



# CESSNA QUALITY REQUIREMENTS

## For SUPPLIERS

### (CQRS)

Export Compliance

Revision	Export Control Classification
N/C-L	-
M	EAR99
N	EAR99
O	EAR99
P	EAR99

Restrictions: None.

Revisions

CQRS revisions are identified with an alphanumeric identifier (Example A, A1, A2, B, B1, B2, etc.) The letter indicates the revision level. Compliance to the latest revision level of the CQRS is required.

To view previous changes made to this document, please refer to previous revisions.

<u>Letter</u>	<u>Date Written</u>	<u>Description</u>
N	2-13-14	REASON: Changed trade compliance to collaboration in Section 2.3. Changed Cessna Tooling Inspection to Cessna SCQE in Section 4.3.3. Added a minimum CPK requirement to Section 4.16. Added Section 4.17.
O	8-23-16	REASON: Incorporates requirements to limit the return of components rejected three or more times. Removes the requirement for a supplier to have a documented procedure on how to notify Cessna of changes within their company.
P	12-14-16	REASON: Updated Section 4.13. Changed company name from Cessna to Textron Aviation. Removed referenc to form X-126 – Engineering Change Verification Status.

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\*Original signatures are on file

## TEXTRON AVIATION QUALITY POLICY

To create great products and keep them operating safely.

## TEXTRON AVIATION SUPPLY CHAIN QUALITY ENGINEERING'S MISSION STATEMENT

Supply Chain Quality Engineering will develop a world class supply chain, by fostering supplier relationships built on trust, partnership and continuous improvement, ensuring products and services delivered to Textron Aviation and Textron Aviation's Customers conform to requirements.

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## 1.0 SCOPE

This document establishes the Textron Aviation quality requirements for suppliers. These requirements apply to Manufacturers, Distributors, and Special Processors providing parts or services for Textron Aviation when this document is specified by inclusion on a purchase order (PO) or contract issued by Textron Aviation.

In the event that the PO or contract conflicts with the requirements of this document, the PO or contract requirement will supersede.

## 2.0 INTRODUCTION

CQRS flows down the quality system requirements of Code of Federal Regulation, Federal Aviation Regulation (FAR) 21.137, and defines Textron Aviation's additional quality requirements. It also advises suppliers that their quality system, facilities, and those of any sub-tier supplier are subject to site evaluations by Textron Aviation, Textron Aviation customers and regulatory agencies.

The Director/Manager of Textron Aviation Integrated Supply Chain Quality Engineering must approve deviations to the requirements included herein. Requests for deviation shall be documented and submitted to Textron Aviation Supply Chain Quality Engineering (SCQE). Contact information can be found at [www.supplier.cessna.com](http://www.supplier.cessna.com).

### 2.1 Supplier Approval

Suppliers' quality systems shall comply with the latest revision of the appropriate quality systems standard along with the Textron Aviation specific quality requirements within this document. Documented evidence of compliance to the appropriate quality management system (QMS) standard along with a successful onsite Textron Aviation or Textron Aerospace Company supplier quality audit is required prior to production.

Documented evidence may be in the form of registration by an accredited registrar who is approved for registrations to the required aerospace standard and listed in the Online Aerospace Supplier Information System (OASIS) database ([www.iaqg.sae.org/oasis](http://www.iaqg.sae.org/oasis)) or an affidavit confirming compliance based on an internal audit or second party audit. Textron Aviation approval is required for all Manufacturers, Distributors (Pass Through Distributor) and Special Processors who supply aircraft parts or services. Interior fabric/textile suppliers are exempt unless they provide structural, flight critical or restraining system items. Suppliers providing commercial product (not specifically designed for the aerospace industry) may also be approved without showing compliance to the requirements outlined in the document.

All written and oral communications with the supplier as well as the supplier's specifications, procedures and reports shall be in English.

Questions regarding quality approval shall be directed to Textron Aviation SCQE.

## 2.2 Supplier Re-Approval

Supplier approval shall be re-evaluated at least every five years by Textron Aviation SCQE. Re-approval will be based on the supplier's quality performance, changes in the supplier's quality system, delegated inspection authority or changes based on the needs of the business.

The supplier shall notify Textron Aviation if the primary contact(s) for quality changes. It is the responsibility of the supplier to provide to Textron Aviation a written statement of any changes in the supplier's ownership, location or changes that may alter the overall effectiveness of the supplier's quality system, including revisions to quality management system certifications. This notification shall be sent to Textron Aviation SCQE. Contact information can be found at [www.supplier.cessna.com](http://www.supplier.cessna.com). Upon receipt of this notification, Textron Aviation will determine what re-approval(s), if any, is required.

