GRFS: General Requirements for Suppliers
Quality Assurance General Requirements

Summary

This document sets the Quality Assurance General Requirements for Suppliers and extends the EP 06-12 “General Requirements for Suppliers”.

Reference Language:	English
Validity:	EC/ECD/ECE/All Subsidiaries

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Issue	Modified Part	Description of Change
A		New document replaces: QAE 06-01, EI075-06-001, QAE 06-05, QAE 06-02-05
B		Issue B supersedes QAE 06-02 Usage of wording shall, may, must etc. reviewed Paragraph related to special processes changed
C	all	Replaces ER070 06 03 now included inside Appendix B, deletes QAF 06-03-01 ER070 16 01 now fully harmonized Requirements for Design configuration control transferred 7.3.1. in appendix A New Appendix for specific Governmental Programs, new appendix for tools providers New pagination
D	All	Rewording, corrections, new pagination, grouping of requirements Appendix J full rewriting redaction of Governmental Programs specificities issued from specific documentation. (EI101) T 000 M 0981 E05 , (EI101) QD S000 N0803 E01(EI101) QD S000 N0849 E01 (all Tiger & NH90 Quality Assurance Requirements for Suppliers), contents have been included in the general text Appendix K list of approved Nadcap Special Processes
D2	Table of contents	Correction of wrong publishing. The minor evolution
D3	P19 P3	Minor evolution § numbering on French version Ref mistakes between QAE 06-02-04 & QAE 06-03-04

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Associated Documents		
Reference	Document Title	Database
AP2003	Document Retention Requirements for Airbus Suppliers *(Appendix I)*	Airbus
AP2006	Accepting Non-conforming Items by Concession *(Appendix I)*	Airbus
AP2190	General Requirements for Aerostructure & Material Suppliers *(Appendix I)*	Airbus
AP5171	Using Equipment Label for Equipment Data Tracing *(Appendix I)*	Airbus
BSF-013	First Article Inspection *(Appendix I)*	Airbus
EI 04-06-01	Handling of Parts according their Classification of Safety	EDMS
EI 04-06-02	Applicable Rules according Equipment Classification	EDMS
EI 09-02-02	Process Control	EDMS
EI 16-04	Log Card Processing	EDMS
EI023 04-008-7	ECPF Process Flow Down (Civil ECD H/C)	EDMS
EI026 08-003	Subcontractor Non Conformities – Aircraft Components	EDMS
EI075 04-006	Handling Classified Parts according to the Categorization in Safety Classes (applicable to Airbus Program)	EDMS
EP 04-06	Classification of Structural Parts	EDMS
EP04-22	Cooperation between Design Organization and Production Organizations	EDMS
EP 06-12	General requirements for Suppliers	EDMS
EP 08-03	Identification, Marking and Traceability	EDMS
ER020 04-01-05	Guideline for writing Equipment Change Sheet by equipment manufacturers, and Eurocopter validation and approval process	EDMS
ER020 04-01-06	3RD Level maintenance data & repair approval process for equipment suppliers	EDMS
ER050 06-002	Eurocopter Quality Requirements for Aeronautical Component Maintenance Service Providers	EDMS
ER050 19-102	Drafting of SB/LS/ITE by the Vendors Validation/Approval/Release by EUROCOPTER	EDMS
ER070 04-06	Quality control of helicopter parts by the Suppliers and Licensees according to their safety class	EDMS
ER070 06-02-06	Exigences spécifiques pour les Fabricants de Demi-Produits, Matériaux & Ingédients (French only)	EDMS
ER 070 06-02-07	Guide for Writing equipment Test Specification	EDMS
ER070 06-11	Acceptance of the first production article of a bought out item	EDMS
ER070 06-20	Quality Requirements for Brokers	EDMS
ER070 13-06	Writing of requests for concessions by EUROCOPTER´s Suppliers	EDMS
ER070 15-01	Packaging Logistics Conditions for ECE	EDMS
ER070 16-01	Filling of Quality Related documents by Suppliers	EDMS
ER150-09-03	Delivery logistic conditions	EDMS
F020 004	Equipment Evolution Sheet	EDMS
F020 026	Sheet of Storage and Conditioning Conditions (EC only)	EDMS
F020 027	Declaration of Performance	EDMS
F023 04-008 1	ECD ECPF Form (ECD)	EDMS
F050-06-002	Content of shop report for a maintained component	EDMS
F075 15-003	Sheet of Storage and Conditioning Conditions (all ECG valid)	EDMS
G023 04-008-6	Instruction for filling the ECPF Form (Civil ECD)	EDMS
MBBN 240	KENNZEICHNUNG VON BAUEINHEITEN ZEICHNUNGSANGABEN	EADS
QAE 06-02-08	Recommendations for EUROCOPTER´s Manufacturers	EDMS
QAE 06-07	Eurocopter Quality Requirements for EC120 partners	EDMS
QAE 10 01	First Article Inspection in Developement	EDMS

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Specific documents applicable to Appendix B		
(EI021) DHN1-007-000	"General vigil"	EDMS
(EI021) HS 5015 series	"procedure applicable to hot worked blank and casting"	EDMS
(EI021) HS 5032	"quality standard on windshield"	EDMS
(EI021) HS5011	List of special processes validated at ECG	EDMS
(EI021) HS5022	Helicopter equipment marking	EDMS
(EI021) HS5022-010 to -040	Helicopter equipment marking series	EDMS
EI 043 650 13	"skills management for electrical manufacturing subcontractor"	EDMS
EI 070 06 006	"qualification of subcontractors and cooperating companies for the performance of quality operations concerning periodic inspection of interchange-ability tooling"	EDMS
EI 070 06 033	"incoming inspection of composite material"	EDMS
EI 070 09 008	"Control of externally sub contracted special processes"	EDMS
EI 070 10 003	SITUATION DES INTERVENTIONS D'INSPECTION DANS LE PROCESSUS DE FABRICATION ET DE REVISION DES PIECES METALLIQUES"Situation of inspection work in the manufacturing and overhaul process for sheet metal parts"	EDMS
EI 070 10 004	"Inspection plan for manufactured composite products"	EDMS
EI 070 10 007	"Inspection plan for concerning the manufacture ofed electrical itemscomponent"	EDMS
EI 070 10 021	"Installation inspection plan for assembly of transmission assembliesdynamic components"	EDMS
EI 070 18 003	"IN-HOUSE PROCEDURE FOR MANAGING THE CERTIFICATION AND QUALIFICATION OF NON-DESTRUCTIVE TESTING (NDT) INSPECTORS AND SUBCONTRACTORS / REPAIR STATIONS APPROVED BY EUROCOPTER (France) "	EDMS
EI 070 18 005	"in house procedure for managing certification and qualification of non destructive test for ECE"	EDMS
EI 071 IGC 04 81 105	"Marking and presentation of pre pregs"	EDMS
EI 075 06 002	"Vergabe von Herstellerkennzahlen""Verbage von herstellerhennzallen"	EDMS
EI 075 18 003	"in house procedure for managing the certification and qualification of NDT inspector at EC…"	EDMS
EI 09 02 02	"process control"	EDMS
EI 09 03	"Controlling geometric interchange-ability for structural and mechanical component"	EDMS
EP 09 02	"Control of material and processes"	EDMS
ER 070 06 02 06	"specific requirements for manufacturer of semi product, material and ingredient"	EDMS
ER 070 09-01	"Industrialization review of subcontractors Mechanical detail part"	EDMS
ER 070 09-02	"Industrialization review for the assembly of subcontractors contracted dynamics system"	EDMS
ER020 04-001	REGLES D'INTERCHANGEABILITE – MATERIAUX METALLIQUES	EDMS
ER070 06 03 04	"Specific requirements for Subcontractors of electrical assemblies (ex QAE 06 03 04)	*EDMS*
L020 020	"extract of Global replacement file"	EDMS
L030 03 007	Repertoire des couples semi finis non metal. /fournisseurs autorisés par EC	EDMS
L030 03 001	"repertory of subcontractors authorized by Eurocopter to undertake specific processes or activities"	EDMS
L030 03 002	"repertory of metal semi product/manufacturer associations authorized by Eurocopter"	EDMS
L030 03 003	"repertory of metal semi product/manufacturer associations authorized by Eurocopter on critical parts"	EDMS
L030 03 004	"repertory Directory of electrical component / supplier authorized by Eurocopter"	EDMS
L030 03 005	"repertory of subcontractors authorized by EC to undertake thermal or thermo chemical treatments on critical Parts"	EDMS
L030 03 006	"repertory of composite product / supplier authorized by Eurocopter"	EDMS
L030 03 011	"repertory of fasteners, mechanical part, fluid system & miscellaneous standard / supplier authorized by Eurocopter"	EDMS
L041 001	"Standard material, manufacturing instruction"	EDMS
L070 042	Directory of major assemblies in EC French range	EDMS
QAE 06 02 02	"specific quality requirement for manufacturers of forging and casting"	EDMS
QAE 06 02 03	"specific quality requirement for bearing manufacturers"	EDMS
QAE 06 02 04	specific quality requirement for manufacturers of screws, bolts and nuts	EDMS
QAE 06 03 04	Specific requirements for Subcontractors of electrical assemblies (will be replaced by ER070 06 03 04)	
~~ER070 06 02 04~~	~~"specific quality requirement for manufacturers of screws, bolts and nuts (ex QAE 06 03 04)~~	~~EDMS~~

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Associated Standards & Regulations		
Reference	Document Title	Database
AQAP 2110	NATO Quality Assurance Requirements for Design, Development & Production	ADS-STAN
AQAP 2120	NATO Quality Assurance Requirements for Production	ADS-STAN
AQAP 2130	NATO Quality Assurance Requirements for Inspection and Test	ADS-STAN
AWS D17.1	Specification for fusion welding for aerospace application	
CCAR 145	China Civil Aviation Maintenance Organizations	CCAR
EASA Part145	on acceptable means of compliance and guidance material to Commission Regulation (EC) No 2042/2003 of 20 November 2003 on the continuing airworthiness of aircraft and aeronautical products, parts and appliances, and on the approval of organisations and personnel involved in these tasks	EASA
EASA Part21	Acceptable Means of Compliance and Guidance Material for the airworthiness and environmental certification of aircraft and related products, parts and appliances, as well as for the certification of design and production organisations	EASA
EN4179	Qualification & approval of personnel for non destructive testing	ADS-STAN
EN9100	Quality Management Systems Requirements for Aviation, Space and Defence Organizations	ASD-STAN
EN9102	Quality systems, First article inspection	ADS-STAN
EN9110	Quality Management Systems, Requirements for Aviation Maintenance Organizations	ASD-STAN
EN9120	Quality Management Systems - Requirements for Aviation, Space and Defence Distributors	ASD-STAN
EN9131	Quality Management SystemsManagement Systems, Non-conformances documentation	ADS-STAN
FAA Part145	Federal Aviation Administration Repair Stations	FAA
ISO 10 005	QUALITY MANAGEMENT SYSTEMS - GUIDELINES FOR QUALITY PLANS	ADS-STAN
ISO 10012:2003	Measurement management Systems - requirements for measurement processes and measuring equipment	ADS-STAN
ISO 14001	Environmental Management Systems - Requirements with Guidance for use	ADS-STAN
ISO 9001	Quality Management Systems Requirements	ADS-STAN
ISO24394	Welding for aerospace applications Qualification test for welders & welding operators…	ADS-STAN ADS-STAN
NAS410	NAS Certification & qualification of non destructive test personal	
TCCA 145	Transport Canada Civil Aviation Maintenance Organisations	TCCA

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1 Purpose

EUROCOPTER must demonstrate the airworthiness of the aircraft as well as for parts and appliances delivered to their customers. EUROCOPTER must therefore ensure that all Suppliers used for provisioning are capable of supplying products and services at the necessary quality level. Thus, EUROCOPTER must be completely assured that the Suppliers are able to deliver products which are in compliance with the design data, in condition for safe operation and delivered with the required documentation.

This document is a complement of the EP06 12 (GRFS General Requirements forSuppliers) that fully applies

2 Responsibility / Application

The Suppliers are responsible to comply with these requirements and shall flow down them to all their sub-tiers.

This documents fully applies, in perimeter defined by EP 06-12, for all supplies of which ECD or EC is in destination or is Design Responsible. It may apply on their requests, to all internal use Eurocopter Subsidiaries other supplies.
The Supplier is responsible for the conformity of the supplies, including the products/parts/appliances, documents and related contractual services. EUROCOPTER acceptance of the delivered supplies shall in no way affect the responsibility of the Supplier for any non apparent problem found after delivery.

3 Document structure, Definitions, Abbreviations

3.1 Document structure

As indicated in Chapter 4, EUROCOPTER requires in particular to its suppliers the full observance of the EN9100 series requirements. This document describes the supplements to the mentioned standards EN9100/9110/9120 requirements.
In this document, paragraphs follow that of EN9100 structure. But are only mentioned the EN9100 chapters & paragraphs numberings and headings where EUROCOPTER has some additional requirements to those already inside EN9100/9110/9120.
This document is divided into a general core part of requirements that are **applicable for all kind of suppliers** and several appendixes for different kinds of suppliers.
Appendixes are to be considered as complements of the general core part

Therefore all requirements mentioned in this document shall be considered as additional ones to those of the EN9100/9110/9120.

Suppliers delivering items specifically dedicated to Military or Governmental Programs must comply in addition with the requirements of AQAP-2110, AQAP-2120 or AQAP-2130 depending on activity.
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Note: **In case of conflict between core of document and appendixes the content of appendixes prevails.**

3.2 Definitions

The use of SHALL, SHOULD, WILL, MUST and MAY within this document shall observe the following rules:

- The word "**SHALL"** in the text denotes a mandatory requirement. Departure from such a requirement is not permissible without formal agreement.
- The word "**SHOULD"** in the text denotes a recommendation or advice on implementing such a requirement of the document. Such recommendations or advice is expected to be followed unless good reasons are stated for not doing so.
- The word "**MUST"** in the text is used for legislative or regulatory requirements (e.g. Health and Safety) and shall be complied with.
- The word "**WILL"** in the text denotes a provision or service or an intention in connection with a requirement of this document.
- The word "**MAY"** in the text denotes a permissible practice or action. It does not express a requirement of this document.
- These means of understanding are applicable in the entirety of all modules of this document.
- **EUROCOPTER** in this document means Division of EUROCOPTER Group that is Contracting Agency to the Supplier, (ECG, see Abbreviations bellows)
- Refer to EP 06-12. for **Suppliers Classification**
- **COTS**: means "Commercial Off The Shelves". It is an equipment part from a Manufacturer of which Specification has been made by the Manufacturer itself, but which specification has been appropriated as is, by EC Design Organisation.
  Nota: The Manufacturer is Design Organisation for COTS when they are under ETSO/TSO or EASA agreed equivalent. But EC remains Responsible as Design Authority for all other COTS, like any other Equipment. EC is anyway responsible for the integration all kind of COTS.
- Some suppliers may together act as "Manufacturers", "Sub-Contractors" or "Maintenance Organizations" depending of the product or service to supply. Those suppliers will have to alternatively follow specific respective requirements in relation of the concerned actual provided task.
- There may be suppliers constituted with several workshops, at different addresses: is considered as being one single supplier, one of which all the perimeter of activity is covered with a unique Quality Organisation, described in a single Quality Manual. Evidence of this will be given by the frame of the EN9100 series certification(s). However, EUROCOPTER Supplier Quality Assurance needs to separately monitor all work plants of a given supplier and may be conducted to segregate them for all audits or assessments or data.
- **Manufacturing Date:** it is the date of the final inspection of the part, it appears on equipment parts labelling, on Log Cards, on packaging identifications. For Elastomers it may be replaced by the Cure date (see Appendix A, §7.5.3.2). On documents attesting the conformity or the airworthiness (CoC, Form 1 …) the date, same or ulterior, is the one when this attestation has been validated.

