QUALITY REQUIREMENTS APPLICABLE TO SUPPLIERS

1. GENERAL

1.1. Purpose

1.1.1. This document defines the contractual obligation for Suppliers when it is specified on the Safran Power Units purchase orders. If, however, a purchase order specification differs from those within this document, the conditions documented in the purchase order shall take precedence.

1.1.2. This procedure is complementary to Safran Group Procedure GRP-0087 and defines Safran Power Units specific requirements.

1.2. Scope

1.2.1. This document applies to all purchased, subcontracted or manufactured products, services or processes. It does not apply to non-production suppliers.

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1.3. Revision History

REV	DATE	CHANGE
New	5/15/15	Initial Release
A	6/8/15	Added functional categories to align with engineering drawings, removed Type 1 and Type 2. Added retention time requirement (10 yrs.) Added supplier responsibility statement to implement controls to ensure no counterfeit parts are used
B	7/14/15	Added Section to include how the supplier is notified of NCM detected at Safran Power Units or at the customer
C	9/23/15	Section added to define Supplier deviation/waiver process
D	10/26/15	Definition for types of non-conformities. Deviation requirements for minor and major NCM's. Requirement for SCAR's including timeframe for reply, form to utilize and actions if overdue. Flow down of requirement including special processes. Restructured procedure for process clarity
E	2/26/16	Updated with Acronyms. Added External Referenced Procedures. Updated 2.25.2, minor changes.
F	4/27/16	Added record retention requirements, updated ATP requirement flow down and defined deviation requirements for both source control suppliers and suppliers with design authority. Added Revision History section.
G	7/28/16	Defined "Part Nonconformity" and "Part Discrepancy" and clarified the Supplier Requirements appropriate for each condition. Removed "Legacy" from the title, this procedure is now applicable to all Suppliers.
H	11/14/2016	Update logo and export footer to reflect name change. Added requirements for Counterfeit Parts Updated Title
I	4/19/2017	Section added for Key Characteristics monitoring to require our suppliers to apply key characteristic control. Added definition for Key Characteristics
J	10/18/2017	Added another situation that defines a Part as Nonconforming to align with OP-830-01. Added requirement for test data for electronic hardware containing software.
K	1/25/2018	Add requirement for effectiveness verification for corrective actions resulting from supplier deviations/waivers. Added requirement for engineering review on recurring non-conformances. Added requirements for ethical behavior and product safety awareness and the use of customer designated suppliers.
L	7/17/2018	Added process for Drop Ship Authorization.
M	11/21/18	Added the quality objectives and expectations from suppliers.
N	1/31/19	Added note to Section 2.18 regarding SPU Toulouse FAI's
O	11/15/19	Included statement regarding shipments directly from one supplier to another
P	4/6/2020	Sec. 2.18.2, 2.18.4 and 2.19.15 to add FMEA and control plan requirements when changes affect product design, manufacturing and or inspection process.

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1.4. Definitions

Basic audit

The basic audit is conducted to examine compliance of processes and knowledge of the basics of job function. It may cover all company processes (purchase, delivery, manufacture, etc.) and/or deal with a specific topic (personnel skills, resources, special processes, configuration management, Safety Management System, the processing of non-conformities, etc.) in direct or indirect liaison with the product or service Quality department.

Functional Categories (for information)

Category 1

Part (finished and indivisible component or assembly) whose failure in service can have a dangerous effect on the aircraft it outfits on, and / or endanger the surrounding environment: bursting, uncontrolled fire, separation of the engine....

Category 2

Part (finished and indivisible component or assembly) whose failure is not unlikely, could result in a voluntary or involuntary stop of a system operation, but has no dangerous effect on the aircraft it outfits and / or does not endanger the immediate environment....

Category 3

Any part (finished and indivisible component or assembly) not classified CF1 or CF2 whose failure could not cause the above risks

Flight Safety Parts

Any part, assembly, or installation containing a critical characteristic whose failure, malfunction, or absence could cause:

- A catastrophic failure resulting in loss or serious damage to the aircraft,
- An un-commanded engine shutdown resulting in an unsafe condition.

Key Characteristics

An attribute or feature whose variation has a significant effect on product fit, form, function, performance, service life or producibility, that requires specific actions for the purpose of controlling variation.

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Manufactured Product

Article which is designed by Safran Power Units and whose manufacture is accomplished according to procedures and with materials supplied by Safran Power Units.

