

Purchase Order Requirements

Quality Flow Down

Quality Flow Down

- **There are 2 sessions covered in this class:**
 - **Quality Clauses**
 - **Raw Material/Special Processes**

Quality Flow Down are found on Hawker Beechcraft web page

Quality Clauses



- **Quality Clauses are listed on the Purchase Order, they address:**
 - **Requirements for individual Part Numbers or groups of Part Numbers.**
 - **Requirements based Engineering, Quality, and FAA requirements**
- **Hawker Beechcraft Corporation checks for compliance to Clauses at Source or Receipt Inspection.**
- **Nonconformance is documented as Quality Notification for non compliance to the quality clauses.**

Quality Clauses define some requirements for the product being purchased

Quality Clauses



File Edit View Favorites Tools Help

Back Search Favorites Media

Address http://www.raytheonaircraft.com/about_us/scm_con

Thu. March 25, 2004

- <http://www.hawkerbeechcraft.com>
 - About Us
 - Supply Chain Management
 - Supplier Information
 - Contractual Flow down
 - Attachments
- **Select: Attachment 1022 Quality Assurance Purchase Order Clauses**
- **This document is revision controlled**

Home About Us Aircraft Government

About Us

- Company Facts
- Organizational Chart
- Executive Profiles
- Family of Companies ▶
- Historical Overview
- Genealogy Chart-Products
- How to Find Us ▶
- Newsletters ▶
- Publications ▶
- Special Interest Stories
- Gift Shop
- Supply Chain Mgmt. ▶
- Vision, Strategy & Goals
- Raytheon.com

Supply Chain Management
Supplier Information

Contractual Flowdown

The documents contained in this section may be attached to your Purchase Orders, Requests for Quotation, or Blanket Agreements.

The full text of each document is contained herein for your reference.

Your Purchase Order. For any questions or requests regarding any of the documents, please contact the Buyer referenced on your Purchase Order, Request for Quotation, or Blanket Agreement.

Documents in this section require the Adobe Acrobat Reader™. The reader can be obtained [here](#).

FARS - DFARS can be accessed at <http://farsite.jill.af.mil>.

DPAS (Defense Priorities and Allocation System Program) can be accessed at <http://www.dhs.gov/bxa/bmp/coe.org/dpas.html>.

- Terms & Conditions ▶
- Specifications ▶
- Attachments ▶
- Certifications ▶

About Supply Chain
Supplier Diversity ▶
Supplier Information ▶
Contacts
Ethics ▶
SCM Tools
Service Network Login
Search Supply Chain

Internet

Quality Clauses



- **Currently QA does sampling audit of Purchase Orders released to assure correct Clauses are flowed down**
- **Quality Clauses cleanup is an ongoing task**
- **If you have any questions regarding Quality Clauses on your Purchase Order, contact Supply Chain Management. Appropriate changes to the purchase order will be done if required.**

Contact Supply Chain for questions on any Purchase Order requirements

Quality Clauses

- **Some Important Quality Clauses**

- **102 – Parts built to Requirements**
- **125 – Source Inspection**
- **133/184 – Raw Metallic Materials**
- **136/185 – Approved Processes**
- **148/187 – Identification**
- **166/188 First Article**
- **177/183 – BS25691**
- **179 – Fracture Critical**

*This slide will change when the company's Quality Clauses are replaced with QNotes.
ECD 12/2007 for total transition*

- **Responsibilities**

- **Company**

- Screen Purchase Orders

- Make PO Corrections

- Provide Supplier Support

- **Supplier**

- Review Contracts/PO's

- Request Correction (if required) Hawker Beechcraft

- Buyer Point of Contact

- Flow requirements internally and externally

- **Metallic Raw Material**

- **Hawker Beechcraft requires that metallic raw materials be provided from Hawker Beechcraft approved Mill Sources**

Mill Source is the material manufacturer that provides the final product form (e.g. Tube, Extrusion, Sheet, Plate, Casting, Forging, etc.)

- **Products must be procured from Hawker Beechcraft approved distributors for Hawker Beechcraft designed parts**
 - **A listing of these approved distributors is available on the http://www.hawkerbeechcraft.com/about_us/scm_quality_assurance.shtml**
- **Copies of original Hawker Beechcraft approved Mill Source certifications must be forwarded with end item parts or kept on file which ever is applicable**