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Abbreviations *(in this document and for exchanges between ECG & Suppliers)*

ATP	Acceptance Test Procedure
ATR	Acceptance Test Report
AQAP	Allied Quality Assurance Publication
C/A	Contracting Agency / Contractor (Eurocopter division through Strategic Procurement)
CAQ	Civil Aviation Qualification
CMM	Component Maintenance Manuel
CoC	Certificate of Conformity / Declaration of Conformity
COTS	Commercial Off The Shelves
DAL	Design / Development Assurance Level (EP 04-06)
DDP	Declaration of Design Performance
DGA	Direction Generale de l'Armement (French Military Authority)
DO	Design Organization
DOA	Design Organization Approval
DRL	Data Requirement List
DVL	Data Validity List (List of Required Documents & data, referred in SOW)
EASA	European Aviation Safety Agency
EC	EUROCOPTER S.A.
ECD	EUROCOPTER Deutschland GmbH
ECE	EUROCOPTER Subsidiary in España
Subs.	EUROCOPTER WW subsidiary companies (for products under EC-ECD DOA, POA or MOA)
ECG	Eurocopter Group: Division of ECD & EC & Subs. actual C/A for the Supplier
ECG-ECE	Means inside ECG & / or ECE the corresponding C/A for the specific supply
ECPF	Engineering / Equipment Change Proposal Form
ETS	Equipment Test Specification
ETSO	European Technical Standard Order
FAI	First Article Inspection
FEE	Fiche D'Evolution Equipment (Equipment Evolution Sheet)
IAQG	International Aerospace Quality Group
IPC	Illustrated Parts Catalogue
LMP	Laboratory Materials & Processes (EUROCOPTER´s)
LRU	Line Replace-able Unit
MOA	Maintenance Organization Approval
NQAA	National Quality Assurance Authority
NQAR	National Quality Assurance Representative
OEM	Original Equipment Manufacturer
P/N	Part Number
PAH	Production Approval Holder (FAA)
PMA	Parts Manufacturer Approval (FAA)
PO	Production Organization
POA	Production Organization Approval
Pri-NADCAP	*Performance Review Institute / National Aerospace & Defence Contractors Accreditation Program (SAE)*
P/O	Purchase Order
QAP	Quality Assurance Plan
QMS	Quality Management System
QN	Quality Notification
R/O	Repair and Overhaul
SDR	System Design Responsibility
SOW	Statement Of Work
SP	Special Process
SPV	Special Process Validation
SQN	Service Quality Notification
SRU	Shop Replace-able Unit
STC	Supplemental Type Certificate
TBO	Time Between Overhaul
TC	Type Certificate
TSO	Technical Standard Order (see ETSO)

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ECG & ECE Supplement to EN9100

4 Quality management system

4.1 General requirements

The supplier Quality Management System (QMS) must comply with the requirements of EN/AS/JISQ 9100/9110/9120 depending on activity as a minimum.
To demonstrate this compliance, the supplier shall have a QMS certified by a Certification Registration Body accredited by IAQG Other Party Scheme, and registered in OASIS (see www.sae.org/iaqg and www.iaqg.org/oasis).

This document lists above standards additional requirements that the suppliers must fulfil with.

For suppliers delivering items specifically dedicated to Military or Governmental Programs, among others the AQAP-2120 requests that the suppliers send to EUROCOPTER last updated copy of their Quality Manual, a Manufacturing route, Inspection and Test Plan, describing the overall process (block diagram,…), plus for approbation a Programme Management Plan and a Quality Assurance Plan (kept available to NQAR), the latter describing

- How the present requirements will be met
- The organisation/responsibilities, including Quality and give focal contacts.
- The contents of Manufacturing and Inspection Files and the control rules.

Any exception or arbitration must be specifically in advance agreed by EUROCOPTER.

Right of access to Supplier's facilities and documentation: refer to EP06-12

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Note: In the present document, there are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9100

Airworthiness Regulations Compliance

Suppliers of safety critical or important parts/equipment or "major assemblies" (Structural elements that contribute significantly to carrying flight and ground loads and whose failure due to fatigue could result in a catastrophic failure of the rotorcraft *) or DAL A or B equipement shall have a POA (Production Organisation Approval) compliant with:

- European Aviation Safety Agency (EASA) standard i.e. PART 21 G, or
- Federal Aviation Administration (FAA) standard i.e. FAR 21, PMA or
- Recognized equivalent by EASA

*specific list L070 042 at EC

The compliance must be demonstrated by the means of an official approval. Arrangements between EUROCOPTER Design Organisations (DO) and supplier Production Organisations (PO) shall be implemented. The PMA (Parts Manufacturer Approval) procedure in alternative of FAR21G will be followed for suppliers under FAA supervision.

All equipment manufacturers and other suppliers providing with maintenance activities, in addition to AS/EN9110 or at least AS/EN9100 series certification, shall have a MOA (Maintenance Organisation Approval) compliant with:

- European Aviation Safety Agency (EASA) standard i.e. PART 145, and/or
- Federal Aviation Administration (FAA) standard i.e. FAR 145, and/or
- Transports Canada Civil Aviation (TCCA) standard i.e. PART 145 and Supplemental, and/or
- General Administration of Civil Aviation of China (CAAC) standard i.e. CCAR-145.

The compliance must be demonstrated by the means of an official approval.

In the exceptional cases of absence of required above PART145/FRA145 approval, the supplier must get formal EUROCOPTER acceptance for being covered with own EUROCOPTER corresponding approvals. In such a case the supplier will anyway be at least AS/EN 9110 certified.

Note: This requirement does not apply to suppliers which deliver only typically military products.
Except for French Military Commercialised Programs where Surveillance under FRA21 regulations is required and includes, among others, the above conditions.

4.2 Documentation requirements

If a quality assurance plan is required, it should be conforming to ISO 10 005 and shall be accepted by EUROCOPTER.
Quality Assurance Plans are compulsory for Governmental & Military Programs under AQAP 2120 applications (CF § 4.1) . Such plans should be conforming to AQAP2105

4.2.3 Control of documents

The Supplier shall assure in the absence of formal other specific order, the application of the latest issue of all documents provides by EUROCOPTER and needed for provision of the service. The Supplier is also self-responsible for managing the updates. The Supplier must directly procure from their respective publishers those documents where EUROCOPTER has no property rights and thus

could not be dispatched by EUROCOPTER however they are needed for the service requested (i.e. standards like EN, ISO etc.).
The Supplier shall acknowledge the receipt of the documents and data sent by EUROCOPTER and inform EUROCOPTER of every error or discrepancy found in orders and other documents provided by EUROCOPTER.
The Supplier shall formally inform EUROCOPTER of any disagreement in the content of the documents to be applied. The deviations shall be agreed by both parties.

4.1.4 Control of records

The Supplier shall set up an archiving system for quality-related records

The Supplier shall comply with the special EUROCOPTER requirements for keeping quality-related documents. The documents must be archived in a fire-resistant, weatherproof and theft-proof area. The Suppliers must proceed according to

- ER070 16-01

If not otherwise stipulated in the contract or the order or after formal agreement with EUROCOPTER.

The archive will be organized that all records can be made available to EUROCOPTER at any time, even in the case of a commercial business termination or bankruptcy.

5 Management responsibility

The Supplier must notify EUROCOPTER of any major change in:

- his overall organization,
- the breakdown of his manufactured products between his sites,
- the breakdown of his manufactured products between his Suppliers,
- the organization responsible for the quality function,
- the procedures for ensuring product conformity,
- the location of activity sites (transfer).

For activities in the scope of AS/EN9110 Standard & Part/ FAR 145 regulations, the supplier must keep available for ECG & ECE all evidences of appropriated skill and of continuous trainings & tests as required in Standard & Regulations in particular human factors & Authorities Part 145 requirements.
In such a purpose, the supplier will make available description and application evidences of its Safety Management System. (Doc; OACI 9859)

A Safety Management System may be required by EUROCOPTER for any other activity, especially for Critical Safety Class products manufacturing

6 Resource management

6.2 Human resources

The Supplier must ensure that the EUROCOPTER requirements are known by its staff as long as members are involved in activity to EUROCOPTER

7 Product realization

7.2.3 Customer communication

Any document, Request or information given by the Supplier to EUROCOPTER will be or directly given to Strategic procurement Direction of with copy to the latter, except formal requirement from recipient.

7.3 Design and development

The Supplier shall apply requirements for the material design according to the instructions defined in the order and/or in the technical specifications of the products and/or the Statement of Works (SOW).

7.4 Purchasing

The Supplier must take appropriate measures to prevent the purchase of suspected unapproved parts. The Supplier must integrate on his own orders the supervisory requirements of the Official Authorities designated on the EUROCOPTER order. The Supplier must also flow down to its own first & flowing ranks Suppliers all EUROCOPTER Requirements and inform EUROCOPTER in case of deviation.
The Supplier shall implement the EN9134 IAQG Standard where applicable (Supply Chain Risk Management)

- **Suppliers for Raw materials, ingredients & Standard parts** must, at least, inform Eurocopter, at the latest at PO acceptance, about any change regarding material, formulae or ingredients. Equally for any change in Hygiene & Security data's

If the Supplier is to deal from a Distributor, it must in addition flow-down to this Distributor all hereafter Appendix E requirements (focussed on delivery documentation)

7.5 Production and service

The classification of structural parts and equipment must be in accordance with the requirements of **EP 04-06.**
EUROCOPTER´s design documents for components and assemblies are categorized in safety classes.
Are applicable:
- For parts under EC Design Organization the ER070 04-06
- For parts under ECD Design Organization the EI04-06-01 and EI04-06-02

and depending on the class and programme additional procedures have to be applied.
- For AIRBUS parts under ECD DO & PO the EI075 04-006 is applicable.
- For Governmental Programs: shall apply following requirement: “Critical part management”, QD S000N0822E01 (or other Partner Company equivalent document quoted in the DVL).The list of critical parts and critical parts files shall be provided to the Buyer, according to “Classification and procedure for structural and mechanical parts” QD N000N0804E01

7.5.2 Control of production and service provision

7.5.2.1 Production Process Verification:

First article inspection
If the report of a First Article Inspection (FAI) is required, the acceptance process for the First Article shall be based on EN9102 and shall respect the ER070 06-11.
In addition to any new production or any process change surveillance, a FAI will be conducted after any process upturn following an interruption longer than two years

7.5.2.2 Control of production process changes

Special Processes
ECG & ECE policy is that all eligible Special Processes which get recognition from EC or AIRBUS will be conducted under PRI NADCAP accreditation. Eventual exception in this accreditation will need formal EUROCOPTER approval & specific surveillance.

(Refer to Appendix A or B considering the product, list of accepted Pri-NADCAP Special Processes in appendix K. For Subcontractors or an External Workbenches refer to appendix B)

7.5.4 Identification and traceability

The Supplier shall set up a system capable of tracing products and including, as a minimum:
- identification by marking products and their packaging, as per the applicable definition documents,
- A recording system providing an on-going cross-reference between the manufactured items and the working documents. For **Critical Parts** or **Important Parts** (see EP 04-06), it must be possible to link the manufacturing file with the material batch.

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7.5.5 Customer property

Upon receiving the delivery, the Suppliers shall visually inspect the material and perform an administrative check of the accompanying documents.

7.5.6 Preservation of product

In addition to the requirements mentioned in this paragraph the ER150 09-003 is applicable for all EC orders. In case of conflict the content of ER150 09-003 prevails for EC orders (and ER070 15-01 for ECE orders).

Packaging

The Suppliers must use storage conservation and transport packaging that is sufficiently resistant and sealed to protect the components against damage and exposure to environmental influences.

Accompanying documents

All supplies shall be delivered with the contractual documentation including:

Delivery Note featuring at least the following:

- a number of identification,
- EUROCOPTER purchase order or contract number,
- the list of products with their respective EUROCOPTER & Supplier P/N and quantities,
- the batch No, if necessary,
- the description of the enclosures,
- the list of components for kit delivery,
- the list of concessions, (if any)
- the package particulars (number of packages, weight and dimensions),
- the list of eventual missing items and/or outstanding operations.
- **Certificate of Conformity** (compulsory)
- **EASA Form One, FRA Form1, FAA Form 8130-3** or equivalent form accepted by EASA:
  Products delivered by suppliers and covered by their Production Organization Approval or their FAA Part Manufacturing Approval or their Maintenance Organization Approval and appearing in the capability list for their DO/PO agreement or their PMA Assist Letter shall be *systematically* supplied to EUROCOPTER accompanied by an EASA Form 1 or equivalent relevant airworthiness release document. Equally for parts under supplier's TSO/ETSO/TC/STC must be accompanied with Manufacturer's own release documents.

And following documents, as required by the order or the contract:

- First Article Inspection Report (when relevant)
- Log card,
- **Acceptance Test Report,** (mandatory for NH90 and Tiger programs)
- Fire Resistance Certificate,
- User Handbook,
- Concession, (if any)
- Quality inspection certificate e.g. acc. STANAG 4107, FRA21 forms
- Completed QN for return reworked / brought to conformity non-conform parts
- Shop Report for maintenance activities

In a Certificate of Conformity, the following information must be included:

- Supplier or ECG-ECE customer entity full addresses & names
- Suppliers NATO Code
- Serial or batch number (depending on requirements & criticality of the safety class)
- EUROCOPTER Purchasing Order or contract references
- Delivery note reference
- For limited shelf life duration products, the corresponding limit date
- Parts list with ECG ref. & part numbers and quantities
- Definition documents ref. as Drawing, specification, standard …
- The list of components for kit delivery
- Commitment form confirming conformity with specifications/design documents
- Reference of maintenance data used for maintenance activities
- List of performed operations (verification, repair, modification,…) for maintenance activities
- List of concessions (if any and only when “recordable”)
- Name, function and signature of approval authority

(In compliance of NF L 00-015 for EC)

7.6 Control of monitoring and measuring devices

The calibrating system shall meet the requirements specified in ISO-10012: 2003. (For military programs the requirements of AQAP 2110 are applicable).

When the Supplier uses interchange-ability tools self-made or provided by EUROCOPTER for controlling contractual interfaces of the components in helicopters, the supplier shall check the tools for wear and general condition, and recondition them if necessary, under the cover of applicable commercial agreements.

8 Measurement, analysis and improvement

8.2 Monitoring and measurement

8.2.2 Customer satisfaction

The Supplier shall be able upon request to provide EUROCOPTER, in addition to any other data related to EUROCOPTER satisfaction measurement, with a detailed analysis of First Fit Rejection including rates, detailed corrective & preventive action and if necessary relevant specific action plan. The Supplier upon request will participate to any meeting requested in the purpose of improving its provision.

8.2.3 Internal audit

The Supplier shall make available to EUROCOPTER its internal quality audits relating to the products within the scope of the contract, and to the associated procedures. The Supplier shall communicate once a year to EUROCOPTER Quality the major lessons learned from the completed audits.

8.3 Control of non-conforming product -process

The Supplier shall implement the EN9131 IAQG Standard (Non Conformance doc.)
In case of non-conforming products detected by the Supplier prior to delivery, to enable any delivery of the product, the Supplier shall use the ER070 13-06. Any use-as-is non-conformity must require EUROCOPTER authorization.

In case of non-conformity on products or on processes detected by the Supplier after the products delivery, the Supplier shall inform EUROCOPTER (at least operational procurement and quality focal points) and all concerned Customers, within 48 hours.
In case of events linked to its products liable to seriously endanger the aircraft in destination, the Supplier must inform EUROCOPTER within same above notice of being aware of the fact.

In case of non-conformities detected by EUROCOPTER on already delivered product or service, a Quality Notification (QN) is usually sent to the Supplier. This latter shall implement the necessary steps in accordance with the EN9100, EN9131 and shall inform accordingly EUROCOPTER by returning, in due time, the QN duly filled with the corrective and preventive action descriptions.