### 2.2.1 Supplier Relocation

Suppliers shall provide advanced written notification to Textron Aviation SCQE of any intent to relocate the production, manufacturing, repair or overhaul of parts/assemblies. Such notification shall include, as applicable, the following information:

- a) Current and proposed facility locations.
- b) Proposed part/assembly numbers, specifications, special processes and tooling.
- c) A proposed transition timeline with a risk mitigation plan that prevents disruption in the supply and/or support of parts/assemblies.
- d) Any additional information required by Textron Aviation to understand business and/or legal impacts.

Textron Aviation SCQE shall review the notification and advise the supplier on lead-times required for approval activities. Textron Aviation SCQE and the supplier shall agree on a timeline for the transition. Quality Management System approvals shall be in place prior to the movement of actual production of part/assembly work.

## 2.3 Supplier Performance Monitoring

Textron Aviation evaluates supplier performance in the areas of quality, reliability, schedule, collaboration and cost as applicable. Performance tracking is accomplished utilizing Textron Aviation's Supplier Tracking And Rating System (STARS). Supplier-specific STARS quality data may be reviewed at [www.supplier.cessna.com](http://www.supplier.cessna.com). Instructions for accessing and interpreting the STARS information are also available at the site.

The STARS Quality rating is based on either a parts per million defective (PPM) calculation or the number of rejects. The Tier One or Tier Two status is determined by the total number of receipts in the previous calendar year. More information may be found at [www.supplier.cessna.com](http://www.supplier.cessna.com). Nonconformances submitted and approved via



Supplier Rejection Disposition Reports (SRDR) prior to shipment or source inspection will not be included in the PPM calculations.

The supplier is responsible for complying with quality system requirements noted herein and for meeting performance expectations. Failure to comply with requirements or to achieve an acceptable performance level may result in an on-site audit or additional source inspection oversight at the supplier's expense. Textron Aviation reserves the right to debit or invoice supplier accounts to compensate for inspection or related activities that take place as a result of Textron Aviation directed inspections.

### 3.0 QUALITY SYSTEM REQUIREMENTS

#### 3.1 Manufacturers

In addition to other requirements within this document, Textron Aviation requires manufacturers of materials, parts and assemblies to have a quality management system that complies with the (AS/EN/JISQ) 9100 Quality Management Systems – Requirements for Aviation, Space and Defense Organizations. Copies of the AS standard can be purchased from SAE International at [www.sae.org](http://www.sae.org).

#### 3.2 Special Processors

A list of all processes requiring Textron Aviation SCQE approval can be found at [www.supplier.cessna.com/cgi-bin/quality/capability\\_view.pl](http://www.supplier.cessna.com/cgi-bin/quality/capability_view.pl).

Any suppliers performing work on Textron Aviation design-controlled part numbers to the specifications at the website above will require approval by Textron Aviation SCQE prior to conducting any processing. Requests can be made at the above website to add additional suppliers to Textron Aviation's approved special processor list. Additions will be made at the discretion of Textron Aviation. However, Textron Aviation reserves the right to rescind approval of special processors at any time at Textron Aviation's sole discretion. Some special processes require that the supplier obtain additional facility qualifications from Textron Aviation Material and Process (M&P) Engineering. M&P Engineering approval requirements are contained within the applicable process specifications.

Special Processors must have a quality management system that is compliant to (AS/EN/JISQ) 9100 Quality Management Systems –Requirements for Aviation, Space and Defense Organizations or accredited to AC7004 Quality Management System Requirements for Nadcap Accreditation. Approval by Textron Aviation SCQE will involve an on-site audit of the supplier's QMS and the applicable special processes. The QMS audit may be waived for suppliers accredited to (AS/EN/JISQ) 9100, ISO 17025 or AC7004. The ISO 17025, General requirements for the competence of testing and calibration laboratories, scope of accreditation must cover the Nadcap scope of accreditation and be from an approved NACLA/ILAC (National Cooperation for Laboratory Accreditation/International Laboratory Accreditation Cooperation) accreditation body. In addition, special processors shall achieve and maintain

Nadcap/NUCAP (Nadcap Users Compliance and Audit Program) accreditation in order to be listed as a Textron Aviation preferred special processor. Nadcap/NUCAP accreditation is required in the following disciplines:

- Composites
- Non-Metallic Materials Testing (Composite Part Manufacturer's Captive Laboratories, Independent Material Testing Laboratories)
- Non-Destructive Testing (RT, UT, PT, and MT)
- Chemical Processing (painting, plating, anodize, etch and various other wet processing)
- Heat Treating (including furnace brazing)
- Welding and Brazing
- Surface Enhancement – shot peen only
- Materials Testing Laboratories (raw material testing)

\*\*\*Textron Aviation will no longer maintain a QPL for Independent Testing Laboratories. The use of independent laboratories is permissible only if the laboratory carries the applicable Nadcap accreditation (e.g. AC7101/2 Rev B – Nadcap Audit Criteria for Materials Test Laboratories – Chemical Testing AI Base.) This information is available in the QML listing on the eAuditNet website.

Information regarding the Nadcap/NUCAP accreditation process can be found at [www.pri-network.org/Nadcap/](http://www.pri-network.org/Nadcap/).

It is the supplier's responsibility to ensure that Textron Aviation SCQE is notified regarding any change of Nadcap/NUCAP certification status.

### 3.2.1 Special Process Documentation Requirements

For all deliveries, all Textron Aviation defined special processes that are performed on Textron Aviation design-controlled part numbers must be identified and documented. Documentation must include the date performed, name and location of all special process suppliers, as well as all special processes, including embedded special processes that were performed.

- An embedded special process is defined as a Textron Aviation defined special process that is not called out directly in a Textron Aviation purchase order, engineering drawing or OPSS, but is referenced within a higher level Textron Aviation defined special process that is called out in a Textron Aviation purchase order, engineering drawing or OPSS.

For first article deliveries, all special processors and Textron Aviation defined special processes, including embedded special processes that are performed, must be listed with applicable certifications on form 2 of AS9102. Copies of the AS standards can be purchased from SAE International at [www.sae.org](http://www.sae.org).

### 3.3 Distributors

A distributor is defined as a supplier that procures parts, materials or assemblies and sells these products to a customer without affecting product characteristics or conformity. Distributors must employ a documented quality system that is compliant to (AS/EN/JISQ) 9120 (R) Quality Management Systems – Requirements for Aviation, Space and Defense Distributors or (AS/EN/JISQ) 9100 Quality Management Systems – Requirements for Aviation, Space and Defense Organizations. Copies of the AS standards can be purchased from SAE International at [www.sae.org](http://www.sae.org).

### 3.4 Sealant Manufacturers and Suppliers

Textron Aviation requires sealant manufacturers, suppliers and distributors to achieve and maintain the appropriate Nadcap accreditations.

For each delivery, the manufacturer, supplier and/or distributor shall submit certifications which shall contain the requisite material data as defined in the applicable material specification, along with a copy of the Nadcap Source Inspection Approval Certification.

## 4.0 SUPPLEMENTAL QUALITY REQUIREMENTS

### 4.1 Deliverable (Airborne) Software Quality Control

The applicable version of RTCA (Requirements Technology and Concepts for Aviation)/DO-178, Software Consideration in Airborne Systems and Equipment Certification, or its equivalent, shall be used as guidance during development, certification and management of airborne software.

### 4.2 Stamp Control

An inspection stamp system shall be established and maintained for Textron Aviation design-controlled parts in accordance with the following requirements:

- a) Inspection stamps shall be designed to be identifiable to the supplier and the supplier's inspector who affixes the stamp.
- b) Stamps shall be used to verify in-process manufacturing and inspection operations (e.g. heat treat, radiographic, magnetic particle or ultrasonic testing, and MRB).
- c) Non-issued stamps shall be kept secure to prevent unauthorized use.

### 4.3 Tooling

#### 4.3.1 Tooling Inspection

Suppliers furnishing an initial order of parts from newly manufactured, modified or reworked tooling shall perform a first article inspection that complies with AS9102,

Aerospace First Article Inspection Requirement. A copy of the First Article Inspection Record (FAIR) shall be submitted to Textron Aviation along with the first lot shipment.

#### 4.3.2 Supplier Required Periodic Tooling Inspection

The supplier shall ensure that tooling which controls or checks the final configuration of Textron Aviation design-controlled parts and assemblies are inspected a minimum of once per year to ensure compliance to tool design, master control tools and to Textron Aviation engineering requirements. The results of these inspections shall be recorded and records retained per CQRS quality record retention.

In addition, the supplier shall address any damage, missing tooling components or wear to tooling prior to producing parts to ensure compliance to Textron Aviation engineering requirements.