Part Discrepancy

A part classified as exhibiting a discrepancy is limited to irregularities found insignificant in nature which do not reach a classification of non-conforming. Examples of discrepancies include, but are not limited to, visual or any other discrepancies that do not affect fit, form, function, flight safety, airworthiness, reliability, interchangeability, performance, previous testing or deviation from Safran Power Units applicable design specification.

Part Non-Conformity

A part is defined as Non-Conforming when there is at least one affirmative answer to the following 8 questions:

- Can the non-conformity affect flight safety and/or airworthiness during the service life of the equipment?
- Can the non-conformity affect operation, performance, a critical or essential function, or correct application?
- Can the non-conformity affect dimensional interchangeability (overall dimensions, attachment, connections, drive, etc.)?
- Can the non-conformity affect service life, structural parts, dependability (operational reliability)?
- Can the non-conformity affect the correct application of the procedures defined in maintenance, repair and installation manuals?
- Can the non-conformity affect the electrical, adjustment and/or control characteristics or the adjustment and/or control software?
- Can the non-conformity affect the validity or acceptance of the report results for previously accomplished part performance testing and/or analysis?
- Does the change affect compliance to any released certification data?

Purchased Product

A product not designed by Safran Power Units but defined by a Safran Power Units specification. It may also be a standard product or a product purchased from a catalog.

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Segregation/Isolation Measures

The action of identifying and isolating one or more products that have a potential or proven non-conformity.

Special Process

A process used in an operation or in a series of operations of the manufacturing process which is likely to bring about changes in the physical, chemical or metallurgic properties of an item which are not directly detectable in the normal sequence of its manufacturing cycle. Non-destructive inspections (NDT/NDI) are included in this category.

Sub-Assembly

Functional sub-assembly of a product that has individual performance criteria that can be checked by acceptance test conditions.

Subcontracted Product

An article which is designed by Safran Power Units but whose supplier works independently for the manufacture and procurement of the material.

1.5. Acronyms

CAR Corrective Action report

CF1 Functional category 1

CF2 Functional category 2

CF3 Functional category 3

CMM Coordinate-Measuring Machine

DQR Designated Quality Representative

FAA Federal Aviation Administration

FAI First Article Inspection

KPC Key Product Characteristic

MRB Material Review Board

NADCAP National Aerospace and Defense Contractors Accreditation Program

NCR Non-Conformance Report

NDT/NDI Non-Destructive Testing/Inspection

OTD On Time Delivery

P/N Part Number

PAR Preventive Action Report

PPM Parts Per Million

QMS Quality Management System

R/R Request / Reply

SCAR Supplier Corrective Action Report

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1.6. References / Documents

GRP-0087	SAFe- Safran Requirements to Supplier
GRP-0132	Overall Supply Source Performance Measurement
OP-424-01	Control of Records
OP-741-01	Supplier Assessment, Selection and Qualification
OP-743-02	Designated Quality Representative (DQR) Process
FM-741-09	Notice of Delinquency for Supplier Corrective Action Request
FM-741-10	Drop Ship Authorization Form
FM-743-02	Request / Reply
FM-830-03	Deviation / Waiver Request
FM-852-01	CAR Form
FM-853-01	PAR Form
AS/EN 9100	Quality Management Systems - Requirements for Aviation, Space and Defense Organizations
AS/EN 9102	Aerospace First Article Inspection Requirement
AS5553	Counterfeit Electrical, Electronic, and Electromechanical (EEE) Parts; Avoidance, Detection, Mitigation, and Disposition
AS6174	Counterfeit Material; Assuring Acquisition of Authentic and Conforming Material
AS13001	The standard applies to aero engine suppliers operating a self-release process as a delegated activity from the delegating organization.
ISO 10012	Measurement Management Systems - Requirements for Measurement Processes and Measuring Equipment - First Edition
ISO 14253-1	Geometrical product specifications (GPS) - Inspection by measurement of workpieces and measuring equipment
ISO 17025	General requirements for the competence of testing and calibration laboratories

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1.7. Document Summary

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2. PROCEDURE

2.1. Supplier Audits

2.1.1. The Supplier must perform:

- An internal audit every 2 years covering its complete Quality Management System.
- Special process audit per NADCAP requirements.
- Safran Power Units reserves the right to review the results of these audits.

