical Plan/Technique sheet without SDR approval, reference HPS-010 for requirements. Special process suppliers shall be listed on Heroux Devtek ASL for the process and specification being performed. Note for Heroux Devtek customer specifications the supplier must maintain the applicable Heroux Devtek customer approval. For Boeing D1-4426 Processes refer to the following link for a list of approved processors and information regarding Nadcap approval requirements:

<http://www.boeing.com/companyoffices/doingbiz/d14426/index.html>

Please note this unique requirements from HEROUX for FAIs to be conducted for all special processes by the special processors. HEROUX WILL NOT ACCEPT PRODUCT IF CFN PERFORMS THE FAI ON BEHALF OF HEROUX, it must be done by the special process supplier:

Unless noted otherwise in the Purchase Order, the Supplier (Including Special Process Supplier) shall abide to the requirements of the Aerospace Standard AS-9102 "Aerospace First Article Inspection Requirement" when completing a FAI or a delta FAI package. This includes using AS-9102 forms 1, 2 and 3 to document the results of the FAI.

This applies to all processors as well . Ex. Processor performing chrome plating is expected to submit his FAI (Form 1, 2 & 3 as applicable). This will include all drawing characteristics, notes, parts list requirements including Manufacturing Control Drwg's or equivalent. To clarify, this means every note in the Manufacturing Control drawing that calls for a specific feature or characteristic, must be listed separately on the FAI report to ensure 100% conformance. This would include such typical chrome plating features in addition to size such as thickness & runouts. Note: It is not acceptable for processors to simply provide a C of C as evidence of their FAI. Suppliers who just supply C of C's will have parts rejected and NCR's raised.

For heat treat processors one hundred percent hardness inspection is required and must be certified as such on the certificate of conformance. For serialized parts, heat treat sources shall record actual hardness values for each serial number.

For machining suppliers;

Approved lubrication/coolant is required and must be documented on the certificate of conformance when BAC5540 and BAC5008 are required for post heat treat machining of Boeing components for Heroux Devtek.

Use of approved lubrication/coolant per PCS4002 is required for machining of finish dimensions on Messier Bugatti Dowty components for Heroux Devtek. Lubricant/coolant utilized must be documented on the certificate of conformance.

Approved coolant required when grinding in accordance with HPS182

Calibrated functional gauges shall be utilized on splines. For "designated parts" per MP-107 the Major/Minor diameter and fillet radius values on external splines must be recorded.

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Calibrated functional gauges shall be utilized on threads. For “designated parts” per MP-107 the Major/Minor diameter, pitch diameter and root radius values on external threads must be recorded. On internal threads Minor and pitch diameter values must be recorded for “designated parts” per MP-107.

Dimensional inspection report required with each shipment.

In addition to Certificate of Conformance requirements specified in CFN-QA-SQR-0001 suppliers working to D1-4426 Processes shall list the title of the process specification being performed, the date processing occurred and the processor’s Boeing assigned code from D1-4426 listing.

Special FAI Requirements for Boeing Commercial Programs ([777](#), [737](#), [747](#), [757](#), [767](#) and [787](#)): All FAI’s and Delta-FAI’s must be completed and loaded into Net Inspect. See HDI Quality Alert # 2015-002 for more details.

Components produced from Beryllium Copper must be tagged with Heroux Devtek tag F7.5.5-6 Rev NC

For part classified as Heroux Devtek “DESIGNATED PART” manufacturing plan approval per MP-107 is required

For part classified as Boeing “DESIGNATED PART” manufacturing plan approval per D6-1276 is required

Refer next page for requirements for Raw Material, Forging and Casting Suppliers (to be flowed down if sub tier to CFN is responsible for procurement of raw material, forgings or castings on product supplied to CFN)

Forgings and Castings

- AS9100 registered QMS required
- HPS-710 applies

Distributors (Raw Material/Hardware)

- AS9100 or AS9120 upon HDI request
- HDI approval (HPS-010)
- Designated part (MP-107) HDI/Customer Compliant

For raw materials forgings and castings accepted on the basis of certification and/or test reports, the Supplier must verify the chemical and physical properties of the material recorded on the certificates and test reports against the applicable specification(s) and maintain evidence of quality control acceptance. The supplier shall ensure the material used is from an approved Mill supplier and that the material has not been converted to a different size or form by the material distributor or any other intermediate/final converter. Certificates of compliance provided by material distributors are not acceptable in lieu of Mill material certifications.

Certification shall include (as applicable):

- Supplier Name and address
- Certificate number
- Supplier work order number
- Purchase order number
- Part number and description
- Serial number or lot number
- Quantity
- DCR number
- Material used, name of source, certificate number and date of actual material certification, melt or serial or batch number.
- SDR number

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- Non-conformity report
- Metallurgical report (chemical and mechanical analysis, mill certificates)
- Signature and stamp of person authorized to release the product
- Date of Certification