For spares tooling that is used infrequently, a 100% part inspection may be used in lieu of tooling inspection to determine compliance to Textron Aviation engineering requirements or a tooling inspection may be performed prior to each use.

#### 4.3.3 Textron Aviation Requested Periodic Tooling Inspection Reports

Textron Aviation SCQE will notify the supplier's quality representative by letter when Textron Aviation requires the supplier to complete a periodic tool inspection. The notification will be transmitted by e-mail, facsimile or mail and consist of a list of the tools. The supplier's authorized quality representative will date, stamp and sign the letter certifying the periodic inspections are complete and show compliance to tool design, master control tools and Textron Aviation engineering requirements. The supplier shall return the letter to Textron Aviation SCQE via e-mail, facsimile or by mail. The supplier's quality representative will facilitate having the tooling and tooling log inspection stamped to note the completion of the periodic inspection as applicable. Supplier's records of the Textron Aviation Requested Periodic Inspections shall be retained per CQRS quality record retention requirements.

#### 4.4 Part Identification

CSTI029, Identification: Inspection and Special Processes, may be flowed down by PO, drawings or other Textron Aviation engineering. The following applies when CSTI029 is not required. Parts that are not Textron Aviation design-controlled shall have the supplier part number applied. Part marking shall be accomplished by permanent ink stamping of the parts when the identification method is not specifically regulated by the drawings, specifications or other documents. For all Textron Aviation design-controlled part numbers, acceptance by the supplier of items to be delivered to Textron Aviation shall be indicated by means of the supplier's final acceptance stamp on all parts. All McCauley Engineering design-controlled part numbers shall be positively identified. This identification shall include McCauley part number, PO number or serial number, date of manufacture and inspection stamp. Products having an insufficient or unsuitable surface to be individually identified will be bundled, if possible, or placed in an identified

container. An identification tag, with all required information, shall be attached to the bundle or the container.

#### 4.5 Raw Materials

Textron Aviation M&P Engineering approval is required for purchases of all aluminum and titanium wrought materials that are outlined in the Textron Aviation Procurement Specification QPLs (Qualified Products Lists). This approval is required for materials to be used for product under Textron Aviation design-control. The QPL controls material size, as well as the source of manufacture.

Note: The definition of wrought material for the purpose of this paragraph does not include material used to produce forgings and castings.

If a supplier wants to request an additional mill be added to a QPL, the request should be forwarded to Textron Aviation M&P Engineering through the supplier's Textron Aviation Supply Chain Management Representative or contact.

#### 4.6 Military/Standard Specification Hardware

Suppliers shall deliver military/standard specification hardware (AN, MS, NAS, etc.) compliant with the latest document revision, unless otherwise specified by Textron Aviation.

#### 4.7 Evaluating Product

##### 4.7.1 Sampling Plans

Sampling plans utilized for Textron Aviation product shall preclude the acceptance of lots with known non-conformities (these plans are also referred to as  $c = 0$  sampling plans).

##### 4.7.2 Test Reports and Certifications for Materials, Parts and Services

Where test reports and certifications are utilized as the basis for accepting materials, parts and services for Textron Aviation product, the supplier shall ensure that the data in those documents are acceptable per applicable Textron Aviation requirements.

#### 4.8 Quality Access

The supplier guarantees the right of access to their facilities and quality related data to Textron Aviation, Textron Aviation customers and regulatory authorities. This right of access is extended to all sub-tier and raw material suppliers.

#### 4.9 Quality Records

The supplier shall establish a system to retain records for a minimum of ten years per the Master Purchase Agreement or CSF2000, Purchase Order Terms and Conditions, as applicable. Suppliers of serialized assemblies under Textron Aviation design-control (i.e.

assemblies with S4053-1 identification placard) shall retain assembly inspection records and delivery records, including all bonded assembly inspection records, for the life of the aircraft.

#### 4.10 First Article Inspection

The supplier shall perform a first article inspection on a part from each first lot shipment of parts to verify all engineering characteristics. Variable gauging shall be used when possible. If a first article was delivered as part of an experimental order, a copy of the first article inspection report shall accompany parts delivered on the first production PO. Suppliers shall comply with AS9102, Aerospace First Article Inspection Requirement, for all first article inspections. The FAIR shall be retained as a quality record at the supplier's facility and a copy shall be submitted to Textron Aviation along with the first lot shipment.

Unless specifically directed by the PO, FAIRs are not required for Textron Aviation parts that are derived from standard catalog hardware (as defined by AS9102), provided that the parts have not been modified. Re-identification of standard catalog hardware to a Textron Aviation part number does not constitute a modification that would require a FAIR.