2.1.2. Verification activities performed by Safran Power Units

2.1.2.1. Verification activities performed by Safran Power Units across all supply chain levels shall not be used by the Supplier as proof of effective quality control and do not exempt the supplier from its responsibility to provide a satisfactory product that meets all requirements.

2.2. Control of Quality Documents

2.2.1. The Supplier is responsible for maintaining current documents and any additional referenced Safran Power Units quality documents that are associated with the contracted work.

2.2.2. The Supplier is responsible for contacting Safran Power Units for confirmation of revision status of this procedure and any other document referenced herein or applicable by purchase order requirement, prior to the commencement of work. Documents and their updates are dispatched by Safran Power Units Purchasing Department.

2.2.3. The supplier shall control all documents received from Safran Power Units, from the manufacturer or from the Regulatory Authority (Airworthiness Directives), writing and management of work instructions necessary for the correct execution of the work.

2.2.4. Documentation shall be controlled in accordance with Standards AS/EN 9100. For each completed purchase order, the Supplier shall return the required documents with the shipment of manufactured articles.

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2.2.5. Any modifications or corrections made on supplier's documents (manufacturing or inspection files, manufacturing follow-up sheets, instructions, procedures, etc.) must be documented in ink and a single line drawn through the original text, leaving it legible and traceable. The type of modification, date, name and signature of people who carried out and approved the modification must be documented. The modification must be performed by authorized personnel and authorized personnel must be clearly identified.

2.2.6. All quality records (dimensional or functional records) in paper or electronic formats, shall be retained on file/archived in accordance with Safran Power Units quality records procedure OP-424-01.

2.2.7. When the Supplier is reviewing a manufacturing and/or an inspection purchase order or any other Safran Power Units production/service request, any remarks and/or questions must be submitted in writing using form FM-741-02 and sent to Safran Power Units.

2.3. Supplier Approval

2.3.1. Safran Power Units assesses and qualifies its Suppliers in accordance with the procedure OP-741-01, Supplier Assessment.

2.4. Performance and Quality Objective

2.4.1. Safran Power Units will periodically provide the Supplier with feedback on its performance objectives (Quality and On-Time Delivery) and the expectations to be complied with.

2.4.2. Suppliers' performance is monitored through incoming inspection history, on-time delivery and non-conforming material records.

2.4.3. Suppliers are expected to maintain a high level of Quality performance. Both rejection rates and concession rates are tracked and monitored. The allowable rejection rate (measured by all non-conforming parts discovered after leaving Supplier's quality system divided by the total number of parts delivered) and concession rate (measured by all product delivered with known and approved specific non-conforming

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characteristics divided by the total number of parts delivered) is no more than 2% based on a rolling six (6) month measurement.

2.4.4. Suppliers are expected to maintain On-Time Delivery. Time is of the essence for all deliveries of purchased parts which are expected to be delivered to Safran Power Units no earlier than a week from, and no later than, the due date called out on the PO.

2.4.5. Should Supplier's delivery performance rating fall below ninety-nine percent (99%) for more than two (2) consecutive months, Supplier shall provide Safran Power Units with a recovery plan within two (2) weeks of requested date.

2.4.6. Safran Power Units reserves the right to re-evaluate supplier's approval status and take appropriate action at any time based on, but not limited to, the following criteria:

- A prolonged interruption of Supplier activity lasting more than 2 years
- A change to the Supplier's organization or structure
- A major discrepancy following an audit at a supplier, not rectified within the allocated timeframe
- Poor performance or deterioration of the quality of supplier services

2.4.7. These actions may include the withdrawal of qualification or financial penalties (administrative costs, rework costs, retrieval costs, rejection costs, transportation costs or costs of impact on the end customer).

2.4.8. In some instances, the articles ordered are placed under the monitoring of an official service such as:

- The Federal Aviation Administration (FAA), Civil Aviation Safety Organization (OSAC), the General Civil Aviation Authority (DGAC) or the European Aviation Safety Agency (EASA) for civil contracts.
- A foreign airworthiness authority for export contracts.

2.4.9. Orders subjected to any of these agencies quality monitoring must include the following clause:

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- These Regulatory Agencies must have free access to premises and documents associated with the service provided by the Supplier and any subcontractors to be able to monitor quality.