For Development activity, especially on Prototypes, and on other cases linked to airworthiness, the Supplier will have to at least acknowledge the information within 3 calendar days (refer to SOW, if any for details)

EUROCOPTER reserves the right to refuse from a Supplier any non-conforming product and any product after significant amount of non-conformities detected on this Supplier's products.

The Supplier will regularly analyse the processes and products non-conformities and should be able to report its analysis results on request.

In some specific cases of non-conformities discovered after supplier's delivery, a formal common technical investigation conducted at the supplier's may be demanded by EUROCOPTER. Such a request will be specifically given to the supplier, it will be confirmed on the QN, if any, and the parts will be sent back sealed with accurate mentions.
Unsealing the given product and consequently beginning the investigation can only be conducted by the suppliers with a formal EUROCOPTER authorisation.
The program of the investigation will be established with formalisation of human and material means (ATP counter reception, visual & instrumented examinations) procedure & agenda. The supplier will after that once agreed assure full availability of means, environment, tools, test devices, human resources under the mentioned schedule.
For investigations linked to airworthiness or prototypes, the supplier will have to make available all needed resources with no notice.

The supplier will diligent all subsequent required containment, mitigation, corrective, preventive or design change actions inside full Eurocopter agreement when the supplier will be the origin of the non-conformity.

8.4 Analysis of data

The Supplier will set up indicators for measuring the quality level of the products the supplier delivers to EUROCOPTER. The results of measures and the progress actions are presented at the periodical reports.
The supplier shall be able to supply ECG-ECE with a periodic assessment (Qualimetry) of any non-quality detected on ECG-ECE products by its internal inspection. This analysis should be based at minimum on 5M methodology and cover Sub tier (including raw material & semi product) performance

8.5 Improvement

The Supplier will notify EUROCOPTER of the following:

- any major event the supplier detects as least in relationship with Quality organisation or with processes or conformity;
- of the corrective actions the supplier implements for the products already delivered and to be delivered;
- and of the preventive actions adopted for other products.

In addition the Supplier must deal with any nonconformity detected by EUROCOPTER, by notifying EUROCOPTER with the result of the investigation and of the corrective action(s) taken, together with its estimated completion time.
The Supplier must regularly inform EUROCOPTER of the progress of the corrective actions requested by EUROCOPTER.
Furthermore, if required in the event of major failure, EUROCOPTER could be prompted to perform itself - or have performed by any Regulatory Authority or EUROCOPTER approved company - an inspection before or after delivery, chargeable to the Supplier. This inspection shall be maintained until corrective actions have been implemented.

Improvement, corrective and preventive measures

The Suppliers must fully take into account defects detected by the final customer.
The Suppliers must inform EUROCOPTER of the result of the investigation, risk analysis, tests that have been performed as well as the corrective and preventive measures that have been taken and the expected date of completion
The Suppliers must routinely inform EUROCOPTER with regard to the progress of the preventive measures requested by EUROCOPTER.

8.5.4 Continual improvement

A minimum annual report incl. major quality events and implemented continual improvement actions will be prepared by the Supplier and submitted upon request to EUROCOPTER. For priority and/or strategic Supplier an improvement plan will be once a year written by the supplier and approved by EUROCOPTER.

8.5.6 Preventive actions

The evaluation of the need of action based on human factors to prevent occurrence of non-conformities must be especially conducted for maintenance activity in destination to ECG-ECE

APPENDIX A: Additional quality requirements for Manufacturers

(Applicable in addition to the general core part)

Note: There are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9100

Note: There may be cases when a Manufacturer is requested by ECG-ECE to act as Sub-Contractor on specific parts, in such a case the Supplier must conform to specific Sub-contractors requirements for these specific parts (corresponding appendix of present document).

7 Product Realisation

7.3 Design and development

The Supplier shall apply requirements for the material design according to the instructions defined in the order and/or in the technical specifications of the products and/or the Statement of Works (SOW).
The Supplier shall implement the EN9103 (Variation management of Key Characteristics) IAQG Standard when applicable

7.3.7 Control of design and development changes

Design Changes during development phases:
QAE 06-02-08 defines as advice the recommendations for controlling the development, approval and definition change process applicable for a material specified by EUROCOPTER.
EUROCOPTER reserves the right to take part in reviews**.**

Three documents are systematically required from the Supplier for each new reference:

- **Sheet of Storage and Packaging Conditions** (see F075 15-003 ECG-ECE valid, and upon request F020-026 only EC valid).
- **Declaration of Design and Performance** (see F020-027)
- **Acceptance Conditions**:
  - the technical specification reference,
  - the definition file reference and revision number,
  - the P/N of the material to be tested,
  - the description of the component status inspection:
    . accompanying documents,
    . markings,
    . appearance check,
    . weight, etc.
  - the technical individual check description (ATP):
    . dimensional check,
    . general test conditions (temperature, pressure ....),
    . the tests to be performed (type, input values, output values, accuracy, acceptability criteria.) clearly defined for application not linked to specific test. For electric and electronic components, this paragraph reiterates the detailed test specifications,
    . the test facilities implemented by the Manufacturer with, if applicable, the test method for these facilities.
  - the technical inspection description on sampling basis:
    . the definition of batch composition,
    . the dielectric rigidity,

. the environmental tests, etc...
- the generic individual acceptance report (ATR template).

The acceptance requirements are referring to the definition file. If not otherwise defined in a SOW, they must be made available to EUROCOPTER for approval:

. 1 month before the inspection of the first production item to be qualified,

Design Changes on Production phases, after qualification:
The Supplier must obtain EUROCOPTER´s agreement before any design change:

In consequence to its Design Responsibility scope (as TC Holder or for referring to its customer) EIROCOPTER must directly approve or transfer for Authorities approvals any design change on qualified products, part or appliances.
EUROCOPTER approbation on requests for design changes given back to the Supplier covers these cases.

The term **"change"** covers the following aspects:

- **modification**: this is a change imposing EUROCOPTER (EC or ECD depending on TC holder of the H/C in destination) or other TC Holder configuration control i.e. affecting installation the dimensional, the reliability, the functional or the maintenance characteristics of the equipment. (often shorten in “3F” for Fit Form Function)

- **amendment**: any other change.

Any change likely to occur on any component (or software) may result either from a EUROCOPTER (EUROCOPTER: EC or ECD depending who is TC holder of the H/C in destination) or a Supplier request.

Any change needing to be approved by EUROCOPTER, to identify this change, the Supplier will draft an **Equipment Change Sheet** using a model accepted EUROCOPTER whatever the envisaged classification of the change. (Harmonisation pending: for commercialised EC: F020-004, ECD: F023 04-008-1, for Tiger refer to (EI101) T 000 M702 E 01, for NH90: F020 186).
The Supplier will not deliver the production material until the Supplier has received formal EUROCOPTER Design Organisation approval through approved Equipment Change Sheet for amendment or through new reference creation process.

For changes requiring additional qualification, EUROCOPTER sends the Supplier a copy of the Equipment Change Sheet stamped with "OK for development". The Equipment Change Sheet signed by EUROCOPTER shall be returned only after the evidence of qualification and the Manufacturer updated DDP are received.

Changes to CAQ (Civil Aviation Qualification), TSO (Technical Standard Order) or ETSO (European Technical Standard Orders) components are not subject to EUROCOPTER approval. However, the Supplier must provide EUROCOPTER with on time information on all the changes (modifications or amendments) using the "Service Bulletin" or Equipment Change Sheet procedure so that the impacts on the installation on helicopter can be assessed by EUROCOPTER

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Specific case of non-recorded amendments

Should an amendment apply to a referenced sub-assembly of a **class (DAL) B**, **C**, **D** or **E** equipment **or Important, Secondary part** (former class 2A, 2B, 3 or not classified), it is allowed this amendment, after formal acceptance by EUROCOPTER, to be only recorded at the supplier's and the amendment issue next to the equipment P/N not to be raised.
In this case, the Manufacturer must ensure by its own process the traceability of the amendment concerned to the equipment S/N.
Any amendment on Class A or Critical equipment must be recorded.

Repair alternative

Any repair alternative which may lead to a non-approved definition status must be subject to EUROCOPTER approval:

- if the repair is to be included in the definition file, the Manufacturer will then make a design change.
- if the repair is not included in a definition file (specific repair instance), the Manufacturer will then request for a recordable concession from EUROCOPTER.

7.5 Control of production and service provision

Depending on the criticality of the materials or further to difficulties experienced, EUROCOPTER may request a process audit to be performed by the Manufacturer. The results of the audit shall be made available to EUROCOPTER by the Manufacturer. If needed, the Manufacturer will also provide EUROCOPTER with the list of personnel authorized for the Non Destructive Tests or welding operations.

7.5.2 Validation of processes for production and service provision

Refer to SOW when existing which will prevail

Service Bulletin

Any proposal of Service Bulletin / Technical Service Letter / Technical Instruction of Execution, issued by the Manufacturer, which has an impact on its material, must be passed on, for validation and / or approval before distribution in EUROCOPTER Customer Support Management.

Maintenance Documentation

The Component Maintenance Manual (CMM) & Component Repair Manual (CRM) must be proposed by the relevant Manufacturer's Department for Eurocopter Design Organisation approval

The CMM/CRM technical conformity is the responsibility of the equipment manufacturer, it complies with the requirements of the aircraft manufacturer in terms of maintainability, testability and maintenance.

The equipment manufacturer draws up the so-called CMM/CRM (maintenance in the workshop) and after this one approval, gives Eurocopter the right to reproduce it and distribute it to customers in electronic format (PDF), in English.

When drafting the CMM/CRM, the equipment manufacturer complies with the ATA100 standard (paper manual) ATA 2100 (electronic manual) for the technical content and the layout.

The equipment manufacturer delivers the manual, accompanied by a declaration of conformity attesting that the CMM/CRM has been drawn up in accordance with the rules in force on the equipment manufacturer's premises and the standard NFL 015C.

The equipment manufacturer provides Eurocopter annually with the revision index of its manuals, in which the maintenance level of the equipment is defined.

Any change to the maintenance data, rules & documentation must be submitted to Eurocopter D.O.

Work on new equipment (Known as "First build-up" or "0 hours")

Work rules for new equipment parts not delivered to customer (Known as "First build-up") are defined in documents specific to EUROCOPTER.

Such operations will be named as REWORK or BRINGING TO CONFORMITY. These corresponding interventions will in no case be considered as "repair", this latter wording being only applicable to parts having already been delivered to final user

All the interventions on these new materials with ETSO TSO or relevant to EASA DO/PO agreements will be realized in accordance with the approvals of production EASA Part 21 (or FAA PMA or EASA agreed equivalent).

The above interventions may be for convenience conducted in another facility than that of the OEM installations, they shall anyway be under the OEM Production Organisation (Part21G)–or the FAA PAH- direct control or through PO-PO arrangements

Some parts to be followed in operation may show in documents, some operating hours that were necessary for tests & reception flights conducted before final delivery for operations. These "Flying Hours" must not be taken into consideration by manufacturers.

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Work on equipment by technical assistance teams

Work on equipment not delivered to end customers by supplier's technical assistance teams

In case the manufacturer has its technical (dedicated or punctual) assistance teams operate in the EUROCOPTER plants, the following rules must be applied (eventual SOW shall prevail):

- The technical assistance teams shall only operate in EUROCOPTER plants after and through a formal request (PO or Contract) and according to a QN, Quality Note(when existing).
- Prior to interventions, EUROCOPTER requestors will formally inform the manufacturer about the scope, the condition and the place of the intervention (i.e. at the laboratory, at a final assembly line, on an aircraft…). These elements cannot change out an evolution of the above formalisation.
- Prior to the interventions, the manufacturer will define and formalize the content of the technical assistance teams' interventions to be realized in EUROCOPTER plants according to EUROCOPTER requests.
- The technical assistance teams will be supervised by EUROCOPTER requestors and geographically limited to dedicated premises.
- Each member of the technical assistance teams must get an exhaustive list of the tools & devices introduced into EUROCOPTER plants (laptop, tools, paper documents, spares etc).
- The technical assistance teams operating in the EUROCOPTER plants on the equipment must be qualified and authorized by their company. Moreover, in the case of operations on "Confidential Defence" classified equipment or on other restricted or confidential parts, subjects or area, the operators must get the appropriate accreditations.
- The technical assistance teams must be identified and their operation period & duration must be determined. They must carry out their operations in compliance with EUROCOPTER Requirements & Instructions (especially for operations at work-shops and on Helicopters).
- All the interventions on the equipment with civil use must be realized in agreement with the requirements of the approval of production EASA Part 21G.
- Any application of a Design definition change (SB or Evolution form- ECPF or EES-) to the equipment parts, cannot be neither conducted nor enven envisaged before full approval of the change by EUROCOPTER Design Organisation and if needed Officials Authorities..
- Any spare components possibly used for the operations shall be conform to the Manufacturer's definition and shall have been submitted to its complete inspection operations.
- The technical assistance teams must certify the conformity of the achieved works: by filling-in EUROCOPTER Quality Notification (QN), by completing their own Work Report and when possible issuing a CoC.
- Any technical operation on equipment implies to update the accompanying documentation (documents specifying the identification and the traceability of the equipment: i.e. log card for equipment and engine notebook…).
- For longer than a week missions, the dedicated technical assistance teams must establish a periodic report of all their technical operations. The report will be sent to EUROCOPTER Supplier Quality Managers.

Work on materials already delivered to a customer for use on civil aircraft subject to the EASA or FAA regulations

Any maintenance or repair operations on parts already delivered to operation or to final customer shall be by obligation performed in compliance with the Manufacturer's maintenance organization approval (**PART 145/FAR 145 or EASA agreed equivalent**).
All material shall be returned to EUROCOPTER together with the authorized release certificate (**EASA Form 1 or FAA 8130-3 or EASA agreed equivalent)**

7.5.3 Identification and traceability

7.5.3.1. Basic marking for equipment

(Except when otherwise formally specified) Manufacturers must bear the following inscribing on equipment to allow their identification:

- the **Manufacturer's Name**,
- the **Manufacturer's NCage/NATO Code**,

This above code being mandatory for most of end-users, when such a marking is not possible the supplier will ask for EUROCOPTER instructions.

- the **Manufacturer's P/N**,
- the **S/N**, or **Batch Nr** (where required in specification)
- the **Equipment Inspection Date** at the end of manufacturing,
- the **Technical Inspection Mark.**
- **for Governmental Programs:** Eurocopter Tiger or NH90 Part Number
- the **Operational SW(s) Part Number**. (if any)

In case of equipment software, the P/N of the Item shall consider both hardware and equipment software.
In case of operational software, a specific P/N shall be defined in addition to the previous one.
Specific indications, if any, must be written in English language.

Data available at end of the manufacturing (date or Inspection Mark) for convenience may be placed in an adjacent separated tagging.

7.5.3.2. Marking of new materials with limited validity, or operated on during storage

Any material delivered to the EUROCOPTER must be identified with **as a minimum**:

- the **Manufacturer's Name**,
- the **Mark of Conformity**,
- the **Manufacturer's P/N**,
- the **Manufacturing Date** (which can be replaced in some cases by another date W).

The Manufacture Date **is replaced by:**

- the Cure Date **(expressed in quarters of a year) for all the elastomer materials,**
- the Assembly Date **(expressed in quarters of a year) for flexible hoses & pipes, elastomer components or equipment mounted on an assembly.**

Elastomer products must be **moreover** identified with the **Durability Group** (or in defect the **Class**) of the elastomer.

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Note: In the particular case of flexible pipes, hoses and piping, it must be marked:

- the Durability Group **(or in defect the Class)** of the elastomer **used to make the** pipe core**,**
- the Nature of the Insulating Material**,**
- the Batch Number,
- the Nominal Pressure**.**

For small size materials or materials where marking would prove destructive, it is accepted that this information needs not all to be identified as described above. It shall then be marked on the package.

