HISTORIQUE DES RÉVISIONS

Rev	Date	Révisé par/Revised by	Nature de la révision/Revision change
01	17/07/2023	Marc Turco	Replace D-ACH_07 rev 8, Complete review and update for AS9100D, As 1300 and AS9145 Include update of P&W requirements
02	26/1/2024	D. Brousseau	Q01 – Replaced Table A for Table 1 Q06 – Added for CMM report

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Clauses	Subject	Description
Q01[1]	QMS	The External provider Quality System must meet one or more of the requirements specified in Table 1. (Ref ISO 9001:2015, AS9100D, IATF16949:2016, ISO13485:2016, ISO 17025, AQAP2110, NADCAP at last revision).
Q02[2]	Not Certified QMS	The external provider must evaluate for temporary or permanent work transfer as specific scope approval. The Work Transfer process shall be authorized by Abipa's original customers.
Q03	CofC eCofC	At a minimum, one (1) original copy with unique certificate number of Compliance (C of C) is required with the packing slip. The C of C must include: o Unique CofC no for traceability o The name and address of the External provider o Abipa.'s P.O. and his latest revision o The date of certification, o Product description (part no, name, serial number, etc.) o The quantity shipped accepted and/or rejected o Reference at work order number/production lot o If applicable, the list of individual serial numbers, o Techniques approved with the revision level, o All applicable specifications including revisions and/or amendment, o The test results (if required) o Declaration to the effect of the product is indicated as having been inspected and conforms to the Abipa. PO requirement, drawing, specifications, and Reference lot no / Job number on PO. The certificate of conformity must be signed, dated, and stamped by an authorized representative with the title, position, or designation of the signatory.
Q04[3]	Raw matl cert.	A copy of the original raw material certificate (factory test results) is required with the shipment, including testing and the heat code of casting. The test report must include the reference specifications, the details of the laboratory test result and the certificate shall be signed by a cognizant test laboratory person, clearly confirming that all tests and inspections have been performed and results meet the drawing and/or specifications limits. Documented evidence of this conformity including listing of each material element or test result in the applicable test report.

[1] Ref AS13100 table 2 par 8.4.2.1
[2] Ref AS13100 par 8.4.1.1
[3] Ref AS13100 par 8.4.2.3

Clauses	Subject	Description
Q05[4]	Special process	Special processes / non-traditional machining: o The External provider may only use a special process subcontractor from a source approved by Abipa and its respective customers. If the External provider does not have NADCAP approval, the validation record for each special process must be approved by Abipa. o Certificate for special processes, NDT and test reports are required for shipment. The certificate must indicate the reference specifications and the details of the results of the laboratory tests. o A Ray (Rx) report including films is required according to the standard specified on the purchase order or the technical drawing. o The validation of each special process and the results must comply with the specifications defined by Abipa and these customers.
Q06[5]	FAIR	First Article Inspection (FAIR) must be performed in accordance with SAE AS9102 (see RM13102) and a copy of the report (3 forms) must be included with shipment or provided upon request for approval prior to delivery. A First Article Inspection Report (FAIR) must be provided if: o A new part is launched in production o A change has occurred in the production process, inspection methods, tooling, material and/or technical characteristics of the product. o A part is manufactured after a gap of 2 years in production o A change of place of production o An event that has occurred that may have changed the process or equipment. o At the request of Abipa It is applicable to production and a single run production, excluding prototype. **Note :** If a CMM (Coordinate Measuring Machine) is used as an inspection instrument to verify the characteristic accountability, a document or CMM report is required with the results ballooned corresponding to the features listed in AS9102 Standard Form 3. The part used for the construction of the FAI report must be labeled.
Q07	APQP/PPAP	When required by the purchase order a PPAP must be submitted to Abipa and must meet one of the following requirements: o AS9145 standard for ASD products, AS13100 chapter B, RM13145 o For Pratt & Whitney a UPPAP as per ASQR 9.2 (UTC Production Part Approval Process) o For Safran an DVI report (Industrial Validation File)
Q08	final inspection	Final inspection report on 100% of the 25 first parts must be done, this report must include all applicable contractual requirements and a copy of the report must be included with the shipment. The inspection report must include: o the measured characteristics of the technical drawing o the results of these measurements (with operator and/or inspector stamp) o the type of measuring instrument o the unique identification number of the instrument o a bubble drawing identifying the measurements taken on the CMM report (if a report is provided) These documents must be sent with the corresponding parts.