2.5. Verbal Instructions

2.5.1. Verbal instructions or agreements shall not be considered in any case as an approval or authorization.

2.6. Special Processes

2.6.1. Supplier of special processes and those of their sub-tiers must be NADCAP Approved.

NOTE: *This does not apply to equipment and purchased products. However, suppliers of these types of products must have an organization that allows these processes to be managed in compliance with the requirements of the current version of AS/EN 9100.*

2.7. Skill Management

2.7.1. The supplier shall:

- Determine the skills required for the personnel performing work with an impact on product quality
- Establish a continuing training program to ensure that the skills of the personnel responsible for specific tasks are maintained current.
- Provide training or undertake other actions to satisfy these requirements
- Assess the effectiveness of undertaken actions
- Ensure that members of its personnel are aware of the relevance and importance of their activities and of their contribution to the attainment of quality objectives
- Keep suitable records regarding initial, recurrent and professional training knowledge and experience.
- Suppliers shall ensure that all their employees are aware of their contribution to product safety and the importance of ethical behavior.

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2.8. Vision Exam

2.8.1. Individuals performing visual and dimensional inspection will require an annual vision exam by a medically qualified individual (protocol according to Snellen 14/18 or equivalent).

2.9. Monitoring of the Supplier Subcontractors

2.9.1. Purchase orders issued by suppliers to their sub-tiers must accurately describe the quality requirements and include at a minimum the requirements specified by Safran Power Units, including specifications and key characteristics.

2.9.2. Safran Power Units may prohibit the Supplier from using the services of a subcontractor that does not have an acceptable quality system.

2.9.3. When required by Safran Power Units, suppliers shall use Safran designated or approved sub-tier providers, including process sources (e.g., special processes).

2.10. Safran Power Units Supplied Materials

2.10.1. Materials provided by Safran Power Units may only be used to satisfy the Safran Power Units purchase orders, unless otherwise specially authorized.

2.11. Maintenance Service Performed by the Supplier

2.11.1. The Supplier will ensure that the work it carries out complies with the Safran Power Units contract requirements. In the event of a deviation, the Supplier must inform Safran Power Units in writing in order to resolve the discrepancy prior to the continuation of work.

2.11.2. A report must be attached for equipment maintenance services. The report shall describe:

- The work performed,
- The maintenance documents used (reference and issue),
- The main parts replaced,
- The applied Maintenance information (other than CMM's),
- The applied Service Bulletins,
- Airworthiness Directives applied.

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2.11.3. Safran Power Units suppliers are responsible for the design, qualification and manufacturing of tools and equipment per Safran Power Units technical specifications.

2.11.4. Additional requirements may be imposed as a Safran Power Units document relative to equipment, e.g. technical specifications and standards.

2.11.5. Ensure that the personnel undertaking the return to service of the equipment is qualified and certified in accordance with the Regulatory Authority's requirements.

2.11.6. Ensure that training is provided and incorporates should there be changes in regulatory requirements, in procedures of the organization and changes maintenance standards.

2.12. Limited Life Materials

2.12.1. Limited life materials shall be identified and controlled in accordance with manufacturers specifications.

2.13. Traceability and Archiving

2.13.1. Counterfeit Control

2.13.1.1. The supplier must implement a counterfeit detection and elimination process to meet the intent of the SAE standards AS5553 for electrical, electronic and electronic-mechanical parts and AS6174 for non-electrical standard parts.

2.13.1.2. All electrical, electronic, electro-mechanical, and non-electrical standard parts delivered to Safran or used on products delivered to Safran, shall have certificates from the original component manufacturer (OCM) / original equipment manufacturer (OEM) or authorized aftermarket manufacturer (AAM) or OCM/OEM authorized distributor chain. If traceability is not obtainable, written notice shall be provided to Safran's Supplier Quality Engineer or Buyer prior to delivery.

2.13.1.3. The certificate shall clearly identify the name and location of all of the supply chain intermediaries from the original manufacturer to the final source of the product delivered to Safran.

2.13.1.4. Suppliers who deliver source controlled assemblies shall flow this requirement to their sub-tier suppliers.

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2.13.1.5. Supplier must inform Safran immediately if it becomes aware or suspects that counterfeit parts or work have been furnished,

2.13.1.6. Safran holds its suppliers responsible for all costs related to the segregation, removal and replacement of counterfeit parts and work including its customer's costs.

2.13.1.7. Upon confirmation of counterfeit parts, supplier shall report the incident to the Government Industry Data Exchange Program (GIDEP) and applicable US Government investigative authorities.

2.13.2. For maintenance services, the supplier shall ensure the traceability between the contract and all the elements of the work file.