7.5.3.3. Marking on new materials with no expiry date

Any material delivered to the EUROCOPTER must be identified with **as a minimum:**

- the **Manufacturer's Name,**
- the **Mark of Conformity,**
- the **Manufacturer's P/N**.

The flexible pipes, Hoses and Piping must **moreover** bear the following marking:

- the Core Material Type,
- the Nature of the Insulating Material,
- the Pipe Manufacturing Batch Number,
- the Nominal Pressure**.**

For small size materials or materials where marking would prove destructive, it is accepted that this information needs not all to be identified as described above. It shall then be marked on the package.

7.5.3.4. Marking of material after overhaul

Overhauled material (0 hours after overhaul) is subject to the same rules as new material.
For material with identification plate, the Manufacturer will add to the initial plate (with initial P/N, S/N and date of manufacture) a second plate or label specifying:

- "Overhaul",
- Date of overhaul, (final inspection)
- Compliance mark.

It is accepted that the Manufacturer may replace the initial plate with a new one bearing, initial P/N, S/N, date of manufacture, plus the above information.

For any material without identification plate, the same information as defined for material with identification plate will be added in the same way as for new material.

7.5.3.5. Concessions marking

The rules regarding marking of concessions are defined in ER070 13-06 specific documents.
. (See appendix J for Governmental Programs)

7.5.3.6. Work's Trace-ability

The Supplier must guarantee that all work performed by his personnel can be traced and the Supplier therefore must implement suitable filing methods.
The initial fabrication date & serialization must be conserved

For in-service monitored equipment, the trace-ability record of the equipment complete lifetime is the Equipment Log Card. All the work carried out on the equipment must be recorded on the Log Card.

EUROCOPTER always requires a Log Card form as per EI 16-04

- The Supplier may use the form proposed by EUROCOPTER in EI 16-04 for commercialized H/C (in EI101 QD S000N0812 E01 for NH90 and in EI101 T000M0986 for TIGER)
- In all cases, the Log Cards must be filled out in strict compliance with the above instructions

7.5.3.6.1. Terminology:

Bringing into conformity:

This is a “work on new equipment”; it consists in restoring the equipment to its physical and functional state when part is new, before any operation at final user.

(The difference with a “Repair” is to be noted: a Repair is only to be conducted on parts already fitted on aircraft in operation, under Part145 or FAR145 perimeter or equivalent. Where applicable, “Bringing into conformity” is conducted under Part21 or equivalent, and cannot be a “Repair”). Another wording could be “Rework” or “Rectification Work”.

Refer to §7.5.2, paragraph “Work on new equipment”.

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***Restoring the validity**:*

This consists in restoring the original storage validity of the equipment by replacing its components and ingredients with limited storage validity without exceeding its technical validity (use-by-date)

Change:

This consists in embodying a change (modification or amendment) on equipment in accordance with an approved definition.

***Working during storage**:*

This consists in performing technical operations in compliance with the manufacturer's instructions in order to ensure optimized storage conditions:

These operations cover:

- Leak tests
- Adjustments
- Calibration

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7.5.3.6.2. Marking of the equipment

a) After a "Bringing into conformity" of equipment

No special marking is applied to the equipment, excepted specific instances e.g. a "Bringing into conformity" associated to a "Restoring the validity" or a P/N change. Only the accompanying documentation is updated (Work Progress Report and Equipment Log Card, if any).

b) After a "Restoring the validity" of equipment

For material with identification plate, the manufacturer must add to the initial plate (with initial P/N, S/N and date of manufacture) a second plate with:
"Restoring the validity"" or "Revalidated" (abbreviations shall be approved by EUROCOPTER when space is limited), Date of "Restoring the validity" (mm/yy), Inspection stamp. It is accepted that the manufacturer replace the initial plate with a new one bearing initial P/N, S/N, date of manufacture and the above information. For equipment without identification plate, the information defined for equipment with identification plate (see above) must be added according to Product Identification & Traceability Rules (§7.5.3 of appendix).

c) After a "Change" of equipment

Case of a (recordable)amendment

The following are added on the original nameplate:

- the reference of the amendment embodied,
- the inspection stamp.

Case of a modification

- An equipment P/N changes. The original nameplate is therefore replaced by a new plate with at least the following information marked:
- the new P/N,
- the date of manufacture corresponding to the date of embodiment of the modification, (final Inspection date)
- the inspection stamp.

d) After a "Work during storage"

The manufacturer must affix a paper tag (instead of on a plate) in an area not visible by the operator after installation in the helicopter or, if impossible, to a tag attached to the equipment.
This paper tag shall bear:

- Manufacturer Name:
- Checked on:
- Statement of Conformity

Caution: The same tag shall also be affixed to the equipment's package.

7.5.3.6.3. Marking on the packaging

After a "Bringing into conformity" of equipment
No specific marking other than the initial marking is required.

After a "Restoring the validity" of equipment
The date of "Restoring the validity" shall be marked in a conspicuous manner on the packaging.

After a "Change" of equipment
The marking on packaging is the same as before modification equipment packaging.

After a "Work during storage".
The same tag as that affixed on the equipment shall be bonded on the equipment packaging.

7.5.3.6.4. Quality records (versus delivery documents)

a) After "Bringing into conformity"
The following documents must accompany the equipment:

- Delivery note,
- Declaration of Conformity regarding the intervention on equipment requested by the Purchase Order:
  As alternative the Authorized Release Certificate (EASA Form 1) issued for the equipment's first delivery may be conserved or may be duplicated (with mention ***"rectification work of an item which has been found to be unserviceable prior to entry into service***" and description of operation in block 12 for EASA Form1).
  Should the work be conducted not at OEM's facilities, the latter shall anyway control it though its Production (or PAH) Organisation directly or under specific arrangements
- EUROCOPTER Quality Note (QN) duly filled out (cause of the defect, components replaced, technical charge),

If the equipment has to have a **Log Card**, the original Log Card, updated by recording on the back of Table 5 the carryover of the operating units and the work designation solely by:
"Brought into conformity" followed by an inspection mark.

b) After a "Restoring the validity"
The following documents must accompany the equipment:

- Delivery note
- For ECD orders only and after specific agreement only:
  Authorized Release Certificate (EASA Form 1 or equivalent) filled in under Part 21
- When not covered by above case: Declaration of Conformity regarding the intervention on equipment requested by the Purchase Order, (when the Authorized Release Certificate issued for the equipment's first delivery is still valid and may not be duplicated).

if the equipment has to have a **Log Card,** the original Log Card, updated by recording on the back of Table 5 the carryover of the operating units and the work designation solely by:
"Revalidated" followed by an inspection mark.

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c) After a change of the equipment

In all cases the following documents must accompany the equipment part:

- Delivery note,
- Authorized Release Certificate (EASA Form 1 or EASA agreed equivalent)
- Declaration of Conformity,

- c.a) Case of a change classified as a recordable amendment

If the equipment requires a **Log Card**, its original one is updated by:

- recording the No. of the embodied amendment embodied plus an inspection mark in Table 1,
- recording on the back of Table 5 the carry-over of the operating units and the work designation solely by:
  "Modified by Amendment No. XXX" followed by an inspection mark.

- c.b) Case of a modification

If the equipment has to have a **Log Card**:

- the original Log Card updated by recording on the back of Table 5 the carry-over of the operating units and the designation "Modified - New P/N YYY" followed by an inspection mark.
- The new Log Card :
  - records the new P/N in Table 1 with the indication: "Derived from P/N XXX" (the one on the original Log Card).
  - records on the front of Table 5, the date of manufacture corresponding to the modification's date of embodiment and the initial date and the equipment's operating units corresponding to Table 5 (back) on the original Log Card, followed by an inspection mark.

d) After "Work during Storage"

- Delivery note
- For ECD orders only and after specific agreement only:
  Authorized Release Certificate (EASA Form 1 or EASA agreed equivalent) filled in under Part 21
- For EC orders only:

Certificate of Conformity only regarding the intervention on equipment requested by the Purchase Order, because the Authorized Release Certificate issued for the equipment's first delivery is still valid and may not be duplicated (as "manufactured").

If the equipment gets a **Log Card,** its original Log Card must be updated by recording on the back of Table 5 the carry-over of the operating units and the work designation by one of the following (depending on the type of test): "Check", "Cross-check", "Weighing", "Filling" followed by an inspection mark.

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7.5.5 Preservation of product

7.5.5.1. Storage, Preservation and Conditioning conditions

The Manufacturer must define the storage, preservation and conditioning conditions (limitations and actions) guaranteeing proper utilisation.
These conditions shall be entered on the "**Sheet of Storage and Conditioning Conditions**" (**F075 15-003, or upon request for EC F020 0026**). This form will be forwarded to EUROCOPTER before the qualification review or, if the latter is not contractually binding, at the latest before the first production item is delivered.

a) Specific rules for "dangerous" products

Handling, storage, preservation, packaging and delivery rules for pyrotechnic materials (delivered individually or with equipment), hazardous products or radioactive material must comply with the applicable national legislations (Safety data sheet, storage category according to packaging, labelling, conditioning and packaging standards etc.).

b) Case of pyrotechnic materials

Should pyrotechnic materials be delivered as components in sub-assemblies, or as accompanying components, the Manufacturer must specify (in same order) on the Release Note of each assembly:

- the UN (United Nations Organization) Number
- the official designation
- the risk category, (should be 1.4)
- the compatibility category. (should be S)
- the Packaging Group (if any)
- the Net Explosive Weight (NeO) in Kg
- the description of pyrotechnic materials,
- the quantity,
- the P/N,
- the ref. of approved Packaging & Authority approval (if any)
- the mode of delivery (in a sub-assembly or as accompanying component),

c) Case of the beacons of distress

The delivery and the transport of beacons must be made **beacon on « off » position** (that is with neutralized internal power, either by disconnection of piles or through switches "RESET» & " OFF ").

7.5.5.2. Packing and packaging mode

The Manufacturer must use specific packing and packaging adapted to the product. E.g. (un-limitative examples):
. painted parts (primer or top coat): protection suitable to prevent friction between the parts,
. use of conditioning on threads (i.e. plastic thread protector or equivalent),
. apply lubricant on steel parts (neutral petrolatum oil or corrosion inhibiting desiccant),
. protect elastomers against the light.

7.5.5.3. Preservation of materials

On material that has to be closed off, the blank must be so shaped that the part itself cannot be mounted until it has been removed. The blank must be brightly coloured and have a large visible collar or fins. The usage of unscrewed he-plugs or transparent or translucent blanks is prohibited.

8.3 Control of non-conforming product

EUROCOPTER shall approve all requests for “use-as-is” or for concessions (either “non recordable” than “recordable”) issued by the Manufacturer.
However, inside a frame of privileges given by authorities, EUROCOPTER representatives may be delegated to the Manufacturer's for approval of "non recordable" concessions. The concession writing/approval procedures implemented by the Manufacturer and the list of authorized signees must have beforehand to be approved by EUROCOPTER. The perimeter and means for controlling this delegation must be formally described in a commonly agreed document

Under this delegated action, only those "recordable" concessions shall be passed to EUROCOPTER Procurement Management, writer of the order, for approval before delivery of concerned materials.
Moreover, all the "non recordable" concessions shall be made available to EUROCOPTER for consultation.
Note: Any concession related to a **"Critical" Part** particularly for non observance of frozen manufacturing process must be classified as "Recordable".

Should doubts arise regarding the consequences of non compliance, the Manufacturer must request a Recordable concession from EUROCOPTER.

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APPENDIX B :

Additional quality requirements for subcontractors and Extended Workbenches

(Applicable in addition to the general core part)

PURPOSE

This document applies to Suppliers who partially or fully manufacture aeronautical products defined by EUROCOPTER

Supplier classification; (refer to EP 06-12 that prevails) depending on the situation the supplier can be:

Subcontractor:	responsible, in accordance with a EUROCOPTER definition file, for the manufacture and/or overhaul/repair of parts or assemblies.
Extended workbench:	responsible, for manufacturing, and/or overhaul/repair of provided products/materials in accordance with production/manufacturing files provided by EUROCOPTER.

These products and/or manufacturing are identified as follow:

- mechanical parts or assemblies,
- sheet metal parts or assemblies,
- composite parts or assemblies,
- electrical assemblies,
- special processes,
- performing manufacturing phases
- blank (supplier of blank are considered as a subcontractors)
- interiors (upholstery, furniture…)

DEFINITION, ABBREVIATION, TERMINOLOGY (proper to this appendix)

The word “supplier” in the present appendix means Major Subcontractors, Subcontractors and Extended Workbenches (abbreviation: E.W). (See doc. Core § 3.3):
EC means, Eurocopter France **as the design responsible** (indicated on the drawing)
ECD means, Eurocopter Germany **as the design responsible** (“ “)
ECE “ “, Eurocopter Spain **as the design responsible** (“ “)

Mechanical parts: means, machined with material removing from massive raw material
Work-package: means, upper assembly kit constituted with product of different technologies

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GENERAL PRINCIPLES

The supplier must check that the sub contracting level is limited to second rank (third rank is acceptable only for special processes and Airframe suppliers) - EC is considered as level zero (rules are detailed in & 7.4.1).

For extended workbenches (EW) supplier's second level subcontracting is forbidden excepted for special process.

ECG-ECE supplier monitoring rules are based on the 3 main steps;

- Authorization (Assessment)
- Product/Supplier qualification (Product Qualification, Special processes, FAI)
- Supplier performance assessment (Discrepancies management, Monitoring)

Authorizations for suppliers are given per activity, "skills", and safety class by ECG-ECE.

Activity: Is a technological domain on which ECG-ECE recognized (assessed and authorized) the supplier competencies (e.g.: pinion machining, detail part made from sheet metal, forging blank, composite sub-assemblies,, metallic sub-assemblies, Electrical harnesses, tools and jigs …)

Skills: Specific ECG-ECE requirements necessary to do an activity or a task and formally authorized by ECG-ECE.

The different "skills" used for subcontractor and E.W are;

1. Procurement of raw material and component
2. Set up work instruction / industrial file (engineering)
3. Subcontract
4. Distortion control of interchange-ability tool
5. Manufacturing of Critical part

☞ A supplier without authorization for skills 1 and/or 2 is named "Extended Workbench"
☞ A supplier with authorization for skills 1 and 2 is named "Subcontractor"
☞ A supplier with authorization for skills 1, 2 and 3 is named "Major Subcontractor"
☞ The skills 4 and 5, to be adapted to the needs

Reminder: in usual language in EC supplier authorized for;
Skills 1 & 2 are called, "Genre "6
Skills 1 or 2 or without skills are called "Genre 8"

ECG-ECE Supplier authorization

For ECG-ECE: the authorized suppliers are listed in repertory L030 03 001 (activities, skills and safety class are mentioned).

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Safety class;
The safety class are; Critical part / important / secondary. Nevertheless, due to Eurocopter history we can find different means to express the safety class, find below a table of equivalence;

(Refer to the applicable issue of the documents)

EP 04-06	*general*	**Critical**	Important	Secondary
(EI 04-06)	DPF 04-06 at EC	Class 1		Class 2&3
		Vital part	Class 1	
	NH90 QDS000N0822E01 & QDN000N804E01	**Class 1A**	Class 1B	Class 2&3
	ECD (EI 04-06-01)	**Class 1**	Class 2	Class 3

For Critical Parts (e.g. Vital parts), the Sub-Contractor must have been qualified by EUROCOPTER in accordance with,
ER070 04-06, for parts to H/C where EC is Design / TC Holder (EC is C/A) or
EI 04 06 01, for parts to H/C where ECD is Design / TC Holder (ECD is C/A)
(Other cases or for other C/A, information on Design / TC Holder is given)
Second level of subcontracting is prohibited (except for special process).

Product/supplier qualification is given to a manufacturing site per part number by ECG-ECE Quality Department when the FAI is validated (including industrial review, products audits and special process qualified).

Eurocopter Special Processes are defined in HS5011.
Special Processes qualification is under ECG-ECE responsibility according EP09-02, EI09-02-02 and EI 070 09 008.
Suppliers for special processes are listed in repertories L 030-03-001 and L 030-03-005.