Original Mill Source Certifications are required for Raw Materials

Raw Material/Special Processes

- **Raw Material/Special Process Lists**

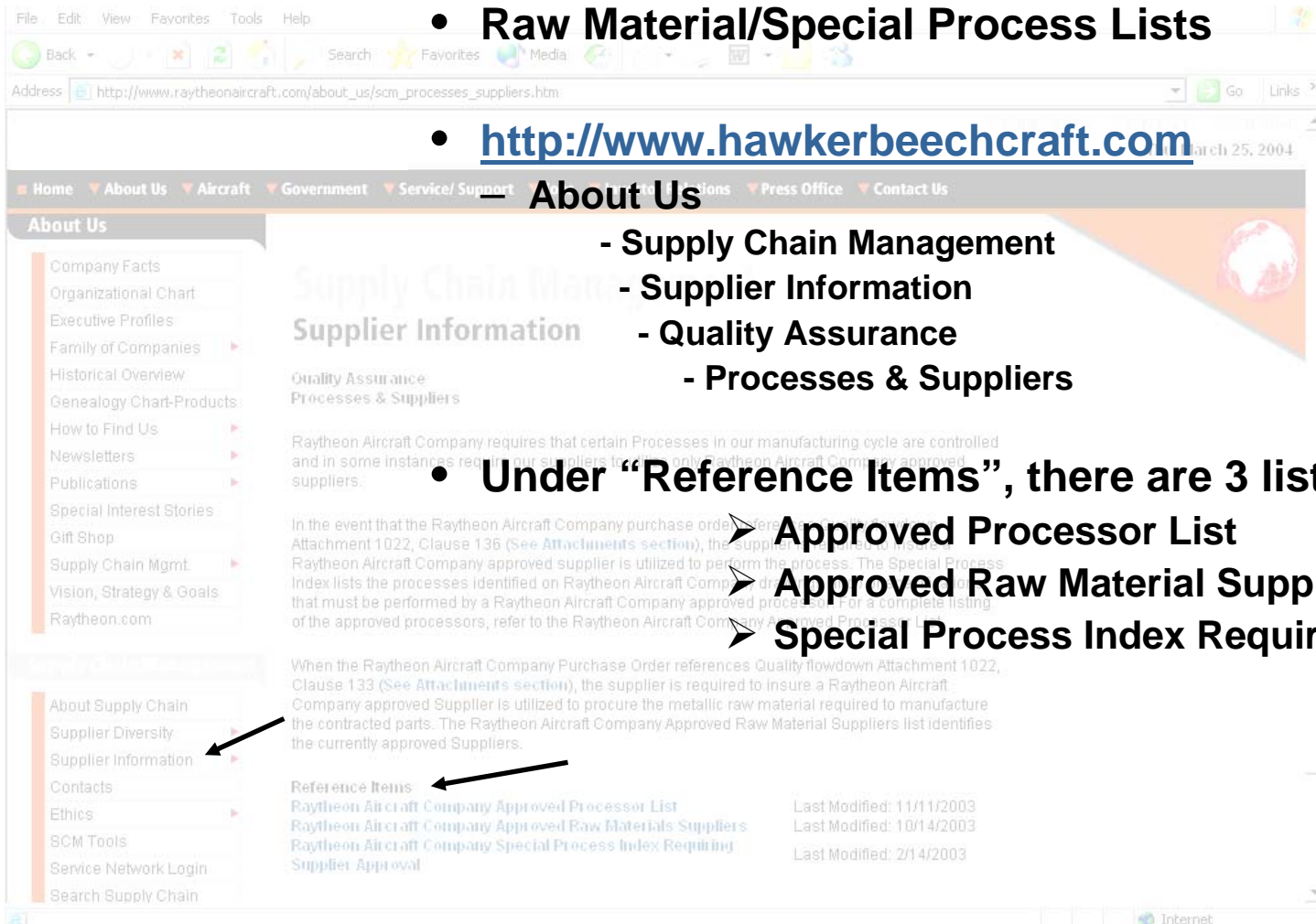
- <http://www.hawkerbeechcraft.com>

About Us

- Supply Chain Management
- Supplier Information
- Quality Assurance
- Processes & Suppliers

- **Under “Reference Items”, there are 3 lists :**

- **Approved Processor List**
- **Approved Raw Material Suppliers**
- **Special Process Index Requiring Approval**



- **Metallic Raw Material (Cont)**
 - **Requests for Deviation (Size, Temper, etc.)**
 - **BS25691 Control of Product Manufacturing Processes for Suppliers and Outside Production covers some allowable deviations and substitutions**
 - **Deviations not covered in BS25691 must be approved by Hawker Beechcraft Engineering prior to material use. A Variation Request (VR) must be submitted and approved before shipment. VR serves as evidence of such approval is required for each shipment. A copy of the VR must accompany each shipment.**
 - **Permanent changes must be requested through the Hawker Beechcraft Change Request (CR) Process by the usage of the Data Submittal form.**

Material Deviation must be approved by Engineering or through BS25691

- **Special Processes**

- **List of Processes Requiring Approval on Website**
- **Only Hawker Beechcraft Approved Processors may be utilized whether subcontracted or internal processes**
- **Hawker Beechcraft currently requires NADCAP approval for new additions and eventually supplier base wide**

Major NADCAP Process Areas to Date:

- » **Heat Treating**
- » **Chemical Processing**
- » **Non Destructive Testing**
- » **Welding**
- » **Non Conventional Machining**
- » **Quality Systems (NADCAP mandates AQS or AS9100)**

- **Special Processes (Cont)**

- **BS25691 Control of Product Manufacturing Processes for Suppliers and Outside Production**

 - Hawker Beechcraft Design**

 - General Processing Requirements for Planning**

 - Source/Specification Control Drawing Parts not affected unless specific requirement on drawing**

- **On-Site Audit by NADCAP or Hawker Beechcraft required for all Approval**
- **Supplier Periodic Audits to include Special Process reviews**
- **NOTE: Buyers and Suppliers need to check this site often for current information**

BS25691 is on the web.

• <http://www.hawkerbeechcraft.com>

About Us / Supply Chain Management / Supplier Information / Contractual Flow Down

 - Specifications**

 - Under “Hawker Beechcraft Specs” is BS25691**