2.13.3. Subcontracted or manufactured products must be marked as per drawing flow down.

2.13.4. Parts listed on the same manufacturing batch shall come from the same material batch.

2.13.5. Traceability of purchased parts must be accomplished at a minimum with the P/N and manufacturing batch number.

2.13.6. The retention (archiving) times for all documents associated with the products shall be in accordance with OP-424-01 (Control of Records Procedure.).

2.13.7. Records shall remain legible, readily identifiable and retrievable

2.13.8. Archiving of X-Ray radiographs is the responsibility of the supplier. Radiographs of type parts must be sent to Safran Power Units. The supplier shall insure the identification of radiographs to the product.

2.13.9. Functional categories are indicated on the technical data associated with the article (attached to Safran Power Units purchase orders).

2.14. Calibration of Measuring and Test Equipment

2.14.1. Measuring instruments must be monitored and calibrated in compliance with standards ISO 10012 and ISO 17025.

2.15. Product Inspection

2.15.1. The inspection of the product shall be performed according to ISO 14253-1 standard.

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2.15.2. Functional Tests and/or Acceptance Test Procedure (ATP):

2.15.2.1. Functional tests and/or ATP's must be performed on items or equipment when required per the drawing or any other documentation flow down.

2.15.2.2. All required ATP's and subsequent changes shall be submitted to Safran Power Units for review and approval prior to implementation.

2.15.2.3. The ATP check charts and/or data sheets shall be delivered to Safran Power Units with the shipment of the items or equipment.

2.15.2.4. The supplier shall ensure the integrity of test operations carried out, and test date, including the identity of the person who carried out the operations, has been completed and documented.

2.15.2.5. Key Product Characteristics (KPC's) shall be managed per QS004 "Variation Management of Key Characteristics". Maintenance and retention of any KPC data is the responsibility of the supplier. Copies of inspection data must be available to Safran Power Units or its customer upon request.

2.15.2.6. New supplier evaluations will include verification that a process exists for the control of KPC's and compliance with QS004. Random spot audits may also be conducted for current suppliers to verify compliance.

2.15.2.7. All electronic hardware that contains software shall be tested by the supplier and the test results (e.g.: Acceptance Test Results) shall be submitted for review and approval prior to shipment.

2.16. Designated Quality Representative

2.16.1. Safran Power Units reserves the right to apply the Designated Quality Representative (DQR) process at the Supplier's facility in accordance with procedure OP-743-02, DQR Process. The aim of this strategy is to retain AS13001 (or equivalent) certified supplier DQR's. The representatives will receive a nominative approval and will be individually authorized to release Safran Power Units products. Suppliers with approved DQR(s) will be given preference during discussions regarding future bids.

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2.17. Drop Ship Authorization

2.17.1. A supplier may be delegated to submit a shipment directly to another SPU San Diego supplier or directly to a customer's facility on behalf of Safran Power Units; this is commonly referred to as "Drop Ship". This situation can only be arranged if requested by SPU San Diego in writing.

2.17.2. Suppliers who have successfully demonstrated compliance to the terms of this document may be granted drop ship authorization.

2.17.3. All required approval conditions that need to be fulfilled for the drop shipment will be defined on the Dropship Authorization Form, FM-741-10. The information on this form will include the requirements for inspection and the time frame, part numbers, P.O. numbers, etc. that the authorization is valid for.

2.17.4. A requirement for drop shipment from a supplier that has not been granted DQR authorization will either be physical source inspection at the suppliers or the recipients facility or an electronic confirmation by SPU San Diego of all records verifying the supplier's inspection prior to shipment (inspection checklist, photographs, etc.).

2.17.5. If the shipping supplier has DQR approval by SPU San Diego, source inspection may not be required. All shipments shall include a copy of the approved DQR checklist, FM-743-03. In addition to including with the shipment, the DQR checklist, Certificate of Conformance and shipping documentation must be submitted to SPU San Diego prior to shipment.

2.17.6. The receiving supplier shall be responsible to determine the conformity of the received products or services through receiving inspection, and any other activity necessary to determine conformity.

2.17.7. Supplier Quality Assurance will maintain a record of suppliers that have been granted drop ship authorization on the Approved Supplier List.

2.17.8. TSOA articles require FAA approval prior to drop shipment.

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2.18. First Article Inspection (FAI)

2.18.1. A partial or complete FAI, as appropriate, shall be completed in accordance to AS/EN 9102 or at Safran Power Units request.