Monitoring is based on audit, periodic review and product performance
The monitoring will be adjusted according to ECG-ECE internal evaluation.

Non-compliance with the requirements specified in this appendix must be motivated and subject to prior formal approval by ECG supplier Quality department.

4 Quality System

4.2.3 Document and Data Control

Should the order, drawing or any other document refer to an IGC (General Inspection instruction) or an MP (production manual), the supplier must apply them with their EC Application Sheet, which it must be in possession with.

Note: The Application Sheet defines the supplements and/or restrictions specific to EC.

For ECG-ECE
The Global Replacement List of replace-able standard part authorized by ECG-ECE is listed in repertories L020 020.

For EC only
The above Global Replacement List of standard part authorized by EC design office is completed by repertories (EI021) DHN1-007-000.

6 Resource Management

6.2 Human resources

6.2.2 Competence, awareness and training

The supplier must identify the activities (including special processes) with direct effect on the quality and conformity of the product.
These activities will be executed only by formally qualified personnel.

Within each activity, all the personal skills and experience required to correctly perform the tasks will be **defined**. The personnel will be **evaluated** against this list and any possible lack of qualification corrected through **training actions**.

Personal qualification will be granted only after formal approval by the tutor that the personnel are capable of adequately achieving the concerned tasks. This qualification will take the background knowledge, the experience and the training into account.

The evidence of qualification will be **recorded** and **archived.**

When qualified, periodic (no longer than every two years) knowledge and evaluation tests will be implemented for the above mentioned operators and inspectors

In case of major changes in the industrial process (resources, Qualification-related documents, prolonged manufacturing downtime…) or repeated discrepancies, the staff qualification will have to be questioned and reassessed.

For electrical supplier the requirements related to this activities are defined in EI 043 650 13 “skills management for electrical manufacturing subcontractor”

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Specific requirements for NDT & Welding

For welding and NDT, the supplier shall be in accordance with the following requirements;

	NDT requirements		WELDING requirement	
	ECG reference	International Normative reference	ECG reference	International Normative reference
EC	EI 070 18 003	EN4179 / NAS 410	EI075 10 021 EI045 80 E 34 6621 EI045 80 E 34 6620 EI045 80 E 34 6100	ISO 24394 / AWS D17.1
ECD	EI075 08 003			
ECE	EI 070 18 005			

For welding and NDT operator qualification involves a third party organization, the supplier shall comply with the re-qualification periodicities for his personnel imposed by these organizations.

For welding the national organization recognized are defined in the international normative reference. http://www.iiw-iis.org

For critical parts

Personnel involved in the manufacture of critical parts (engineers, operators, inspectors ...) must have received specific training from ECG-ECE, and must hold proof of the training.
The supplier must yearly make sure his personnel is aware of and applies the rules (as per ER 070 04-06 for EC).

For Distortion control of interchange-ability tool

For EC only: personnel involved in this task must have received an EC qualification according EI 070 06 006.

7 Product Realisation

7.4 Procurements

The supplier shall flow down and impose the requirements of this document to all its sub tiers.
The supplier must request and obtain from his own suppliers the same evidences of document conformity as those requested by ECG-ECE.

The following information at least shall be noted on Purchasing Orders;

- Part Number/ Material designation, Description of Task
- Main Procedure and/or Eurocopter requirements
- Technical information (e.g. asna, ecs, drawing….) with applicable issue index
- Documents for deliveries (CoC, FAI and EASA Form1 if necessary, ATR on request)
- Safety class (for Critical & Important parts)

7.4.1 Second-level supplier

On ECG-ECE request, according to hereunder table, the tier 1 supplier must provide with the industrial scheme (included process risk analysis, overview of used sub-tier, flow chart, key characteristic, milestones……).

This industrial scheme shall be agreed by ECG-ECE Supplier Quality Manager.
The supplier shall be formally authorized by ECG for all activities which it is entrusted to.

A supplier can only subcontract when authorized for skill 1 and 3.
Hereafter rules and necessary ECG agreements according safety class and task:

Safety Class	*Task*	*ECG acceptance of Second rank*
Critical	Complete product	**2nd rank cannot be authorized**
	Special process task	See L030 03 001 + EC agreement
	Non special process task	**2nd rank cannot be authorized**
Important	Complete product	See L030 03 001 or EC agreement
	Special process task	See L030 03 001
	Non special process task	EC agreement
Secondary	Complete product	See L030 03 001 or information to ECG
	Special process task	
	Non special process task	

For material involving different activities (e.g.: ***workpackage***….) if the supplier is not authorized for one of the entrusted activities, the supplier shall be qualified for skill 1 and use a Tier 2 supplier listed in L030 03 001 (or especially approved by ECG-ECE) for the concerned activities.

A second rank (Tier 2) supplier can only purchase raw material and components when authorized by ECG-ECE for skill 1 (see index L 030 03-001).
If not the tier 1 has to provide with raw materials and components to this tier 2 supplier.

Trace-ability

The subcontractor shall ensure required trace-ability of all products entered into stock or delivered to ECG-ECE.

7.4.2.1 Quality requirement for procurement of Standard product*

*Standard product means; supplied product defined by normative document (ISO, DIN, EN, ASN, DHS, MIL, ECS, QAE, FRF…).

When authorised for "procurement skill", the Tier 1 supplier shall use a Tier 2 manufacturer qualified by ECG-ECE or distributor according to the document or mentioned below rules;

- Pairs supplier qualified for composite material is available in document L030 03 006**
- Pairs supplier qualified for non metallic raw material is available in document L030 03 007**.
- Pairs supplier qualified for metallic material is available in document L030 03 002** & L030 03 003**.
- Pairs supplier qualified for fasteners, assembling part, accessories is available in document L030 03 011**. (Fasteners, screws, washers, clamps…)
- Pairs supplier qualified for electrical component is available in document L030 03 004**

Specifics for L030 03 011 L030 03 004 lists, when supplies out of these lists are necessary:

- A formal agreement from ECG Strategic Procurement & Suppliers Quality will be needed
- Tier 2 distributor will have to be EN9120 certified
- Surveillance of this Tier 2 distributor will be formally conducted by the Tier 1 with a formal engagement to EC.

Qualified list for AIRBUS pairs of product/supplier is recognized by ECG-ECE for the two last ones.

*** Nota: at the date of the edition, these lists were under process for formalising their span of application to ECG-ECE*

At the ECG-ECE request, the subcontractor shall draw up and maintain the list of product/supplier pairs (manufacturer & Distributor) to be validated by ECG-ECE.

7.4.2.2 . Procurement Data

The subcontractor must get all standards and/or drawing related to the products to be procured. If neither the order nor the definition documents refer to standards, the subcontractors must ask EC for the reference of the applicable standards.

7.4.3 Incoming inspection by supplier

The supplier has at least to:

- Analyze the certificates of conformity and check the equivalence between the specification to which the material supplier is committed and the specification on the order.
- Systematically analyze the test results included in the supplier reports (acceptance test report) with respect to the specification (for metallic, pre-impregnated fabrics and adhesive semi-products used for structural bonding only).
- Check marking in accordance with the ECG-ECE requirements.
  - Check Concession marking and request for approval if any.
  - Verify Manufacturer name
  - Check presence of Inspection stamp
  - Check mention of Part number & serial number (if any)
- Inspect integrity of Packaging condition

In case of non conformities, in accordance with EN9100, the supplier shall either segregate the batch(es) in a properly defined dispute zone than affix on the non conform product label the indication “non compliant”, until the resolution of the issue.

Non conformities

The supplier shall directly monitor the non conformities with the sub tier and keep-on traces of exchanges (answers, acceptance, corrective action, supplier returns etc…).

The supplier shall provide with a feed back to ECG-ECE supplier quality manager at least once a year regarding the non conformities encountered on the procured parts.

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A) Additional requirement for procurement of organic semi-*products (prepregs, film adhesives, bonding primers, paste adhesives, sealants, dry fabrics, honeycomb)*

A. 7.4 Procurement

For cooled materials (prepreg and film adhesives), the subcontractors must required in the purchasing order systematic use of thermal recorder to have trace-ability for each batch and for each delivery.

A.7.4.3 Incoming inspection by supplier

Visual inspection on each batch:

- Packaging (must be undamaged), for cold material: the bag must be sealed.
- If any, dry ice condition
- Raw material supplier marking must be checked (Eurocopter standard, supplier identification, shelf-life in accordance with EC material specifications, Storage condition and batch number) as per EC Material specification and EI 071 IGC 04 81 105 "Marking and presentation of pre-preg.
- Defect of aspect: criterion and requirement for pre-preg (pre impregnated roving tapes not included) are defined in ER070 06 02 06 (appendix 1).

Specific requirement for Shelf life Products (pre-pregs and film adhesives)
Transport and storage
Each batch of cooled materials will be monitored, checked by thermo recorder from the place of material manufacturing to the final destination of use of the product, including intermediate transports and storages. This requirement is mandatory.
Supplier will systematically analyse the records according to the storage specifications and product associated standards of each material.

In case of non conformity, an anomaly report has to be raised and acceptance tests specific to product have to be performed.

Note: For any necessary storage revalidation tests the supplier shall contact LMP ECG. Material revalidation is forbidden for materials entering critical part manufacturing and for adhesive materials

Incoming inspections
For this activity, subcontractors which perform incoming acceptance tests must be qualified by Test Laboratory as defined in the HS5011.
Cases of lower rank subcontracting this inspection must be authorized by Eurocopter.

The supplier shall describe the rules for incoming inspection including associated test.
For information: ECG process is described in EI070 06-033 for Composite material incoming inspection.

The tests to be carried out have to be conducted according to Eurocopter specification (Standard material, manufacturing instruction, L041 001).

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B) Additional requirement for procurement of metal semi-products (sheets, bars, tubes...)

For EC Part, the supplier must have a specific qualification given by EC for manufacturing blanks from semi-products. If not the supplier will procure blanks part from suppliers qualified by ECG.

B.7.4.3. Incoming inspection (technical checks)

- aspect check on each batch (check for impacts, scratches, oxidation, etc.)
- supplier marking check (marking type, grade, condition, standard, batch, supplier identification) as per referred IGCs at EC (*Instructions Generales de Contrôle*) or others applicable document (see list of applicable document)
- dimensional check for thin metal sheets (≤ 6 mm), tubes and sections
- mechanical tests:
  The supplier shall define an incoming inspection plan including at least Hardeness tests completed with electrical conductivity on aluminium alloys. Frequency & periodicity will be formally determined by the supplier.

Note 1: the supplier shall identify raw material bars with a diameter ≤ 16 mm by means of a colour code and/or metallic labels (due to absence of marking on small diameters).

Caution: As regards semi-products used to manufacture critical part, all tests described (incoming inspection) in the specification must be systematically formalized and performed regardless of the delivery condition (tempered, treated…) of the procured part.

C) Additional requirement for procurement of screw, bolt, nuts….

For EC only
For material specified by EC (EC drawing & P/N) additional requirements are defined in QAE 06 02 04.

D) Additional requirement for bearing

For EC only: Requirements are defined in QAE 06 02 03

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E) Additional requirement for procurement of blanks

The supplier must procure blank parts from ECG-ECE supplier specifically approved. ECG-ECE supplier cannot procure blanks which are under ongoing development.

In the case of blanks pending qualification process, these blanks will be under DA or Concession; the supplier will not deliver its subcontractor without formal ECG-ECE approval.

ECG-ECE is responsible for the pair blank / Supplier qualification.

All blanks FAI files, joined to theirs Type Part, DA & Concessions must be directly transmitted to ECG-ECE (not going through the first rank sub-contractor)

Re-qualification is necessary if manufacturing has been resumed after more than 3 years.

The subcontractor must check blank/supplier pair is qualified before series production parts are delivered to ECG-ECE.

Exceptional process: Cut-up "under reservation" (square mark) only with ECG-ECE authorisation

An exceptional process exists for "release under reservation" that may allow first beginning machining blanks in the waiting of completed qualification results. This process must only be applied after ECG-ECE authorisation, for some capital reasons (timing for ex.) and once criticality analysis conducted.
The supplier of blanks will write the following mention on its Test report or CoC for each reference pending FAI validation:

Caution non-qualified blank: pending EC validation

Manufacturing launching with « Cut-up under reservation » is an industrial risk under the sub-contractor responsibility

Eventuality of Blanks provided by ECG-ECE, not yet qualified

Corresponding delivery documentation will have to bear a provisory (EC: square) stamp marking put by ECG-ECE. This mark (stamp) will be transferred by the supplier at Cut-up phase and must be removed and replaced by its definite stamp before delivering the parts (qualification completion of the blank to be checked from ECG-ECE)

The Subcontractor will get assurance that machined parts will be unable to be delivered without definite agreement for the blank EC qualification. Means for having these machined parts actually not delivered will vary owing to the subcontractors, but this discrepancy will anyway be formalized in the manufacturing travellers at cut-up and final inspection phases.
A manufacturing file with a cut-of under reservation must not be doubled up.

Only for EC: Additional requirement are defined in HS5015 and QAE 06 02 02

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Procurement

The supplier must keep evidence that manufacturing files and blank layout modifications have been validated by EC as per QAE 06-02-02.

Product of a batch

For forging blank the semi-product of the batch is used for sample during metallic counter expertise if necessary. It is representative of the batch.

Heat treatment:

If any, heat treatment planned during the process of manufacturing the semi-product of the batch shall be “conserved” until the finalized product delivery. In case of heat treatment and thermo chemical during the manufacturing files of finalized product, the batch sample shall be a part of this semi batch product in order to ensure the representativeness of product.

Reminder: one batch = same casting + same forge campaign + same loading of heat treatment.

E.7.4.3. Incoming inspection

The supplier must draft up a counter-acceptance layout from the test data sheet of the blank. This layout must clearly explain the inspection for:

1) Delivery documents
   - Test Report (mechanical characteristics, etc.),
   - Dimensional Inspection Report (only rough castings for critical parts),
   - X-ray inspection file (for the case provided in QAE 06-02-02).

2) the following information in the Supplier certificates/Supplier Report
   - Blank Part Number,
   - Safety Class category of the Blank,
   - Metallurgical grade + delivery condition,
   - Pair basic metal/generator for forged products (frozen for critical blanks),
   - Type of used Semi-product (bar, bloom, etc.) for manufacturing the blank (frozen for critical blanks),
   - Serial number if applicable or batch No. according HS5022.30,
   - Homogeneity check (hardness and/or Sigma test) in accordance with HS 5015.20,
   - Mechanical properties (Rm, Re, A%, KCU etc.) in operating conditions,
   - Chemical composition of the original material,
   - In case of repairs, indicate "Part repaired by welding" for cast blanks, with a chart locating the repairs. (Letter "S" on cast blanks repaired by welding)

3) the following data, when existing:
   - Supplier's hardness test mark.
   - Casting No of batch(es)
   - Grade and condition,
   - Manufacturer's monogram,
   - Protect corrosion according HS 5015.50,
   - Appearance of the blanks (no knock, scratch, oxidation…) particularly those areas that remain as rough on the finished part
   - Conditioning description

4) The presence of semi test part of the batch (excepted for forging blank)

7.5 Production and service provision

In case of major changes in the industrial processes the supplier shall inform ECG-ECE before any implementation.

A) In cases when Parts or Raw material are provided by ECG-ECE

The Supplier must check referring to the Transfer Sheet (delivery doc.) and/or "list of components" enclosed to the purchase orders, and/or the Delivery Note:

- material or product identification,
- grade and condition (administrative check for metal products),
- batch N°, or serial N° of parts or blanks if applicable,
- quantities and dimensions,
- packaging condition,
- material validity state (including transport conditions...),
- inspection stamp presence on ECG-ECE Transfer Sheet or on ECG-ECE CoC / Delivery Note. (For EC only: following IGC 04-01-110)

In case of detected non-conformity, the Supplier will notify ECG-ECE with indication of all trace-ability data (among others: material indication, batch or serial n°, eventual manufacturing file ref…) and will wait for specific directive before any proceeding.

