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**Pratt & Whitney Rocketdyne West Palm Beach (PWR WPB)  
Supplier Quality Assurance Procedure**

**WARNING**

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■ **APPLIES TO:** *PRATT & Whitney Rocketdyne West Palm Beach (PWR WPB) Suppliers*

**1. PURPOSE AND SCOPE**

- @ This procedure defines the process and requirements required by the supplier's quality organization to release product to PWR WPB..
- @ **Note:** *Unless otherwise specified, this procedure does not remove requirements of the SQA Process Manual, Supplier Quality System Requirements, ASQR-01, or any current requirement governing supplier activities. The intent of this procedure is to clarify unique supplier requirements required to perform work for PWR WPB.*

**2. OWNERSHIP AND APPROVAL**

The Manager, Product & Process Quality, owns this document. All revisions to any quality related document must be approved by the document owner and Program Engineering prior to inclusion.

**3. APPLICABLE DOCUMENTS:**

Applies when specified on the QAD to PWR production (PD) quality assembly and/or detail drawings, and to source control interface drawings identified on PWR drawings. IE: P&WR drawing has source controlled note that 100% inspection to be performed on all features on the suppliers drawing. This applies to the suppliers drawing as provided to P&WR only.

**4. REQUIREMENTS**

- @ PWR WPB requires suppliers to document and maintain detailed quality records for delivered hardware. Supplier's are required to record actual data during the inspection process and provide added assurance by providing additional over inspection of raw material, NDT and special process certificates of conformance, and dimensions which are critical, major, close tolerance, difficult to control, or which use more than 80% of the allowed tolerance.

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**5. ACRONYMS**

FAI	First Article Inspection
MCL	Materials Control Laboratory
M&TE	Measuring & Test Equipment
N/C	Numerical Control
NDT	Non-Destructive Test Specifications
P/N	Part Number
P.O.	Purchase Order
PWR WPB	Pratt & Whitney Rocketdyne West Palm Beach
QAD	Quality Assurance Data
SID	Supplier Information Database
SPECIAL PROCESSES	Includes processes described as; performed by SQL suppliers, Appendix A & B suppliers, or functional tests
SQA	Supplier Quality Assurance
SQAR	Supplier Quality Assurance Representative
SQE	Supplier Quality Engineer (Same as SQAR)
VIS-M	Visual Master
PVC	Process Verification Checklist

**6. SUPPLIER PREPARATION FOR SOURCE INSPECTION**

Aerospace First Article Inspection Requirement, AS9102 Forms 1, 2 & 3 must be used for all First Article Inspection (FAI) and source inspection releases.

**6.1 Documenting the Inspected Features**

6.1.1 The Supplier shall provide actual dimensions (variable data) on the (AS9102-Form 3) whenever a characteristic can be measured and variable data can be obtained.

6.1.2 Whenever possible the supplier should record both the minimum and maximum reading (range) for each feature.

6.1.3 Inspection data must be recorded on the AS9102 Form 3.

6.1.3.1 For production lots, the lot identification and quantity shall be annotated on AS9102 Form 3, or AS9102 Form 1 cover sheet may also be used.



6.1.3.2 For multiple quantity shipments there is only one entry (range) per feature (characteristic listed on the AS9102 Form 3) required – includes the minimum and maximum for the lot of parts or the series of features.

@ **Note:** *Suppliers who demonstrate continuous defect free submittals to PWR WPB source inspection may be allowed (at Supplier Quality Engineer (SQE) discretion) to record actual data for dimensions, which exceed 60% of the allowed tolerance and Pass/Fail identification for dimensions which fall within 60% of the allowed tolerance. SQE approval, in writing. (Critical, major, <.002 inch dimensions N/A.)*

## **7. SUPPLIER SOURCE DOCUMENTATION PACKAGE**

7.1 First Article Inspection / Source Inspection Package Format:  
Supplier will prepare an inspection review package which includes all specified documentation:

Description

1. Supplier packing slip for shipment and PW SDS label when applicable.
2. Purchase Orders (POs) for shipment including all supplements.
3. AS9102 Forms 1, 2 & 3 completed per AS9102, & SR-059, including PVC requirements when specified by PO.
4. All applicable certifications including material, processes, NDTs, process verification checklists, etc.
5. Completed manufacturing operation sheets, router, etc.
6. All applicable Part Assembly & Detail Drawings and QADs.
7. Process Approval Record (P&W [Form 4692](#)) (if applicable).
8. Non-Conformance documentation (if applicable).

7.2 Supplier Special Process Documentation and Reporting

PWR WPB suppliers must submit certifications for all PW special processes and PW specified NDTs, including processes performed internally. All certifications must include the following information and be signed by the responsible representative. (Internal certifications must be signed by the Quality Manager or their designee.)

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Required information:

1. Supplier name and verification that the supplier is approved for the process.
2. Requirement exactly as specified from reference document (i.e., b/p, specification, QAD).
3. MCL/NDT LCS statement or qualified commercial lab test report (if applicable).
4. Signature of quality representative assuring compliance.
5. Approval/Acceptance statement.
6. Traceability identification to product being inspected.

Supplier shall draw a small circle and place the above number in the circle next to the required information response stated. These six items will be re-verified by the SQE during source release.

**8. RECORDS:**

The records identified in this procedure are retained in accordance with Control of Records, [PW-SLP 16.1](#) and the Record Retention Schedule:

SAE AS9102 (Forms 1, 2, & 3).

**\* 9. REFERENCES:**

9.1	<a href="#">ASQR-01</a>	Supplier Quality System Requirements
9.2	AS9102 Form1, 2, 3 (Not Available by Hyperlink)	Aerospace First Article Inspection Requirement
9.3	<a href="#">P&amp;W Form 4692</a>	Process Approval Record
9.4	<a href="#">PW-SLP 16.1</a>	Control of Records
9.5	UTCQR Form 6 (Not Available by Hyperlink)	Reliability/Maintainability/Safety Notification of Potential Quality Escape (NOPQE)

**10. NATURE OF CHANGE:**

Complete re-write to remove obsolete instruction and procedures.

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