2.18.2. Changes that may affect product design, product manufacturing or inspection process may require the supplier to establish and update PFMEA and or control plan.

2.18.3. The following are excluded from the FAI process:

- Standardized and catalog products (except specific requirements),
- Prototype parts.

2.18.4. Upon completion of the FAI process, the supplier shall submit the FAI file (including PFMEA and or control plan) to Safran Power Units for review and approval prior to shipment of the product. Suppliers will be notified of Safran Power Units decision regarding the completeness and correctness of the FAI file.

NOTE: Subassembly or detail parts under the design authority of SPU Toulouse are reviewed and approved by SPU Toulouse. For parts used as spares by SPU San Diego, a copy of the approved SPU Toulouse FAI shall be maintained on file in San Diego.

2.18.5. Upon receipt of articles and after examination, Safran Power Units may reject the FAI if a discrepancy is found. Suppliers will be notified of such decision.

2.18.6. After the FAI is approved, the supplier shall notify Safran Power Units Quality Department, using FM-743-02 or the supplier waiver, of any changes likely to affect the original FAI in compliance with Standard AS/EN 9102. The Safran Power Quality Department shall decide whether it is necessary to completely or partially re-issue the FAI.

2.19. Non-Conformity Detected at the Supplier

2.19.1. When a non-conformance is detected, the supplier must ensure that all non-conforming material is contained and that none has escaped to the end customer.

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2.19.2. The Supplier shall notify the Safran Power Units Supplier Quality Department within twenty-four (24) hours if it suspects a non-conformity on products already delivered to Safran Power Units.

2.19.3. All material scrapped at the subcontractor's facilities must be clearly marked and segregated and the supplier is only authorized to destroy the product after receiving written authorization from Safran Power Units.

2.19.4. Any incident or anomaly identified on the equipment during repair or maintenance work shall immediately be reported to Safran Power Units.

2.19.5. Defects identified outside of contractual maintenance activities must be dispositioned in accordance with defined arrangements.

2.19.6. The supplier shall not deliver product that incorporates any known non-conformity from the engineering drawing or specification requirements unless a deviation has been submitted to and approved by Safran Power Units Material Review Board (MRB).

2.19.7. Deviation Request shall only be submitted for Non-Conforming material that cannot be reworked to engineering/specification requirements.

2.19.8. Suppliers with design authority (source control suppliers) shall submit deviation requests for non-conformities to Safran Power Units MRB for approval prior to shipment.

2.19.9. Suppliers with design authority are not required to submit deviation requests for material discrepancies to Safran Power Units.

2.19.10. Suppliers with design authority are required to internally disposition any identified discrepancy, maintain all such records in compliance with the organizations record retention requirements and make such records available to Safran Power Units upon request with respect to Proprietary information privileges.

2.19.11. Suppliers with no design authority (build-to-print suppliers) shall submit deviation requests for both non-conformities and discrepancies to Safran Power Units MRB for approval using the process as described herein for non-conformities.

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2.19.12. Suppliers shall use Safran Power Units Request/Reply form FM-743-02, or an internal form if approved by Safran Power Units, to report non-conforming material to Safran Power Units prior to shipment. Safran Power Units will reply with a disposition on the non-conforming material.

2.19.13. Supplier can use Safran Power Units' deviation / waiver request form FM-830-03, or can use their own forms if approved by Safran Power Units, to submit deviation / waiver requests to Safran Power Units for approval.

2.19.14. The deviation / waiver request shall include a detailed description of the non-conformity, acceptable root cause(s), effective corrective action(s) with completion date, and objective evidence to show the implementation.

2.19.15. When corrective actions include changes that may affect product design, product manufacturing or inspection process, the supplier may be required to establish or update PFMEA and or control plan.

2.19.16. Deviation/waiver requests will be reviewed by Safran Power Units Quality. They will only be processed through Safran Power Units MRB if Quality is satisfied that the actions taken will eliminate the chance for recurrence.

2.19.17. In the case of a recurrence of the same nonconformity, the part definition must be evaluated to determine if the nonconformity can be eliminated through an engineering change or manufacturability.

2.19.18. Any Repair activity must be discussed with and approved by Safran Power Units MRB before any work is performed.

2.19.19. The outline of the deviation / waiver request must be clear and concise and include a default sketch and/or digital photos if necessary, in order to facilitate the handling of the problem.