If applicable, a Textron Aviation source inspector may verify FAIRs at the supplier's facility. The verification of the part conformity will be noted on Textron Aviation's X-159 Source Inspection Form or by direct data entry into Textron Aviation's electronic IP system.

#### 4.11 Nonconforming Material

##### 4.11.1 Textron Aviation Material Review Board (MRB) Disposition

A Textron Aviation MRB disposition is required when material is found to depart from PO requirements and cannot be reworked without affecting fit, form or function. To obtain a Textron Aviation MRB disposition, the supplier shall initiate a Supplier Rejection Disposition Report (SRDR) for articles under Textron Aviation design control. SRDR applications are to be submitted online and can be found at [www.supplier.cessna.com](http://www.supplier.cessna.com). Instructions for the use of the online application are also available at the website.

Upon receipt of a disposition to an SRDR, the supplier shall perform rework/repair in accordance with Textron Aviation's SRDR disposition. The supplier's authorized quality representative must indicate that the rework/repair has been completed in accordance with all requirements by the application of their inspection stamp impression on the SRDR form. Each article shall be identified with the SRDR number provided by the online application. If this identification is impractical due to product size, identification shall be in accordance with Section 4.4. For serialized assemblies, under Textron Aviation design-control (i.e. assemblies with S4053-1 identification placard), the supplier may tabulate the applicable SRDR numbers on a log and include the log in the assembly delivery document package in lieu of stamping the assembly and associated detail parts with the SRDR number. A copy of the log shall be attached to the assembly.

A copy of the completed SRDR form shall be included with the shipment of the product. The applicable SRDR number(s) shall be referenced on the shipping documentation.

#### 4.11.2 Suppliers with Textron Aviation delegated MRB Authority

Suppliers with Textron Aviation delegated MRB authority shall tabulate a log of assembly level nonconformities and detail nonconformities that may affect the next higher level assembly at Textron Aviation. At a minimum, the log shall contain the nonconformity record number, a brief description of the nonconformity (including: part number and location) and an indication of the status of the nonconformity (closed, etc.). A copy of the log shall be included with the shipment of the product. Detail parts with nonconformities dispositioned under Textron Aviation's delegated MRB authority shall be identified with the supplier's nonconformance record number. If this identification is impractical due to product size, identification shall be in accordance with Section 4.4. Assembly level nonconformance record numbers may be identified on the assembly. Nonconformance record numbers may be identified on the assembly. Nonconformities dispositioned through Textron Aviation's SRDR system shall be handled in accordance with Section 4.11.1.

#### 4.11.3 Latent Defect Reporting

In the event a condition is discovered that affects previously delivered product, Textron Aviation shall be notified of the condition in a timely manner. Notification shall be in the form of a letter addressed to the attention of the Textron Aviation Supply Chain Management and Textron Aviation SCQE Departments. Contact information can be found at [www.supplier.cessna.com](http://www.supplier.cessna.com). The letter must include all pertinent information concerning the condition (i.e. part numbers, part name, quantities, serial number range, ship dates for parts in question, time frame, a detailed description of the defect) and the corrective action taken to prevent recurrence.

#### 4.11.4 Multiple Rejections - Single Component

Items returned to the supplier three or more times may not be shipped back to Textron Aviation without SRDR approval from Textron Aviation. Extensive failure investigation and analysis to determine root cause and corrective action will be required prior to approval.

#### 4.12 Purchase Order (PO) Quality Notes

Suppliers shall obtain and comply with the latest released PO Quality Note revisions available at [www.supplier.cessna.com](http://www.supplier.cessna.com).

#### 4.13 Documentation

##### 4.13.1 Delivery Documentation

The supplier shall provide, as applicable, copies of the following original documents with each shipment of product to Textron Aviation.

- a) Certificate of Conformance (C of C) – A statement by the Supplier Quality Representative certifying that shipment complies with all Textron Aviation purchase order requirements.
- b) Identity of actual manufacturer (manufacture of origin) if the end item manufacturer is a company other than themselves
- c) List of part serial numbers, when applicable
- d) Textron Aviation Engineering approved SRDR (see para.4.11)

In addition to the documents above, shipments containing the first article of Textron Aviation designed product, shall include copies of the following original documents as applicable.

