

# BOMBARDIER

Toronto (de Havilland)

**PROPRIETARY INFORMATION**

# PPS 20.10

## PRODUCTION PROCESS STANDARD

### Radiographic Inspection

- Issue 1
- This is a new standard.
  - Direct PPS 20.10 related questions to [michael.wright@aero.bombardier.com](mailto:michael.wright@aero.bombardier.com).
  - This PPS is effective as of the distribution date.

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Production Process Standards (PPS)		
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Quality		

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## 1 Scope

- 1.1 This Production Process Standard (PPS) authorizes the use of BAPS 176-017 for radiographic inspection wherever radiographic inspection according to PPS 20.10 is specified.
  - 1.1.1 This PPS complements the engineering drawings that specify its use as an authorized instruction and the procedure specified must 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.

## 2 Hazardous Materials

- 2.1 Before receipt at Bombardier Toronto (de Havilland), all materials must be approved and assigned Material Safety Data Sheet (MSDS) numbers by the Bombardier Toronto (de Havilland) Environment, Health and Safety Department. Refer to the manufacturer's MSDS for specific safety data on any of the materials specified in this PPS. If the MSDS is not available, contact the Bombardier Toronto (de Havilland) Environment, Health and Safety Department.

## 3 References

- 3.1 [PPS 13.26](#) - General Subcontractor Provisions.
- 3.2 [PPS 13.39](#) - Bombardier Toronto Engineering Process Manual.
- 3.3 BAPS 176-017 - Radiographic Inspection.

## 4 Materials, Equipment and Facilities

### 4.1 Materials

- 4.1.1 As specified in BAPS 176-017.

### 4.2 Equipment

- 4.2.1 As specified in BAPS 176-017.

### 4.3 Facilities

- 4.3.1 As specified in BAPS 176-017.

- 4.3.2 Only facilities approved to process parts in accordance with BAPS 176-017 are considered approved to process part in accordance with this PPS.

## **5 Procedure**

- 5.1 Follow the procedure specified in BAPS 176-017. For the purposes of this PPS consider all welds as fracture critical zones requiring a minimum radiographic quality level of 1.

## **6 Requirements**

- 6.1 Refer to BAPS 176-017 for requirements. For the purposes of this PPS consider all welds as fracture critical zones requiring a minimum radiographic quality level of 1.

## **7 Safety Precautions**

- 7.1 The safety precautions specified herein are specific to Bombardier Toronto to meet Canadian Federal and Provincial government environmental, health and safety regulations. It is recommended that other facilities consider these safety precautions; however, suppliers, subcontractors and partners are responsible for ensuring that their own environmental, health and safety precautions satisfy the appropriate local government regulations.**
- 7.2 Observe general shop safety precautions when performing the procedure specified herein.**
- 7.3 As specified in BAPS 176-017.**

## **8 Personnel Requirements**

- 8.1 As specified in BAPS 176-017.