Raw Material cut up step
The cut up task on ECG-ECE manufacturing file shall be stamped once the raw material conformity (dimensions, grain flow direction, material appearance, marking and trace-ability) has been checked.

B) In case when Manufacturing file is provided by ECG-ECE & supplier not qualified for skill 2

Manufacturing/follow-up data sheet

The supplier shall strictly apply EUROCOPTER routing manufacturing file.

Any change of manufacturing file has to be forwarded and accepted by ECG-ECE.

The manufacturing file must be validated for each phase by the Supplier.

(Excepted when on ECG-ECE request, the parts are delivered partly finished for the phases concerned).

The manufacturing file must be duly filled in, stamped and forwarded with the product delivery.

If the raw material is supplied by EUROCOPTER, for the material cut up the information of traceability shall be ensured and mentioned on the manufacturing file (see §7.5.3).

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The following additional requirements for ***mechanical parts*** are requested

On the manufacturing file, the following information must be included

Transfer Sheet No (OT),
Cast No if applicable,
Batch No. if applicable,
Parts Serial No. if applicable,

Only one single raw material batch No. must be used per manufacturing file.

Caution: For metal parts with grain flow direction specified on the drawing, the Supplier must mention it on the material cut up phase, and a check for this grain flow direction must be included during machining phases (see EI 070 10 003).

C) When Manufacturing file is provided by ECG-ECE for supplier qualified for skill 2:

The manufacturing file does not need to be forwarded with the product delivery.

D) In case when Manufacturing file is written by the supplier

Industrial file implementation

The supplier can only draw up manufacturing files inside the scope for which they are qualified (sheet metal work, composites, mechanical and electrical).

For EC part, the supplier shall take into account EC requirements described into;

EI 070 10 003	"Situation of inspection work in the manufacturing and overhaul process for sheet metal parts"
EI 070 10 004	"Inspection plan for manufactured composite products"
EI 070 10 007	"Inspection plan for manufactured electrical component"
EI 070 10 021	"Installation inspection plan for dynamic components"

The supplier's authorized personnel to validate the processes are those:

- qualified directly by EUROCOPTER
- trained and qualified by those above, on in-house procedure based on EUROCOPTER requirements and specificities (e.g. for EC: protection code, marking code, DML, STL).

The supplier must periodically get assurance that personnel knows and applies ECG-ECE rules for implementing manufacturing files The supplier must inform ECG-ECE with the qualified persons names, as any persons names changes.

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E) In case of Critical part (e.g. former Vital Parts)

For EC

The supplier shall proceed in accordance with ER 070 04 06

Critical Parts can only be delivered after EC has formally accepted the supplier's manufacturing file.

The certificate of conformity shall include the following mention;

Critical Part in accordance with ER 070 04-06 manufacturing file Ref. xx (Issue yy)

For ECD

No additional requirement

F) In cases when tooling (ECG-ECE property) is provided by ECG-ECE

The tooling must be the subject of an inventory by the supplier.
The supplier is responsible for the conservation in good condition of this tooling in order to assure the conformity of the produced part.

G) Specific requirements for machining

Electro-erosion or laser machining

Electro-erosion or laser machining processes on helicopter parts (incl. marking) in the finishing phase is prohibited; it may be applied for machining blanks. In this case, a representative specimen (same material & thickness) must be forwarded to the EC/ECD Materials Laboratory so that the minimal reservation to keep can be determined.

If not specific other indication on drawings,
- all external (acute) edges will be blunt with a radius from 0.2 to 0.3 mm
- all internal (obtuse) angles will be joined with a radius from 0.2 to 0.3 mm.

H) Specific requirements for supplier using interchange-ability tools

For EC:

Tools subject to interchange-ability (the list of tools is managed by EC Tool department) are covered by the general rules defined in EI 09 03.

Two categories of tools are to be taken into account:

♦ Interchange-ability tools for "large assemblies" Bottom Structure (Forward / Rear), Intermediate Structure, Upper Structure (Forward, Centre and Rear), Tail Boom, Fenestron, Horizontal Stabilizer, Pylon, Upper Fin, Cabin Door, important class products (e.g. class 1), critical class products (e.g. Vital Parts).

♦ Interchange-ability tools for "small assemblies" (assemblies not listed above).

Interchange-ability tools can be manufactured only by suppliers formally authorized by EC for "Manufacturing interchange-ability tools and jigs" in accordance with the assembly classification (large / small). Manufacturing includes design, manufacture (or prime contractor ship), upgrade/modification, and checking tool conformity, comparing it with its definition. The authorized suppliers are listed in repertory L030 03 001.

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“General condition" inspections concerning all the tools are at the charge and under the responsibility of the supplier. This inspection must be anyway carried out and recorded each time before tool utilisation.

The wear checks concern all the interchange-ability tools and are also at the charge and under the responsibility of the supplier.

Checking Period for serial tools:
-four years if tool is only check by wear inspection
-two years if tool is check by distortion inspection. In this case, control must be performed three months before distortion inspection.

Repair tools wear inspect every four years. For tools check by deformation inspection, these inspections must be performed three month sooner.

These checks are to be performed on the basis of the tool drawings provided by EC Tools department, on request. These requests are to be formalized by the supplier three months before each time limit is reached.
These checks are to be materialized by:
-inspection reports (which can be the tool drawings annotated with the values found) filed by the supplier with one copy sent to EC (tools department)
-follow-up label validation for the wear checks by the supplier.

Should the check reveals a non-conformity concerning the tool, the subcontractor must send a request for approval to EC tools department in order to receive instructions concerning actions to be taken.

H1) For interchange-ability tools subject to distortion checks

These checks must be performed by EC or by personnel qualified by EC for "Checking distortion of interchange-ability tools and jigs" The maximum periodicity for these checks is 2 years.

The supplier must contact EC tools department at least 6 months before these checks validity limits are reached.

H2) Setting into service an interchange-ability tool:

When an interchange-ability tool is at first set into service, it is certified with a pending stamping mark keeping in mind that interchange-ability demonstrations have not yet been finalized.
However, the assemblies manufactured using these tools can be certified by the supplier provide they are delivered to EC in accordance with the Delivery Report procedure described in this document, in order to indicate: "Assembly manufactured with non-validated interchange-ability tool".
Once the interchange-ability demonstrations have been performed and are compliant, the tools are validated by EC and the assemblies resulting from these tools can be normally delivered.

H3) Relocation of interchange-ability tools anchored to the ground

At least 3 months before moving a tool, the supplier must contact EC tools department in order to define the conditions and scheduling for this relocation.

No tool modification made on the basis of a drawing under EUROCOPTER´s responsibility is possible without the prior formal approval from EC tool department.

7.5.1.1 First serial article inspection procedure

The first serial article shall be accompanied by its file in accordance with ER 070-06-11. The form to be used for this file is defined according to the product technology, (listed in applicable document).

Request of FAI is mentioned on ECG-ECE purchase order and in accordance with EN9102.

No serial deliveries are possible before first serial article acceptance by ECG-ECE.

The FAI part shall be identified distinctly and if possible separately conditioned.
In case of spare part fitted in upper assemblies on which the FAI has been pronounced, the supplier will mention on CoC;

"part already delivered in upper assemblies and validated by FAI"

"upper assembly reference"

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Appendix B: Sub-Contractors

7.5.2 Special Processes

EUROCOPTER special processes are defined into HS 5011 document.

In no case the supplier should use a special process which is not referenced into HS 5011 (e.g., for non conventional machining for example) except under formal approval from ECG-ECE Supplier quality department. The supplier shall need ECG-ECE approval before any implementation

HS 5011 describes qualification type per processes.

PRI Nadcap accreditation does not replace ECG qualification.
The special process/supplier pair qualification by another aeronautical prime contractor does not replace ECG qualification.

Special process qualification by ECG is mandatory and formalized by Qualification Report issuance regarding the Process / Sub-Contractor pair.

The list of qualified "Process/Contractor" pairs, able for implementing special processes is described in Index L 030-03-001. In the specific Critical Parts case, the authorized pairs Parts / Sub-Contractors list to undertake thermal or Thermo chemical treatments is described in Index L 030-03-003**.**

Process Monitoring

At any time, the supplier should be able to provide evidences that EC qualification is maintained. Periodically, upon ECG-ECE request, the supplier shall produce an inventory of all its qualifications. The supplier's quality department shall periodically conduct a monitoring audit program for the qualified processes.

Specific requirements:

- For non-destructive testing processes, the process must be qualified in compliance with European Regulation (see requirements for Human Resources monitoring).
- All the NDT procedures (process sheets) must be validated by a level 3 Cofrend Cosac agent.
  If the company does not possess internal level 3 personnel, validation can be subcontracted to a Cofrend Cosac approved organization. In case of critical part, this must be approved by ECG-ECE.
- In the case of processes where operators qualification requires a third party organization (welding and NDT in particular), the subcontractor must provide with qualification evidences granted by these organizations.
- If these organizations are not qualified in compliance with European Regulation, an equivalence with reference organizations must be demonstrated.

7.5.3 Product Identification and Traceability

Supplier Identification ECG code

A supplier identification code is given by ECG when;

- the supplier has no individual code
- for class 1 part at ECD

For EC
The supplier shall provide his ECG Supplier Quality manager with the code identifying its company (and its sub-tiers) on its inspection stamps, and the one used for serial numbers (component individual number).
When a new supplier ECG code is the same that the one used by another supplier likely to perform the same service or to manufacture an identical product, EUROCOPTER can ask the supplier to change his code. The supplier cannot change his code unless agreed beforehand by ECG.

Marking

For ECG-ECE: as per drawings requirements (for ECG-ECE Governmental Programs refer also to HS5022 & MBBN 240 for Commercialised at ECD)
In addition, ECG-ECE corresponding NATO code must be systematically marked -*refer to "Log Cards" § for ECG-ECE NATO codes indications*- accompanied with ECG Part Reference & Manufacturing file reference

Manufacturing traceability

When the parts are serialized, the component individual number shall be preceded by the supplier's identification code registered with EUROCOPTER Supplier Quality department.

7.5.5 Handling, Storage, Packaging, Preservation and Delivery

Raw Material Storage

Raw material must be properly stored to prevent any mix-ups, deformation or damage (buckling, scratches, marks, corrosion, etc.) throughout the full storage period.

Raw material which belongs to ECG-ECE (as customer supplier item) must be clearly identified

Admittance to the store must be restricted to nominated persons.

All unused material surplus (if any) must be identified then stored with the original identification document (Transfer Sheet or Delivery Note / CoC).

When there are no ECG-ECE specifications of shelf life, the original manufacturer requirements are applicable.

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Accompanying documentation

Certificate of Conformity (Declaration of Conformity) shall mention:

- the issue index of the applicable drawing
- any supplements to the drawing (DML, ACI)
- the processing number for electrical harnesses
- the delivery report reference when applicable
- the reference of any concession (if any)
- the reference of any Request for Approval (if any)
- the reference of the last Quality Notification (QN) if any, for the three consecutive deliveries following the notification of the QN
- Suppliers NATO Code (if any)

Log Cards

See general requirement.

If the Subcontractor delivers product with a Log Card, Table 1 must indicate the following NATO code

Manufacturer's NATO code: **for EC*:* F 0210**
for ECD: CO417
for ECE: 274BB

and the manufacturer's name: EUROCOPTER.

Delivery Report

If, **at EUROCOPTER request**, parts are delivered only partly finished, the "delivery report" ("PVL" at EC) should mention.

In case of product delivery subject to a delivery report each product must be identify with the following text in the language where the product are delivered;

"Warning product submitted to delivery report n° XXXXX"

Mention of this must be indicated on the Certificate of Conformity and delivery note

The Delivery Report, as per Form F070 005, must be forwarded with the parts in the following cases:

- Non-finalized concessions.
- Non-finalized requests for approval.
- Missing Parts.
- Operations remaining to be performed (Product delivered unfinished).
- Any deviation on raw material or components delivered by ECG-ECE.

The supplier is only authorized to deliver the products concerned if the Delivery Report is validated by ECG-ECE (production & quality).

For electrical assemblies, the form to be used is document F070 081 "Electrical Delivery Report".

8.2.4 Inspection and testing

In the case where the Inspection Plan (manufacturing files with inspection phases) is not supplied by EUROCOPTER,

The "Engineering" authorized supplier shall draw up an "Inspection Plan"

For EC: According technologies (electrical, composite, machining…..) additional requirements are applicable;

- EI 070 10 003 “Situation of inspection work in the manufacturing and overhaul process for metal parts”
- EI 070 10 004 “Inspection plan for manufactured composite parts”
- EI 070 10 007 “Inspection plan for manufactured electrical component”
- EI 070 10 021 “Installation inspection plan for dynamic components”

In case of Manufacturing data sheet is provided by EUROCOPTER

The supplier shall strictly apply EC inspection plan as a minimum,

In the case of Critical or Important Parts, Major assemblies,

the supplier shall formalize the inspections to be carried out with the means used (in particular, the measurement facilities) in the form of a specific inspection sheet specifically related to the part number, in order to assure conformity and inspection frequency.

The Majors assemblies are listed in the L020-021 for EC

Inspection and test status

When the supplier certifies the parts conformity upon a final inspection, the final inspection phase must be attested as well as the parts in accordance with the definition and HS 5022 for EC / MBBN240 for ECD.

If the supplier uses a second-rank supplier;

- the inspection stamping must be applied in the final inspection phase and on the part by the supplier's quality manager in charge of the final inspection.
- the certificate of Conformity for the product delivered to ECG-ECE must be certified by the first level supplier.

8.3 Non-Conforming Products Control

Non-conformity detected by the supplier

ECG-ECE is responsible for decision on any non-conformity.

Case 1 – Recoverable material

When the Sub-contractor considers that the material is recoverable, the supplier shall:

- Describe & qualify the non-conformity on an "Approval Request" form and send it to ECG-ECE (See Form 070 018).
- Apply the solutions stated by ECG-ECE on the Approval Requests, i.e. to accept as is, to rework, to keep under concession or to scrap.

In the case a rework is asked by ECG-ECE on the Request for Approval, copy of this “request for approval” must be send with the parts to ECG-ECE with the attestation of correct realization of the rework/repair (“rework done + date + name + signature + stamp-mark”).

In the case of a request for concession; this request has to be performed on Form F070-001, to be filled out as per the rules in ER 070-13-06, or Form F101 001 for NH90 products, to be filled out according to the rules in QDS 000 N 0805 E01

- *send* the completed Concession to ECG-ECE
- take into account of the response from ECG-ECE
- mark the number of the concession (assigned by ECG-ECE) onto the product if “recordable”
- *record* (if “recordable”) the concession on the accompanying documentation (Statement of Conformity, Delivery Report (PVL), EASA Form 1, Log Card, documentation specific to the assembly on which the part is installed...etc.)

Reminder:
No product can be delivered unless the concession and/or request for approval is (are) finalized (excepted if delivery report, see §7.5.5)
Append with the delivery a copy of the approval request and/or concession filled out by ECG-ECE if necessary.

All these documents references shall be mentioned on the Certificate of Conformity.

Case 2 – Material to be scrapped

When material is to be scrapped, the supplier must;

- turn it unfit for use (mutilation)
- certify scrapping on the Request for Approval to be returned duly certified to ECG-ECE “operational procurement”, only if material is given by Eurocopter.

Non-conformity detected by ECG-ECE

In the case of non-conforming deliveries, ECG-ECE Supplier Quality department may inform the supplier through Quality Notification(s) (or via equivalent doc.) on the non-conformities in order to introduce the containment, corrective and preventives actions.
The supplier's response shall be given on corresponding ECG-ECE quality notification form.