[4] Ref AS9100D par 8.4.3 (i)
[5] Ref AS13100 par 8.5.1.6

Clauses	Subject	Description
Q09[6]	Final inspection sampling	Final inspection report required using the sampling technique previously approved by ABIPA. The application of the sampling program must be c = 0 (zero default) on statistically controlled characteristics. The program must consider the requirements and include all applicable contract requirements. A copy of the report is included with the shipment. Sampling of characteristics identified as critical or major is not allowed unless a process certification program is in place that demonstrates a Cpk ≥ 1.33 min (on the first batch of 30 or more) or Ppk ≥ 1.33 in production. Sampling planning is defined in specific customer specifications (ex: ASQR 20.1) The document process may include alternative inspection (Ref RM13002).
Q10[7]	Lab	External calibration report according to ISO17025 is required for all measuring tools.
Q11	Report submitting BEFORE shipment	The External provider must send to the ABIPA. Quality Representative all reports, and valid documentation as required by this procedure and purchase order for approval and authorization of the pre-delivery product lot.
Q12[8]	On-site release inspection BEFORE shipment	On-site (on-site) release inspection by ABIPA. quality representative or by delegation must be performed prior to shipment. External provider must contact the Quality Manager at least two days in advance to make arrangements. ABIPA.'s main customer may also request a quality check at the External provider's facilities. Release inspection by ABIPA. or its customer after a product delivery authorization or inspection at source does not relieve the External provider of its responsibility to provide proof of actual quality control and to provide an acceptable product. Complies with all applicable requirements. This inspection does not exclude subsequent rejection by the end-user customer.
Q13[9]	DPR&V DQR	The service provider is authorized to accept the product for the ABIPA customer if the parties have been formally authorized to do so according to the end customer's program. o Raytheon according to SCOP DQR
Q14[10]	ADQR	When Abipa delegate product release. the provider is authorized to accept the product as part of Abipa's Work Transfer process by an authorized ADQR. The external provider shall provide documented information of training for self release delegates and satisfy the requirements of AS131001 and AS9117.

[6] Ref AS9100D par 8.4.3 (i)
[7] Ref AS9100D par 8.4.3 (k)
[8] Ref AS9100D par 8.4.3 (f)
[9] Ref AS13100 par 8.4.2.2
[10] Ref As13100 par 8.4.2.2

Clauses	Subject	Description
Q15	In-process Quality Control OpCert	Control in production. When the results are produced during production and there is no planned final inspection for these characteristics, the External provider must have a quality control program approved by ABIPA. This program must include: o The establishment of a control plan o FOI (First-off Inspection) o Current method o Operator certification process Control plans must be approved for the product and ABIPA. may require and /or specify specific inspections for the key characteristics on the control plan.
Q16[11]	SPC	The results of the CSP (statistical control), data, and inspection control charts for the key (critical) characteristics are required including the capability results. The report of the results of the SPC must be included with the C of C.
Q17	Preservation	The External provider must propose and make approve the method of preservation and identification of the product including the control of FOD to prevent damage, deterioration, contamination, substitution, or diversion of products.
Q18	Lot/Batch	For non-serialized parts, the External provider shall maintain acceptance records. The records shall be traceable to the batch and/or heat code when applicable.
Q19	S/N	The External provider shall maintain complete records of traceability on the processing of serialized parts when serial numbers are called for by the drawing or the purchase order for critical product.
Q20	Frozen Process	The external service provider must document a process for 'Process frozen' according to customer requirements with reference to the PO -PWC: CPW135 and SQOP-01-07 latest revision -PWC: PWA 370 latest revision The CofC must include a note with ESA with the reference number and Rev approved
Q21	Critical Item	A documented program for the management of Critical Parts / Frozen Process / Flight Safety / ESA / Designated Part / etc. must be in place when specified to ensure product safety. This program must be approved by ABIPA.
Q22	Military program	Canadian External providers performing work associated with any military program shall be duly registered with the Canadian Controlled Goods Program (CGP), as decreed by the Defence Production Act. American External providers performing Work associated to any military program, shall be duly registered with International Traffic Arm Registration (ITAR).

[11] Ref AS9100D par 8.4.3 (j)