2.19.20. The supplier may be requested to submit a proposed disposition for review and approval by Safran Power Units MRB.

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2.19.21. A copy of the Safran Power Units approved Deviation/Waiver Request (form FM-830-03) or minor non-conforming material reports (for source control suppliers) must be included with the shipment of the affected material.

2.19.22. In case of a non-conformity discovered during manufacturing, the Supplier shall inform Safran Power Units of the nature of the non-conformity.

2.20. Non-Conformity Detected by Safran Power Units or its Customers

2.20.1. In case of non-conformities detected during receiving inspection, suspect product is moved to “blocked product” in SAP. The parts are physically moved to the “suspect/non-conformance” cage while awaiting disposition. The Quality technician will generate a Quality Report (Notification) in SAP, a copy of which is sent to the SQE who will then determine if the non-conformance warrants a request to the supplier to begin the root cause and corrective action process (as per sec. 2.22 of this procedure).

2.20.2. In the case of non-conformities detected on a product or process following acceptance at Safran Power Units, products in stock and/or being produced are to be isolated by Safran Power Units within a maximum of forty-eight (48) hours.

2.20.3. Other products in stock and/or being produced that may present the same non-conformities are also isolated by the party which holds them (supplier, Safran Power Units, subcontractors, etc.) in compliance with the following requirements:

- As soon as a non-conformity is identified, Safran Power Units issues the necessary information on the type of non-conformity, traceability elements (manufacturing batch, serial numbers, etc.), quantity of affected products, etc. to the supplier and other relevant parties via a NCR, so they can segregate the products.
- As soon as a non-conformity is identified, the supplier issues to Safran Power Units and other relevant parties the information regarding the segregation and isolation of the product, e.g., type of non-conformity, traceability elements, manufacturing batch, serial numbers for batches being produced, delivered, in

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stock or already delivered, associated with batches, quantity of affected products, root cause of non-detection, etc.

- The Supplier agrees to isolate the products it holds (being produced, pending delivery, in stock, etc.) that may contain the same non-conformity, within a maximum time limit of forty-eight (48) hours following Safran Power Units' request.
- In case of non-conformities that are discovered after the product is shipped to the customer, Safran Power Units Quality shall issue a Supplier Corrective Action Request to the responsible supplier.

2.21. Inspection Following Segregation / Isolation

2.21.1. The Supplier inspects the products it has isolated at its own cost.

2.21.2. When permitted by the type of non-conformity, the supplier agrees to inspect the products within forty-eight (48) hours from receipt of the information required to perform the inspection.

2.21.3. Other products isolated by Safran Power Units and other parties concerned are inspected at supplier's expense. The supplier agrees to inspect the products or to organize their inspection by a representative at a Safran Power Units site, if necessary.

2.21.4. When the type of non-conformity allows it, the supplier agrees to inspect the products within two (2) days from receipt of the information required to perform the inspection and at the request of Safran Power Units to perform the inspection on site.

2.21.5. Or, by default, Safran Power Units returns the isolated products to the supplier for inspection (shipping costs to be covered by the supplier).

2.21.6. Or, by exception, a Safran Power Units representative inspects the products at Safran Power Units sites.

2.21.7. In this case, the cost of the inspection will be charged to the supplier and must be subject to an estimate previously approved by both parties.

2.22. Corrective and Preventive Action

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2.22.1. For Non-conformities discovered after the product leaves the supplier facility, and depending on the severity of the problem, the frequency of occurrence, and the cost caused by the problem, Safran Power Units may decide to issue a SCAR to the supplier. Once a SCAR is issued, the Supplier's must determine:

- Root cause of the non-conformity
- Cause of the escape by the Supplier (in case of an escape detected by Safran Power Units after receiving)
- Corrective actions to avoid repetition of the non-conformity
- Preventive actions to avoid appearance of similar non-conformities
- Objective evidence to show implementation and of the corrective actions.

2.22.2. This information shall systematically be communicated to Safran Power Units' Suppliers Quality Department on Corrective Action Form FM-852-01 or Preventative Action Form FM-853-01.

2.22.3. The supplier must provide a complete Root Cause Corrective Action plan including the planned completion date within 14 days of issuance to Safran Power Units Supplier Quality Department. If the action plan is submitted after the due date, it will be recorded as overdue. Extensions can only be approved by Safran Power Units for special cases (e.g. extended testing).