- e) First Article Inspection Report (FAIR) – for partial FAIRs, only documentation associated with the cause of the partial FAIR is required

Example: FAIR generated for a change in source of a plating operation - the supplier is required to provide the certification from the new plating source, not a complete set of certifications for all materials and processes.

- f) Hardware certifications
- g) Raw material test reports/certifications – metallic raw material test reports/certifications must be from the approved mill (see para. 4.5)
- h) Special processing certifications (see para. 3.2.1)
- i) For Textron Aviation furnished materials, a copy of the Textron Aviation shipping document

Suppliers of product of their own design are not required to furnish the First Article Inspection Report (FAIR) with shipment of product to Textron Aviation. However, the documents shall be made available to Textron Aviation upon request.

#### 4.13.2 Alternate Delivery Methods

In lieu of supplying hard copies of the documentation listed above with the shipped product, Textron Aviation prefers suppliers to provide them electronically utilizing a secure online repository, Aerospace. Aerospace contact information is available at [www.aerospac.com](http://www.aerospac.com).

Textron Aviation has employed a preferred method of submitting FAIRs. The process utilizes an internet-based first article inspection system facilitated by Net-Inspect. The use of this system is at no cost to the supplier. Requests for Net-Inspect access need to be submitted to Textron Aviation Supplier Quality at [scm\\_qa@txtav.com](mailto:scm_qa@txtav.com).

#### 4.13.3 Other Quality Forms



Suppliers of serialized assemblies under Textron Aviation design-control (i.e. assemblies with S4053-1 identification placard) shall use the following forms as applicable. Forms and form instructions are available at [www.supplier.cessna.com](http://www.supplier.cessna.com).

- Form X-31 – Class “A” Bond Assembly Accountability Log
- Form X-374 – Open Standing Work to Ship Incomplete Work
- Form X-382 – Supplier Open Work Log

#### 4.14 Textron Aviation Granted Authority

##### 4.14.1 Supplier Delegated Inspection Authority (SDIA)

Delegated inspection authority may be granted to suppliers. Suppliers may request SDIA through their Textron Aviation SCQE representative or may be recommended for SDIA by a Textron Aviation commodity team. Textron Aviation SCQE is responsible for the final approval of all SDIA candidates. When the supplier and Textron Aviation mutually agree to work towards SDIA, a timeline for the implementation will be set. If that timeframe is exceeded due to poor quality performance, supplier-funded source inspection may be implemented until the supplier attains SDIA.

##### 4.14.2 Material Review Board (MRB) Authority

Textron Aviation delegated MRB authority is limited to minor deviations and granted on a limited basis to key suppliers. Suppliers may request approval of their MRB through Textron Aviation SCQE. Textron Aviation SCQE will coordinate the MRB authority approval with Textron Aviation Engineering.

Textron Aviation reserves the right to reject any disposition made by the supplier’s MRB.

#### 4.15 Supplier Delegation Programs

Suppliers that delegate verification of product to their suppliers shall maintain an effective delegation process in accordance with AS9015 – Supplier Self Verification Process Delegation Programs. In addition, Textron Aviation suppliers shall ensure that their sub-tier suppliers comply with AS9015 requirements. Copies of AS9015 can be purchased from SAE International at [www.sae.org](http://www.sae.org).

#### 4.16 Variation Management

Suppliers shall conduct effective variation management activities on identified key characteristics and processes for dimensionally managed parts in accordance with AS9103, Aerospace Series – Quality Management Systems - Variation Management of Key Characteristics. Key characteristics may be identified on Textron Aviation engineering drawings and specifications. The supplier shall identify additional key characteristics based on their knowledge of their manufacturing processes. Supplier identified key characteristics shall be communicated to Textron Aviation upon request.

Suppliers shall achieve a minimum CPK 1.33 for all key characteristics. Copies of AS9103 can be purchased from SAE International at [www.sae.org](http://www.sae.org).

#### 4.17 Supplier Control Plans

When applicable, suppliers may be asked to develop part specific control plans to address process issues identified by the supplier or Textron Aviation. The supplier agrees to provide a copy of the control plan to Textron Aviation. The supplier agrees to maintain processes as identified within the control plan and the appropriate revision level. The supplier will not implement changes to the control plan without providing prior notification to Textron Aviation via an updated control plan and revision level. To provide visibility to both Textron Aviation and the supplier, Textron Aviation may identify the supplier's control plan identification and revision level on the OPSS associated with the Textron Aviation purchase order for the part identified. Inclusion of the control plan identification and revision level is solely to provide visibility of the supplier's defined control plan and does not constitute Textron Aviation's approval of the control plan.