



Supplier Delegated Inspection Program

QAI 03-01-125

Supplier Delegated Inspection Program

- **Supplier Delegated inspection program is designed to Qualify the supplier QA system to inspect and accept inspection of HBC parts.**
- **Suppliers identified for this program will be strategically aligned with HBC in a Customer-Supplier relationship.**
- **If a supplier meets the preliminary requirements and is interested in the program, please contact HBC Supply Chain Management.**

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- **General Requirements**

- **Supplier must maintain ISO9001/AS9100 accredited quality system**
- **Successfully pass on-site audit. HBC Semi-Annual on-site audits.**
- **Monthly Quality Data exchange:**
 - **Rejection Trends**
 - **Root Cause and Corrective Actions**
- **Supplier Quarterly Internal Audits:**
 - **Product Audits**
- **Supplier Notification of HBC of Escapes and Out of Tolerances**
 - **Supplier**
 - **Sub-tier suppliers**
- **Configuration Management**
 - **HBC CM Plan**
 - **Supplier CM Plan**
- **Conformity Validation prior to HBC delegation**
 - **WI 04-04-010: Supplier First Article Inspection**



Supplier Delegated Inspection Program

- Available on the web:

Mon. April 12, 2004

Home About Us Aircraft Government Service/ Support Jobs

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

Supply Chain Management

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

Supplier Information

- Contractual Flowdown Specifications
- EDI
 - EDI Guide MRP Forecast Requirements X12 830 Version 4010 Release 1-0
 - EDI Guide Purchase Order Change X12 860 Version 4010 Release 1-0
 - EDI Guide Purchase Order X12 850 Version 4010 Release 1-5
 - EDI Guide Scheduling Agreement Release X12 830 Version 4010 Release 1-0
- Beech Specs
 - BS23431 Electrostatic Discharge Sensitive Device Protection Requirements
 - BS24405 Source Control for Electrostatic Discharge Sensitive (ESDS) Devices Revision D
 - BS25526 Specification for Stress and Embrittlement Relief Requirements for Manufacturing Processes Revision
 - BS25691 Control of Manufacturing Processes For Suppliers and Customers
- Barcode (software)
 - Barcode Software Frequently Asked Questions
 - Raytheon Receiving Bar Code Label Specification Revision B

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QAI 03-01-125: Supplier Delegated Inspection Program

First Article Inspection

QAI 03-01-125: Supplier Delegated Inspection Program

WI 04-04-010: Supplier First Article Inspection

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

- About Us

- Supply Chain Management

- Supplier Information

- Contractual Flow down

- Select "Specifications"



Supplier Delegated Inspection Program

- **Supplier Responsible for 100% FAI**
 - Including Sub-Contracted Work
 - A new conformity must be performed every 24 months

- **HBC to Assure FAI Process**
 - On-Site Review of First Articles
 - 100% Review of Data
 - On-Site Auditing
 - Assure Sub-Contracted Work FAI Process Flow Down
 - Assistance by HBC Commodity Team

Supplier Delegated Inspection Program

- **Product Inspection**

- HBC & supplier agreed upon inspection criteria. (QIP, Quality Inspection Plan)
- Records maintained for 5 years and available to HBC
- Sampling ANSI/ASQC Z1.4-1993, based on C=0
- Sampling shall not permit skip lot or delegated inspection to sub-tier suppliers.

- **Metrics Exchange and Corrective Action**

- HBC will provide the supplier with QN written against the supplier
- Supplier shall have a CA system focused on root cause.
- Supplier submit CA plans to HBC upon request.
- CA statusing during monthly quality metrics exchange

Supplier Delegated Inspection Program

- **Section 5.2 Supplier Quality System Responsibilities**
 - **Contract Review**
 - **Supplier Quarterly product audits of HBC Parts. Findings made available to HBC.**
 - **Supplier conformity process address configuration management elements:**
 - Planning, Document Revision/Control, Purchase Order Validation & Flow down, Inspection Media Validation, Tooling Control, Dimensional Inspection & Testing, Production Inspection Requirements**
 - **Product conformities – WI 04-04-010: Supplier First Article Inspection**
 - **Control of HBC supplied materials**
 - **Supplier control of Sub-tier suppliers (including raw materials and special processes).**
 - **QA personnel qualification and training record.**

Supplier Delegated Inspection Program

- **Section 5.5 RAC Quality System Requirements**
 - **HBC shall provide necessary product definition information**
 - Engineering
 - Condition of Supply / Manufacturing Plan
 - **HBC SQE Semi-Annual On-Site Product Audits**
 - **HBC SQE to assure all supplier responsibility non-conformances are communicated to supplier.**

Supplier Delegated Inspection

Phase Process



Phase I Assessment 10%	Phase II Interface 30%	Phase III Action Plan 60%	Phase IV Performance Metrics 90%	Phase V Approval 100%	Phase VI Sustaining
Review:					
<ul style="list-style-type: none"> - Extensive audit at the supplier with emphasis on processes 	<ul style="list-style-type: none"> - How to work with HBC (20%) - Technical Skills and competencies of inspectors (30%) 	<ul style="list-style-type: none"> - First Article Inspection / Quality Inspection Plan (50%) - Business assessment during work in process (60%) 	<ul style="list-style-type: none"> - QN History(80%) -Supplier Rating System - Delegated supplier (90%) readiness review 	<ul style="list-style-type: none"> - Presentation to FAA 	<p>Frequency & Gradual reduction of audits based on:</p> <ul style="list-style-type: none"> -Complexity of parts -Quantity of parts -Location of Supplier -Performance of Supplier
Acceptance Criteria:					
<ul style="list-style-type: none"> - Audit successfully closed 	<ul style="list-style-type: none"> - Completion of training and delegated inspector identified 	<ul style="list-style-type: none"> - Percentage completed and supplier comfort level - Good assessment 	<p>Metrics analysis and rating meets RAC's requirements</p> <ol style="list-style-type: none"> Supplier Internal Rejections Quality Notification First Article Inspection Variation Request Change Request 	<ul style="list-style-type: none"> -FAA notification for Supplier Delegated Inspection 	<p>The diagram shows a staircase of yellow steps representing decreasing audit frequency over time. From top to bottom, the steps are labeled: Weekly, Bi-Monthly, Monthly, Quarterly, and Semi-Annually. Below these steps is a green box labeled 'Life of Project' with an upward-pointing arrow, indicating that the audit frequency is maintained throughout the project's duration.</p>