When the products have been sent back to the supplier's for rework (bringing to conformity) on return the additional following documents must accompany the part:

- Declaration of Conformity regarding the intervention on part requested by the Purchase Order:
  As alternative the Authorized Release Certificate (EASA Form 1 or equiv.) issued for the part's first delivery may be conserved or may be duplicated (with mention ***"rectification work of an item which has been found to be unserviceable prior to entry into service***" and description of operation in block 12 for EASA Form1 or equiv.).

- EUROCOPTER Quality Note (QN) duly filled out
- If the part gets a Log Card, the original Log Card, updated by recording on the back of Table 5 the carryover of the operating units and the work designation solely by: "Brought into conformity" followed by an inspection mark.

8.5 Improvement

In case of recurrent C or D assessment (for a 6 month period) by ECG-ECE, the supplier shall establish and communicate an appropriated action plan to EUROCOPTER.

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Quality Assurance General Requirements
Appendix C: Engines Manufacturers

APPENDIX C:

Additional quality requirements for manufacturers of engines

(Applicable in addition to the general core part)

Note: There are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9100

The helicopter Manufacturer representatives shall have access to the premises and to the quality records of the engine Manufacturer and of the Suppliers of it, related to the supply subject of the contract/order, in accordance with confidentiality rules, after preliminary acceptance by the engine Manufacturer of the subject and nature of the inquiries and under the condition that these enquiries are strictly related to activities linked with a contract/order signed with the helicopter Manufacturer.

The engine Manufacturer may be subject to supervision by the civil and/or military Official Authorities according to the stipulations on the order, or on the contract. The engine Manufacturer must provide the helicopter Manufacturer with his Quality Manual, and each updating. If a quality assurance plan is required with the supply, it will be conform to the ISO 10 005.

7.3 Design and development

The engine Manufacturer must inform the helicopter Manufacturer of any evolution of the engine that could affect the “interface” (mechanical, electrical, or performance in use) or having a significant weight repercussion.

All modifications with an impact on the 3F concept (form, fit, function) must be identified in the “engine installation and operating manual”. A draft manual must be validated by EUROCOPTER before official distribution.

7.5.4 Customer property

Should the helicopter Manufacturer request the engine Manufacturer to scrap a product, the latter must send the helicopter Manufacturer a Reject Report and a Certificate of Destruction signed by an approved agency for the product involved.

Components supplied by the helicopter Manufacturer must be accompanied by the relevant documents (Log Card, EASA Form 1, Certificate of Conformity) in accordance with the requirements duly quoted in the order placed to the engine Manufacturer. The engine manufacturer would not be liable for any defect on the component delivered by the helicopter manufacturer.

7.5.5 Preservation of product

Accompanying documents

All supplies must be delivered with the contractual documentation paragraph 7.5.5: In more the Supplier provides an engine log book:

- the Engine Book including as a minimum :
  - the modules log cards,
  - the modifications status,
  - the equipment log cards,
  - the compliance to bench performances,
  - the resulting availability,
  - the storage and follow up measures,
  - the measured weight,
  - the list of major concessions,
  - the airworthiness directives status,
  - the initial statuses of the daily follow up of the engine.

  Each engine book is stamped by the Quality responsible of the engine Manufacturer and by the Official Services or their delegates.

- a storage follow up sheet (the humidity indicator device shall be external of the container, if any)

Case of repairs of products in use at customers (R/O DERH layout)

Products subject to an overhaul/repair order must be more accompanied with the following documents:
- any investigation reports
- shop report stating maintenance data used, (ER050 06-002)
- Delivery note,
  - For ECD orders only and after specific agreement only:
    Authorized Release Certificate (EASA Form 1 or equivalent) filled in under Part 21or under Part 145 / FAR 145
  - For EC orders only:
    Declaration of Conformity for Military customer and EASA Form 1 (or FAA Form 1, or TCCA Form 1…) for civil Customers regarding the intervention on equipment requested by the Purchase Order.

Note: The accompanying documentation shall be delivered at the same time than the engine (except if particular request of the helicopter Manufacturer).

8.2.4 Monitoring and measurement of product

Whenever a single inspection of the product does not provide an adequate guarantee, the engine Manufacturer must set up supervision of the manufacturing methods and resources used.

For critical parts, the engine Manufacturer shall identify the critical phases in his process by using Risk Analysis methods.

8.3 Control of non-conforming product

Servicing
The technical actions undertaken by the engine manufacturer representatives at the helicopter Manufacturer are regulated by the Logistics Agreement. The engine Manufacturer must inform the helicopter Manufacturer of all Service Bulletin relative to the engines of the helicopter manufacturer's fleet and which has an influence on the airworthiness conditions of the helicopter.

Control of non-conforming products
Non-conforming products must be identified and segregated to prohibit their use or shipping pending a decision, i.e. acceptance "use as is" or with a concession, repair, touch-up or scrapping.

Major concessions are submitted to the approval of the helicopter Manufacturer.

8.5 Improvement

The engine Manufacturer must notify EUROCOPTER of any major event he detects, of the corrective actions he implements at the occasion of the Major Incidents meetings held between the engine Manufacturer and EUROCOPTER. All anomalies detected by the helicopter manufacturer must be reported at the engine manufacturer major incident meeting.
Furthermore, if required in the event of major failure, the helicopter Manufacturer could be prompted to perform him or have performed by any helicopter Manufacturer -approved company- an inspection before or after delivery, chargeable to the Engine Manufacture, after his preliminary technical agreement. This inspection shall be maintained until corrective actions have been implemented.

APPENDIX D:

Additional specific requirements for maintenance organizations

(Applicable in addition to the general core part)

Note: There are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9110

The ER 050-06-002 shall be applied (not applicable to ECE).

The maintenance organisation must implement only approved repair solutions as defined in the Maintenance, repair and overhaul manuals. Alternate design solutions must be approved by the equipment manufacturer and the aircraft manufacturer.

In the case the maintenance organisation should get no approved EASA Part 145 or accepted FAR 145, TCCA-145 or CCAR-145 organisation, it will built and submit to EUROCOPTER a Quality Assurance Plan taking into account all requirements from EASA Part145 & AS/EN9110. This Quality Assurance Plan must be agreed between parties, it will cover all needed additional requirements not beard by current organisation. Among all specificities, focus will be made on Human Factors & Safety Management System.

8.5 Control of non-conforming product

Servicing

The Supplier shall be able to assure the maintenance / repair of the delivered product; as such he must arrange the adequate documentation of maintenance and, in case of repair (according Part21 definition and relevant EUROCOPTER instruction for “maintenance data validation”, transmit it to EUROCOPTER Design Responsible for approval).
The Supplier, according order request, must perform the maintenance / repair operations according regulations requested by the order (for products with civil usage, approvals EASA Part 145 or accepted FAR 145, or TCCA-145 or CCAR-145,awarded by the competent civil authorities.

Maintenance of used products

Components subject to overhaul/repair orders must be additionally accompanied by the following documents:

- Authorized Release Certificate according requested regulation: EASA Form One for EASA Part 145 approved repair organizations. FAA form 8130-3 or EASA Form One Dual Release for FAR 145 approved repair organizations accepted EASA Part 145, Form AAC-038 for CCAR-145...
  In this case, the Authorized Release Certificate replaces the Certificate of Conformity
- Certificate of Conformity in alternative of above, or if required
- Shop report concerning the status of conducted changes, performed works or services, applied service bulletins and airworthiness instructions, and indication of the used maintenance data including all information requested by document F050-06-002.
- Acceptance Test Report
- List of parts with TBO service life or service life restriction (if required)
- Concession if any
- Any inspection report(s)
- Log card (if required), Release to Service
- Maintenance Validation Dossier in case of first repair or overhaul and if requested by the order.

GRFS: General Requirements for Suppliers
Quality Assurance General Requirements
Appendix E: Distributors, F: Brokers

APPENDIX E:

Additional quality requirements for Distributors

Scope
This appendix specifies the quality requirements to be applied by the distributor, either as acting as First or lower rank, on his organization and on aeronautic products he provide

Generalities
No additional requirements to AS/EN9120 in general except for:

7.4 Purchasing

The Distributor is only authorized to deliver products from "EUROCOPTER authorized" manufacturers, as specified in the order or the contract. If the Distributor intends to deliver a product whose manufacturer is not authorized by EUROCOPTER, he must previously request authorization from EUROCOPTER.

7.5.5 Preservation of product

Besides his own Statement of Conformity, the Retailer and\or Distributor (or Manufacturer acting as Retailer and\or Distributor) will deliver products with the original Manufacturer's documents of conformity referring to the specification, mentioning Bach or Serial N°, and, so applicable, the Tests and\or Analysis and/or Inspection Reports (systematic for Raw materials), Safety Security data and the eventual requests for concessions.
In the case of a batch broken down, the copy of these documents is accepted. If asked with Purchasng Order, the original of the Authorized Release Certificate will be joined.

APPENDIX F:

Additional quality requirements for Brokers (special kind of distributor)

(Applicable in addition to the general core part)

Note: There are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9100

Scope
This appendix specifies the quality requirements to be applied by the broker, on his organization and on aeronautic products and services he provide

Generalities
Additional to the requirements of AS/EN9120 the **ER 070-06-20** shall be applied and fulfilled in general.

APPENDIX G:

Additional quality requirements for manufacturers of maintenance tool & On Ground Equipment deliverable to End – Customers

(Applicable in addition to the general core part)

Scope
This appendix specifies the quality requirements to be applied by the manufacturer for Tools & Test Means, on his organization and on products and services he provides.

- The qualification of the product shall also include CE Directives requirements (i.e. 2006/95CE, 2004/108/CE, 2006/42/CE, 1997/23/CE, 1999/92/CE…).

The Supplier must provide with (plus any contracted additives):
- the Statement of Conformity,
- the results of tool validation,
- the user manual if requested by the order,
- the calibration certificate when applicable

These suppliers are only required to get a Quality Organisation with an ISO9001 certification.

GRFS: General Requirements for Suppliers
Quality Assurance General Requirements
Appendix H: Services Providers

APPENDIX H:

Additional quality requirements for Services Providers

(Applicable in addition to the general core part)

SCOPE
This appendix applies to Suppliers who handle services relating to aero product and/or End Users satisfaction: Supply Chain Services, Logistic, Engineering, Intellectual Services, Tech Pub, Training, Tech Assistance, IT/IS …directly procured of through EADS General Procurement interface

INTERVENTION ON EUROCOPTER FACILITIES
When a Supplier has to work inside EUROCOPTER facilities, he shall apply and formally commit with several rules relating to Security, Health & Safety, Confidentiality, Environment, Airworthiness and Quality. The Supplier has the obligation to plan interventions in a close cooperation with EUROCOPTER customer department who also helps for coordination.
In case of intervention during a holiday period or on Sunday, the Supplier shall obtain an additional and specific authorization.
Each intervention or continuous on-site assistance, on aero products shall be managed with the prior agreement of EUROCOPTER quality department in charge of the product or service conformity. Access to some Industrial facilities, Assembly Lines or Flight Test area requires a specific qualification approved by the customer department and the quality department of the area where the intervention takes place.
In this kind of activity, the Supplier, what ever his classification is (EP 06-12) insures a Service Provider mission and shall apply consequently this Appendix.
Following to intervention or continuous on-site assistance, the Suppliers shall provide a quality report for activity where he states the conformance of services. In case of interaction with the product he will record the results of activities and produce the relevant release product documentation.
Subcontracting this kind of activity by the Supplier is submitted to a prior approval of EUROCOPTER.

GENERAL PRINCIPLES
At company organization level, the Service Provider Quality Management System (QMS) shall comply with the requirements of EN9100 and with all the regulations obligations part of the segment he operates (Airworthiness, Safety, Labour, Environment…). To demonstrate this compliance, the Supplier shall have a QMS certified by a Certification Registration Body delivering a Certificate including the service activity and listing the associated facilities.

In addition and for contract execution, the Service Provider must apply the compulsory EUROCOPTER instructions and definition of need set into the Work Specification (also named Statement Of Work) or the Frame Contract. The operational quality and project management requirements can be developed into these documents and/or refer to dedicated documentation such EI (EUROCOPTER INSTRUCTION), ER (EUROCOPTER REQUIREMENTS) or other standardized documents.

GRFS: General Requirements for Suppliers
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Appendix H: Services Providers

4 Quality management system

Each contract placed for services shall be fitted with a Quality Management Plan submitted to EUROCOPTER acceptance before contract execution.

If the Supplier's QMS does not meet:

- the minimum requirements in term of certification and agreements,
- the EUROCOPTER operational quality and project management requirements,

- The Quality Management Plan shall develop and highlight through a compliance matrix, the recovering actions and practices capable to restore a satisfactory level of service (i.e. training by EUROCOPTER, use of EUROCOPTER technical means…).

- The following chapters shall be part of the Quality Management Plan (non exhaustive):
  - Processes mapping and KPI location
  - Project Management including Specific organization for starting the contract
  - Organization for the contract execution and roles and responsibilities of each actor
  - Quality Risks Management
  - Quality records
  - Configuration Management
  - Quality Assurance for Design, Production and Services including quality gates (reviews, First Article Inspection…)
  - People Qualification
  - Subcontractors quality management
  - Identification & traceability
  - Manufacturing means and practices qualifications
  - Identification of incomplete deliveries (concession)
  - Customer provided products and data
  - Nonconformities management (on products, services and processes) and links with Risk Management Plan

The Quality Management Plan shall be up dated in case of a major change at Supplier organization.

4.2.4 Control of records

Each contract placed for service shall be prior fitted with a Non-Disclosure Agreement and completed by conservation and archiving rules for Quality-related documents (see general part chapter 4.2.4).
The Supplier is not allowed to sign EUROCOPTER Quality-related documents or to use EUROCOPTER quality identification stamps.

6.2 Human resources

Training and qualification of people is under Supplier responsibility using, methods registered in its SQM and at least fulfilling EUROCOPTER practices. EUROCOPTER could be part of the qualification process, when linked to EUROCOPTER agreements; so the Supplier shall appropriate and apply the EUROCOPTER rules for employees' qualification. In this case, the Supplier may be subject to direct audits from EUROCOPTER and Official Services in the scope of EUROCOPTER agreements.
The Supplier shall manage a relevant assignment of persons for contract execution, considering their skills from Expert, Senior, Junior to New Comer (EADS ABCDEF classification). For the Project Management it is recommended to assign the leadership to an Expert or Senior level.

7. Product realization

When the service includes a design activity, the Supplier can produce detailed service specification, test procedure, process flow chart, tool specification which shall be under quality assurance process and subject to EUROCOPTER acceptance. All the design outputs produced by Supplier in addition to EUROCOPTER ones shall be at least available in case of reversibility up to deliverable when contractual.

So when the service starts by a design or an implementation process for the service, the Supplier shall led then a validation sub process to demonstrate the serial service is resulting from stabilized production process and organization. The validation sub process, shall initiate the formal receipt on the first service delivered and on the basis of EN9102 requirements completed by the ER070 06-11. EUROCOPTER shall be informed of the receipt scheduling in order to participate.

Planning of product realization

The Supplier shall manage the project by his own, involving EUROCOPTER on relevant steps. Those steps and payment ones shall be as more as possible identical.
The Supplier must make available to EUROCOPTER his internal project management relating to the service within the scope of the contract, and to the associated records and tools (contract risk management, planning change, people qualification and skill, localisation change, major subcontractor change…).
In addition to the starting and termination reviews, the Supplier shall lead progress reviews with a relevant periodicity for service fulfilment all along the contract.
The management of the Improvement Plan shall be part of the agenda of these reviews.

SERVICE CONFORMANCE PROCESS

The service conformance process at Supplier shall involve on relevant steps, the Supplier Quality function that shall have the authority to stop or authorize service delivery and to manage conformance process for the complete life cycle (proposal, contract review, design, production, support and termination).

