

Supplier Quality Assurance





Source Inspection FAI Process At A Glance

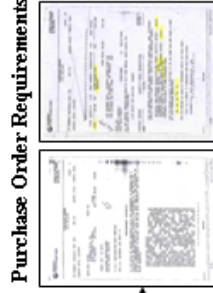
Perform Required inspections utilizing the following

Supplier FAI Package

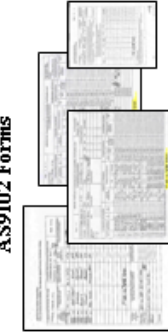
- Supplier will perform 100% FAI inspection of all drawing features and submit the product and all supporting documentation to SSI for review i.e. the Purchase order ,Drawing, Opt Sht, M&P Index,PartsStandard,ASL, AS9102 forms.

SSI Package Review

- SSI will review the submitted Documentation for
 - Completeness
 - Correctness



AS9102 Forms



ASQR-01 Doc.



- SSI reviews suppliers FAI per AS9102 inspection reports to ensure all the required data and drawing characteristics were adhered to per po,ASQR-08.2 requirements.

Parts List



Opt Sht



- SSI reviews the Parts list for required materials
- SSI reviews suppliers material certs

Materials Certs



Process Certs



- SSI reviews the Process Certifications with cross reference to the required ASL, M&P index, Part standard index when required.

M&P Index



QATI 3157

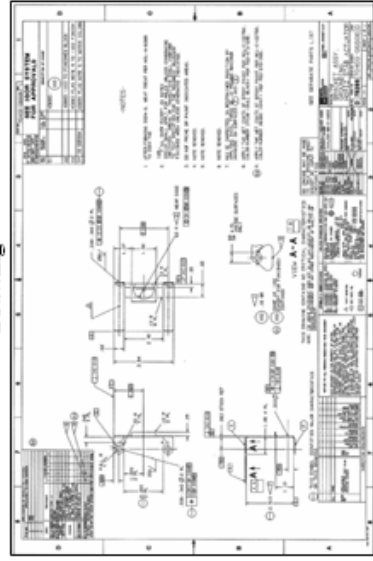


- SSI reviews Dwg's, sheet metal CCL/PCL, And QATI 3157 for inspection requirements and required gagging

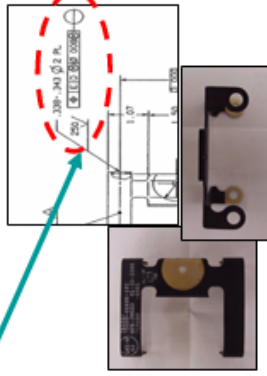
CCL'S



Drawing



- SSQS to determine Sample Size to be inspected
- SSI (MOI) Tooling i.e. T002, T4008
- S/A Mylar's (7mil Thk.) full scale
- T358 Flat pattern Mylar
- Drawing, Part List, Opt Sht.
- 100%Dimensional inspections to be performed on only "non-Geometric Dimensions less than or equal to .003 Tol. range, Geometric dimensions less than .005 Tol. range, Chamfers less Than .010 Tol. range, and angles less than 1°Tol. Range all other features are sampled per: QAP L201 (C=0 AQL 1.0)



After completion of inspection process stamp all required documents i.e. certs, AS9102 forms and stamp the part.

Documents That Define The SSI Program

- ASQR-01 - Aerospace Supplier Quality Requirement
- Approved Source List (ASL) of Special Process Suppliers
- SS 7777, Material and Process Specifications Index
- SAE AS9100 Aerospace Quality System – Model for Quality Assurance in Design, Development, Production, Installation, and Servicing
- SAE AS9101 Quality System Assessment Reports
- SAE AS9102 Aerospace First Article Inspection Requirement
- SA 908, Attachment to Sikorsky Aircraft Purchase Order
- Standard Parts Index

Documents Defining Inspection Requirements

- Supplements and SA 908 Attachment
- Engineering Drawings With All Changes (E.O.'S, R.T.E.'S)
- Sikorsky Aircraft Operation Sheets
- Specifications and Standards
- Approved Source List for Special Processes and Laboratories
- Standard Parts List
- SS777, Material and Processing Index
- ***“Original”*** Certifications for All Processes Conducted by SAC Approved Sources
- SA5193 Form - Receiving/Source Inspection Critical Characteristics Checklist
- First Article Checklist per AS 9102 (When required by P.O./ SSQS)

Documents Defining Inspection Requirements (Cont.)

- For Reduced Dimension Type Drawings
 - Coordinate Measuring Machine Programs/ Readouts
 - Reduced Dimension Drawing Approval Letters
- Review **ALL** Documentation to Assure Revision Levels Meet PO Requirements
- Quantity of Product Shipped Is Per the Purchase Order, SSQS and Shipping Documents
- Authorized MRB Parts Are Properly Processed and Annotated on Shipping Documents When Required
- Packing Slip/SSQS Shipping Authorization Is Accurate and Complete
- When Government Contract Quality Assurance/government Source Inspection Is Invoked on the Purchase Order:
 - Insure Government Representative Final Acceptance Is Properly Documented and Applied to the Appropriate Shipping Documentation As Required

Utilization of Other Required Documents

- Supplier Inspection Check List for both detail parts and assemblies
- Material certification identifying chemical, mechanical and physical properties for raw material
- Sikorsky test plans for raw material
- Form SA 342 or SSQS Non-Conforming Material/Rejection Report
- Acceptance and Test Procedures
- Kit List
- Correct Quantity of Part (As required by purchase order)
- Review of Alerts/Bulletins received from SQM's office via SSQS system and SAC Portal to determine if any additional instructions are required prior to performing inspection

Utilization of Other Required Documents (Cont.)

- Review the Inspection Documentation and Process Certifications to Assure Specifications and Revision Levels Are in Accordance With PO Requirements
- Prior to Conducting Any Material Inspections, Verify That All Inspection Instruments to Be Used During the Inspection Are Calibrated and Have a Calibration Due Date Sticker Attached

Supplier Performance

- Supplier Evaluation
 - UTC Common Report Card is an established method for determining supplier performance and consists of the following elements:
 - Defective Parts Per Million
 - Escapes
 - On Time Delivery
- DQR Evaluation
 - DQR performance will be evaluated by designated SQAR utilizing the Delegated Quality Representative Assessment Checklist.
(Ref: UTCQR Form 7)
- Periodic Audits
 - Audits of the DQR to review the implementation, compliance, and effectiveness of the Authorized To Release (ATR) Program will be conducted at the discretion of the SQAR based on supplier performance.