

BOMBARDIER

Toronto Site

PROPRIETARY INFORMATION

PPS 10.50

PRODUCTION PROCESS STANDARD

CUT AND FOLD PANEL STRUCTURE FABRICATION

- Issue 2
- This standard supersedes PPS 10.50, Issue 1.
 - Extensive changes and/or deletions have been made at this issue and, therefore, detail changes have not been noted.
 - Direct PPS related questions to christie.chung@aero.bombardier.com or (416) 375-7641.
 - This PPS is effective as of the distribution date.

Prepared By: _____ (Christie Chung) _____ June 4, 2014

PPS Group

Approved By: _____ (L.K. John) _____ June 4, 2014

Materials Technology

_____ (A. Gordon) _____ June 9, 2014

Quality

The information, technical data and designs disclosed in this document (the "information") are either the exclusive property of Bombardier Inc. or are subject to the proprietary rights of others. The information is not to be used for design or manufacture or disclosed to others without the express prior written consent of Bombardier Inc. The holder of this document, by its retention and use, agrees to hold the information in confidence. These restrictions do not apply to persons having proprietary rights in the information, to the extent of those rights.

Signed original on file. Validation of paper prints is the responsibility of the user.

TABLE OF CONTENTS

Sections	Page
1 SCOPE	3
2 REFERENCES	3
3 FACILITIES	3
4 SAFETY PRECAUTIONS	4
5 PERSONNEL REQUIREMENTS.....	4

1 SCOPE

- 1.1 This Production Process Standard (PPS) authorizes the use of Heath Tecna Inc. Process Specification HPS-10003, Revision C, for cut and fold panel and structure fabrication when use of PPS 10.50 is specified. This standard also authorizes the use of Heath Tecna Inc. Process Specification HPS-10002, Revision M, ADCN 1, in so far as it is referenced in HPS-10003.
- 1.1.1 This PPS complements the engineering drawings that specify its use as an authorized instruction. The procedure specified in this PPS shall be followed to ensure compliance with all applicable specifications. In general, if this PPS conflicts with the engineering drawing, follow the engineering drawing. The requirements specified in this PPS are necessary to fulfil the engineering design and reliability objectives.
- 1.1.2 Refer to [PPS 13.26](#) for the subcontractor provisions applicable to this PPS.
- 1.1.3 Procedure or requirements specified in a Bombardier BAPS, MPS, LES or P. Spec. do not supersede the procedure or requirements specified in this PPS. Similarly, the procedure and requirements specified in this PPS are not applicable when use of a BAPS, MPS, LES or P. Spec. is specified.

2 REFERENCES

- 2.1 [PPS 13.26](#) - General Subcontractor Provisions.
- 2.2 [PPS 13.39](#) - Bombardier Toronto Engineering Process Manual.

3 FACILITIES

- 3.1 This PPS has been identified as a "Critical or Special" process according to [PPS 13.39](#) and as such only facilities specifically approved according to [PPS 13.39](#) are authorized to perform cut and fold panel and structure fabrication according to this PPS.
- 3.2 Bombardier subcontractors shall direct requests for approval to Bombardier Supplier Quality Management. Bombardier facilities shall direct requests for approval to the appropriate internal Quality Manager.

- 3.3 Facility approval shall be based on a facility report, a facility survey and completion of a qualification test program, if required. The facility report shall detail the materials and equipment to be used, the process sequence to be followed and the laboratory facilities used to show compliance with the requirements of this PPS. Any deviation from the procedure or requirements of this PPS shall be detailed in the facility report. Based upon the facility report, Bombardier Toronto Engineering may identify additional qualification and/or process control test requirements. During the facility survey, the facility requesting qualification shall be prepared to demonstrate their capability. Once approved, no changes to subcontractor facilities may be made without prior written approval from Bombardier Aerospace Supplier Quality Management.
- 3.3.1 For approval of subcontractor facilities to perform cut and fold panel and structure fabrication according to this PPS, completion of a test program and submission of suitable test samples representative of production parts is required.

4 SAFETY PRECAUTIONS

- 4.1 *Safety precautions applicable to the materials and procedures specified herein shall be defined by the subcontractor performing the work for Bombardier Toronto.*

5 PERSONNEL REQUIREMENTS

- 5.1 This PPS has been categorized as a "Critical or Special Process" according to [PPS 13.39](#). Refer to [PPS 13.39](#) for personnel requirements.