The Supplier shall maintain a system capable to trace and record the result and conformance of a provided service. As a minimum he can materialize the service by presenting an acknowledgement, any document/record capable to demonstrate the service is delivered up to an activity report for a period of delivered services.
This documentation, connected to payment process, shall include a clear statement of service conformance (1) and they shall be managed by Quality function at Supplier.
The EUROCOPTER form for this documentation prevails to Supplier one.

(1) i.e. it is hereby certified that apart from the approved deviation noted in the present document, the service/product listed above and the workmanship conform in all respects to the contract requirements and applicable standards and regulations.

REVERSIBILITY PLAN

The Supplier shall maintain a Reversibility Plan which describes the arrangements able to insure the reversibility of data, rules and practices but also the specific arrangements which insure that EUROCOPTER could be, if necessary, able to provide a continuation of Services:

- In case of Supplier failure due to bankrupt, activities cessation…
- In case of services re assignment to EUROCOPTER or an other Supplier, what ever the reason is,

In the scope of reversibility, the Supplier shall insure that all the data, rules and practices are usable and recordable by EUROCOPTER. The Supplier shall guarantee definition and traceability of activities belonging to the service.

Customer-related processes

Support for EUROCOPTER

The Supplier shall maintain a capability to support EUROCOPTER beyond the contract. To contribute to different needs which can occur beyond the contract perimeter, EUROCOPTER ask for partnership and flexibility at Supplier for problem solving. The Supplier can provide a support service using his resources, knowledge, expertise, tooling, data…
The Supplier can be requested to participate on reviews for improvement of existing processes, documentation and tools.

8.3 Control of non-conforming product

When detected by the Supplier, the Supplier shall correct and then prevent it. If the correction jeopardizes the on-time delivery or service level, it shall inform the EUROCOPTER customer department to decide if the correction is relevant before delivery. If not and on EUROCOPTER decision, the Supplier shall note the allowed deviation on the documentation used to materialize the service delivery.

When detected by the EUROCOPTER, the Supplier will receive a request for correction and for prevention, using the Service Quality Notification form (SQN), or equivalent for specific areas. The Supplier shall answer in a requested time and detail the action plan indicating the due dates. Depending to number or gravity, this detection can initiate the claim process.

Both origins shall be recorded and managed at Supplier quality management system.

In addition to the case by case answer on the SQN, EUROCOPTER can request to the Supplier a global quality report with the root causes analyses and the actions plan status.

8.5 Improvement

The Supplier will contribute to service competitiveness by leading a continual improvement process for EUROCOPTER (PDCA process of the ISO9001-V2000).

The aim is to:

- Implement a shared and relevant measure of the service performance,
- Afterwards check periodically EUROCOPTER satisfaction,
- For piloting an Improvement Plan capable to save costs and to improve, efficiency of processes, quality of the service and customer satisfaction.

This process is initiated on EUROCOPTER request or by when detecting ways for improvement.

APPENDIX I:

Additional quality requirements for Suppliers in Airbus Programs

(Applicable in addition to the general core part)

Note: There are only those numberings and headings mentioned where EUROCOPTER has additional requirements to those of EN9100

Suppliers for Airbus parts, appliances and equipment shall keep the AP2190 (GRAMS) requirements (only in the case this document is asked in the contract).

EC(D) acts as the purchaser in the following items; the seller is the appropriate Supplier/subcontractor.

4.2.4 Control of records

For the retention of documents (incl. periods, definitions and the way of archiving) the AP 2003 is applicable.

5.6 Management review

Supplier Quality Review

The Supplier shall participate in regular 'Quality Review Meetings' organised by the Purchaser.

7.2 Customer-related processes

Applying and fulfilling the Airbus processes
The AI processes are applicable. In the case the process can not be met, a permit for alternative shall be approved in written form by Airbus (organised by ECD).

7.2.3 Customer communication

The Supplier is required to inform the Purchaser prior to any changes of the Manufacturing & Inspection Plan (not only presented during FAI).

7.4 Purchasing

Acceptance of Cascade for Subcontracting

The sub-contractor cascade in terms of contractual quality responsibility shall not have more than 3 levels.

The Supplier cannot delegate the qualification and quality survey to the sub-contractors that means the Supplier shall have to directly qualify and survey all the sub-contractors of the cascade.
All transfer of work shall be approved in written form by the purchaser.

The Supplier is responsible to give the Purchaser the proof that the Airbus requirements are met all along the cascade.

When the Supplier subcontracts safety critical or important parts/equipment or “major assemblies”; it must establish an IPO PO arrangement to forward the confirmations of approved design data to the sub tier Supplier.

7.5 Production and service provision

7.5.1.4 Control of work transferred, on a temporary basis, outside the organization’s facilities

Information of planned transfer of work
The planning of an outsourcing project shall be agreed between the Supplier and the Purchaser.

7.5.2 Validation of processes for production and service provision

Special process validation
The AI (Airbus Industries) special processes are applicable; all processes the Supplier applies shall be approved by ECD/Airbus.

7.5.3 Identification and traceability

For equipment the traceability for the complete lifetime is guaranteed by using the label according to AP5171 (Using Equipment Label for Equipment Data Tracing).

8.2 Monitoring and measurement

Audit planning & Audits

The Supplier shall provide an annual planning for internal and external (Sub-tiers) audits.
The purchaser, EUROCOPTER, can conduct related product audits in the production sites of the Supplier. The Supplier shall provide access to the purchaser, Airbus members or authorities for monitoring the product quality.

8.2.4 Monitoring and measurement of product

Product Inspections and Final Tests

The Supplier is responsible for the quality of its supplies and ensures the conformity of the finished product with the specified requirements, in particular by means of pre-delivery inspections and final tests.

8.2.4.2 First Article Inspection

According to BSF-013 (Airbus document) if the AP2190 is not applicable.

8.3 Control of non-conforming product

According to EI026 08-003. In the case a deviation occurs a concession the AP2006 (Accepting Non-conforming Items by Concession) has to be considered.

APPENDIX J:

Additional quality requirements for Suppliers in Governmental Programs

For Equipment parts Manufacturers this Appendix J application is required in **addition to core of the document & to Appendix A,**
For Subcontractors this appendix J is in **addition to core of the document & to Appendix B** requirements.

Specific Abbreviations

AQAP	Allied Quality Assurance Publication
ATE	Automated Test Equipment
CCB	Configuration Control Board
DVL	Data Validity List
ECT	Eurocopter Tiger
ETS	Equipment Test Specification
GQA	Governmental Quality Assurance
GQAR	GQA Representative
GSE	Ground Support Equipment
HAC	Helicoptere Anti-Char
HAP	Helicoptere Appui Protection
OCCAR	Organisation Conjointe de Coopération en Matière d'Armement (*Joint Organisation for Co-operation in matter of weapons*)
OTD	OCCAR Tiger Division
PIR	Production Investment Review
SOR	Schedule of Requirement
SPC	Statistical Process Control
SRU	Shop Replaceable Unit
STANAG	Standard of North Atlantic Treaty Organisation
STTE	Special-to-Type Test Equipment
UHT	Unterstützungshubschrauber TIGER

4.2 Documentation Requirements

Configuration Management Plan, Risks Management Plan
The Supplier shall provide for approval with a Configuration Management Plan & a Risks Management Plan as defined in the “Statement of Work (SOW)” of the Contract, they will be consistent with AQAP 2110 requirements.
Quality Assurance Plan
The Supplier shall describe in the Quality Assurance Plan (AQAP2105) the contents of Manufacturing route, the Inspection Files, the Test Plan and the control rules. This Plan will be submitted to Eurocopter for approval.
The Quality Assurance-plan shall also describe the Quality monitoring and the provisions for continuing improvement
The Suppliers Quality Assurance Plan must be provided by the supplier to its NQAR.

GRFS: General Requirements for Suppliers
Quality Assurance General Requirements
Appendix J: Suppliers in Governmental Programs: TIGER

For parts, products & services in destination of TIGER Program,

In addition to Appendixes A & B, The following documents & requirements are applicable.

Specific documents applicable to TIGER Programs		
T000A0812	"« PI Review Procedure for subsystems and equipment »	EDMS EI101
T000M0982	Quality Plan	EDMS EI101
T000M0984	Concessions procedure	EDMS EI101
T000M0985	« Discrepancy reporting procedure »	EDMS EI101
T000M0986	Log card procedure	EDMS EI101
T000M0702	"Configuration Management Procedure to be used with the suppliers"	EDMS EI101

Suppliers Quality Assurance Plan
The Suppliers Quality Assurance Plan shall take into account the applicable serial configuration management procedure (T000M0702)

Marking: tooling
Specific tooling is identified by appropriate marking (identification plate) so the helicopter type (Tiger) and part to which they are dedicated may be identified (by repeating the part series reference number in the tooling identification). In addition, marking is including an indication to show ownership of the customer.

Production and Service provision

Log Card procedure (EI101) T000M0986 will be applied

Control of Non-conforming Products

Handling of Non Conformities is described in the documents:
(EI101) T000M0985 « Discrepancy reporting procedure »

GRFS: General Requirements for Suppliers

Quality Assurance General Requirements

Appendix J: Suppliers in Governmental Programs: NH90

For parts, products & Services in destination of NH90 Programs,

Specific documents applicable to NH90 Programs		
QD S000N0822E01	"Critical" parts management	EDMS EI101
QD S000N0805E01	Concessions procedure	EDMS EI101
QD S000N0812E01	Log card procedure	EDMS EI101
QD S000N0806E01	Anomaly reporting & handling procedure	EDMS EI101
QD S000N0816E01	Supplier Production Investment Review	EDMS EI101
QD S000N0815E01	Supplier First Article Inspection procedure	EDMS EI101
QD S000N0817E01	Specific tools/test means validation procedure	EDMS EI101
QD S000N0818E01	Special processes validation procedure	EDMS EI101
QD S000N0819E01	Guide for writing equipment test specification	EDMS EI101
QD N000N0804E01	Classification and procedure for structural and mechanical parts	EDMS EI101
F020 186	NH90 Equipment Change Proposal from Suppliers Form	EDMS

3. Specific Definitions

Direct delivery
It is delivery from a Supplier to a Partner Company which is not the Buyer.

Inspection File
The Inspection File is the set of technical documentation which defines the procedures and the processes to be applied and the means to use to check:
- that the products are in compliance with the Definition File,
- that they are carried out in accordance with the instructions given by the Manufacturing File.
Note: The Manufacturing File and the Inspection File can be integrated into a single document.

Item
It means the Equipment and its Spares, any type of hardware, software, report, data, assistance, service and any other outcomes to be rendered by the Supplier to the Buyer within the Contract and/or Agreement.

Manufacturing File
The Manufacturing File is the set of documents which defines the procedures, the processes and the means necessary for the established production of an Item in compliance with the Definition File.

7.3 Design

Declaration of Design and Performance

The Declaration of Design and Performance (DDP) and its subsequent updates, shall be approved by Eurocopter corresponding Design authority. A DDP shall be provided at the first delivery and after any design modification of the item
The Declaration of Design and Performance's content/form is to be requested to Design Department

GRFS: General Requirements for Suppliers
Quality Assurance General Requirements
Appendix J: Suppliers in Governmental Programs: NH90

7.4 Purchasing

The Supplier shall inform in advance Eurocopter of any new sub-contract(s), change of subcontractor(s),

7.5 Production and Service provision

7.5.1 First Article Inspection & PIR

A PIR shall be carried out according to the document: (EI101) QD S000N0816E01.
The FAI shall be performed according to the document: (EI101) QD S000N0815E01.
The Supplier shall set up a surveillance of manufacturing process and related means through an Inspection and Test Plan that shall include periodic (calendar or number of Items) complete verification to verify to keep under control the constancy of the quality level during the whole production phase.

7.5.2 Special Processes

The Validation shall be carried out in accordance with the document "Special processes validation procedure": QD S000N0818E01

Software

Production activities related to software will be the following, according to AQAP-160:
_ Safe storage of masters,
_ Replication procedures from masters, including check of the copy conformity,
_ Loading procedure and verification,
_ If applicable, delivery procedure,
_ Implementation of configuration management rules (maintenance).

Evidence and traceability

The Supplier shall be able to make available, on Buyer's request, for each delivered Item:
_ Evidence of incoming inspection of all supplied Items,
_ Identification of material,
_ Traceability of storage conditions (when applicable),
_ Evidence of reviews, inter-stage inspections, final inspections and tests and the identification of the inspectors involved,
_ Evidence of release documentation for delivered Items,
_ Identification of each technical problem, non conformity and evolution of the configuration/definition of the Items,
_ Evidence of traceability (Item against Definition Files, means...).
All these records shall be retained ten years from the delivery (except for "Critical Parts" see specific document) and shall not in any case be destroyed without prior permission of the Buyer.

Log Card

Where requested, Log Card shall be established in accordance with "Log card procedure": (EI1010) QD S000N0812E01.

Delivery documentation

In addition to general documentation, the Acceptance Test Report will be provided.

Packaging identification

Except otherwise agreed, the packaging identification shall be consistent with the requirements of AECMA 2000M/STANAG 4280

GRFS: General Requirements for Suppliers
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Appendix J: Suppliers in Governmental Programs: NH90

7.6 Control of Monitoring and Measuring Equipment (Tools & test means)

7.6.1 Validation of specific tools/tests means

It shall be carried out in accordance with “Specific tools/test means Validation procedure”: (EI1010) QD S000N0817E01. In addition to the tool reference, the identification plate shall mention:”NH90-PI/P0001-June 2000” (without indication of property).

7.6.2 Reporting

The Supplier shall, consequently, deliver to EUROCOPTER, according to DRL requirements, the list of its tools and/or test means developed, manufactured or purchased for specific NH90 purposes in the format and to the extent/content as agreed.

8.2 Monitoring and Measurement

GQA can never be a reason for justifying any delay on contractual commitment

8.3 Control of Non-conforming Products

The Supplier shall notify its local NQAR of non-conforming items received from sub contractor that have been subject to GQA, according to the list provided by its NQAR (AQAP110).
Within Contract limits, the reporting on defective Items shall be managed according to “Anomaly reporting & handling procedure”: QD S000N0806E01.
In case of repetitive anomalies or failures rate leading the Supplier to be unable to replace the defective Item(s) in the conditions defined in the Contract following conservative actions shall be taken:
_ Functional incoming tests, under Supplier responsibility, with the relevant means will be implemented at the Buyer premises, or Buyer representative may decide to attend systematically to Supplier‘s acceptance tests until 10 supplies delivery without anomalies/failures,
_ A Supplier analysis and action plan shall be established to eliminate the anomaly as quick as possible and to prevent recurrence,
_ A quality audit of the Supplier may be held at relevant premises.

The handling of Non Conformities is described in the documents: (EI101)QD S000N0805E01.

Special Investigations

When a defective Item is the subject of a special investigation, steps shall be taken by the rejecting company to ensure that the unit is properly packed, sealed and the outside of the container distinctly marked:
“TO BE OPENED ONLY IN THE PRESENCE OF THE BUYER’S QUALITY MANAGEMENT AND NQAR (OR WITH THEIR AUTHORISATION) “.

Items supplied with "ground use only" limitations, will be subject to the following mandatory requirements:
 The Items shall be identified by a bright red band approximately 20mm wide or as wide as is practicable for the size of the Item,
 The Release Note, the CoC and The Log Card (where applicable) shall be clearly endorsed "NOT FOR FLIGHT",

GRFS: General Requirements for Suppliers

Quality Assurance General Requirements

Appendix J: Pri-NADCAP eligible & approved processes

Appendix K: eligible & approved accredited Pri-NADCAP Special Processes

List of Special Processes Pri-NADCAP accredited, eligible & approved by ECG-ECE or AIRBUS

The Pri-NADCAP accreditation is requested on these hereafter Special Processes for being approved and monitored by ECG-ECE & AIRBUS: (list valid at the date of publication)

Chemical Processing
Coating: plasma spraying
Composites
Heat Treating
Non Destructive Testing
Material Testing laboratory (for tier two subcontracted tests)