2.22.4. If the Root Cause Corrective Action plan is not submitted by the 21st day, additional steps will be taken to obtain the action plan from the supplier.

2.22.5. If there is no communication or action plan submitted by the 30th day, a Notice of Delinquency for Supplier Corrective Action Response (FM-741-09) will be issued and may jeopardize the supplier approval rating.

2.22.6. If either the corrective action plan or plan due date are not acceptable, the Supplier Quality Department will reject the supplier's reply to the SCAR and return it to supplier for improvement.

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2.22.7. To ensure effectiveness of the corrective action, the supplier shall perform a 100% inspection of the deviated characteristics for the next three (3) consecutive manufactured lots following the event.

2.23. Delivery

2.23.1. The Supplier shall ensure that all products are correctly identified in accordance with the Safran Power Units purchase order requirements and technical data associated with the article.

2.23.2. An individual test sheet shall be attached to all equipment when required. The declaration of conformity shall identify all products delivered, state all deviations and Request/Replies that were approved by Safran Power Units. A copy of any deviation documents approved by Safran Power Units shall be included.

2.23.3. When required, each delivery must be accompanied by:

- The technical documents (drawings, drawing sets, instruction sheets, test sheets, etc.) attached to the purchase order and that were used for the product manufacturing,
- Any requests/replies, deviations and non-conformity reports that may have been issued.

2.24. Packing

2.24.1. Packing must conform to the instructions given in the purchase order, in the absence of special instructions; it must preserve the product and its accompanying documents to avoid any destruction due to impacts, corrosion, electrostatic discharges or other contamination.

2.24.2. Printed wiring shall be delivered individually stored in anti-corrosion bags, which shall be marked with the date of manufacture.

2.24.3. Electronic components and/or equipment shall be delivered by batch, in antistatic bags, each batch having the same manufacturing date marked on the bag.

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2.24.4. Electronic equipment shall be delivered individually packaged in antistatic bags with connectors be protected. Packaging shall also comply with any additional requirements defined in the drawing.

2.24.5. All cast and forged parts as well as electrical / electronic equipment, electronic components and printed wiring must be delivered per the purchase order requirements.

2.24.6. Information included in the delivery notes and the inspection documents will provide the following information:

- Articles returned subsequent to NCR (Non-conformance Report) number
- Standard articles
- Partial delivery
- Order completed
- Specific reference regarding the nature of the product: specimen, sample part, inspection report,
- X-ray film, heat treatment chart.

2.25. Supplier Portal

2.25.1. All production suppliers shall use Safran Power Units' supplier portal to:

- View and acknowledge PO's and any documents flowed down by the PO.
- Submit required delivery documents (including FAI forms) to Safran Power Units for approval prior to shipment.
- Request delivery authorization and print shipping labels to be applied to packages prior to shipment.

2.25.2. Safran Power Units will provide approved supplier's access to the Safran Power Units supplier portal and will provide work instructions/training on how to use the portal. These instructions are available on the Safran Power Units supplier portal.

2.25.3. Exceptions must be approved by both Safran Power Units' purchasing manager and the quality manager.

2.26. Design Change Requirements for Suppliers Responsible for Design

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2.26.1. "Major" changes are subject to prior approval from Safran Power Units.

2.26.1.1. A change is said to be "Major" when it affects the following elements:

- The characteristics of the materials, articles or components that affect safety, operation, reliability and endurance
- Functional or dimensional interchangeability
- Performances, utilization conditions and resistance to the environment
- Reliability
- Implementation and maintenance by the user
- Utilization safety and service life

2.26.1.2. Major changes that result in a change of the product's part number are referred to as "Modifications".

2.26.2. "Minor" changes shall be submitted to Safran Power Units before the next shipment and do not require prior approval.

2.26.2.1. A change is said to be "minor" when it does not affect the above-mentioned elements.

2.26.3. Corrections made to drawings not affecting fit, form or function are not considered to be design changes. Their traceability is ensured by the drawing or by a computer medium.

2.26.4. In both cases of change mentioned above, traceability of the changes must be ensured. Any document or drawing affected by these changes must be sent to Safran Power Units.

3. RECORDS

3.1. The retention requirements for records referenced in this procedure are defined in Quality Records procedure OP-424-01.

4. RESPONSIBILITY

4.1. The Quality Manager is responsible for the implementation of this procedure.

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