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<b>DOC. No : QD S000N0816E01</b>		<b>Issue</b> <b>C</b>	<b>WBS. No : 40000</b>		<u>Distribution list</u>  NHI GM/DGM FC T, TE OPS QA  AG QA  EC QA  ECD QA  FK QA					
<b>TITLE : Supplier Production Investment Review</b>										
<b>Summary :</b>  In the frame of the Production Investment phase of the NH90 Programme, this procedure describes the NH90 requirements in Production Investment review organisation for supplied item. The target of the Production Investment Review is to confirm that all tooling, methods, processes, Inspection and Manufacturing Files are available and accepted before starting the first item manufacturing.										
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<table border="1"> <tr> <td>AG</td> <td>EC</td> <td>ECD</td> <td>FK</td> <td>NHI</td> </tr> </table>						AG	EC	ECD	FK	NHI
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<b>SDRC/LF</b> Prepared by (name) : Signature : Date :  Approved by ( ) : Signature : Date :					<b>JEPPSON</b>  					
<u>Delegated authority(ies)</u> Authorized by : Signature : Date :		<b>PALIAGA</b> <b>QAT 05/01</b> <b>2/3/05</b>  <b>AG</b>	<b>MARTIN</b> <b>QAT 05/01</b> <b>2/3/05</b>  <b>EC</b>	<b>BRAUNER</b> <b>QAT 05/01</b> <b>2/3/05</b>  <b>ECD</b>	<b>MOORE</b> <b>QAT 05/01</b> <b>2/3/05</b>  <b>FK</b>					
					<b>JEPPSON</b>    <b>2/3/05</b> <b>NHI</b>					



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Issue	Issue date	Affected pages	CHANGE REASONS / ORIGINATORS CHANGE PROPOSAL / N°	Companies / Departments	Signatures
A	11/07/00	ALL	FIRST ISSUE	NHI	GUIGNARD
B	14/09/00	3 to 7	Improvements	NHI	GUIGNARD
C	2/3/2005	See borders	Improvements QAT05/01	NHI	JEPPSON

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## 1 INTRODUCTION

In the frame of the Production Investment phase of the NH90 Programme, this procedure describes the NH90 requirements in Production Investment review organisation for supplied item.

The target of the Production Investment Review is to confirm that all tooling, methods, processes, Inspection and Manufacturing Files are available and accepted before starting the first item manufacturing.

## 2 SCOPE

The Production Investment Review shall be performed in accordance with this procedure and with respect to the clauses specified in the Contract between the Buyer and the Supplier.

## 3 REFERENCE DOCUMENT

- Statement of Work (SOW) for an "item" (model) for PI & P phases: SOW S000A0703E01

## 4 PREREQUISITE FOR PRODUCTION INVESTMENT REVIEW

The Production Investment Review cannot be launched before:

- The release of the series drawings,
  - The release of Production concept and the Manufacturing route,
- has been successfully done and if the Declaration of Design and Performance (DDP) is available and approved by the Buyer.

Except otherwise agreed:

- Specific reviews on these above mentioned subjects shall be performed,
- A review on the satisfactory status on the tools and associated means shall be performed.

## 5 PRODUCTION INVESTMENT REVIEW

The Production Investment Review shall include:

- Configuration identification of the item, and, if applicable, evolutions between qualified and serial definitions,
- Presentation of the production concept, Manufacturing route and the Manufacturing/Inspection Files and the chosen industrial organisation,
- Status of the manufacturing tools and associated means, manufacturing and inspection sheets, with associated documentation,
- Status of Special processes,
- Identification of the industrial risks.

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## 6 REQUIREMENTS FOR PRODUCTION INVESTMENT REVIEW ORGANISATION

### 6.1 General Review process

The general Review process is described in the document Statement of Work (SOW) for “item” (model) for PI & P phases : SOW S000A0703E01

### 6.2 Specific Production Investment Review process requirements

#### 6.2.1 Preliminary Production Investment Review

Before the effective launching of manufacturing of the tools, the Supplier shall perform a Preliminary Production Investment Review.

The Supplier shall inform in writing the Buyer of the date and the agenda of the Preliminary Production Investment Review, at least one month before the date of the Review.

During this Review the Supplier shall present to the Buyer, the following data:

- the list of the specific tools,
- the list of the special processes (if any),
- the specifications/drawings of the tools which have been requested by the Buyer,
- the relevant acceptance tests for the tools,
- the concept for Equipment Tests Specifications (ETS) and the Acceptance Test Procedure (ATP),

Minutes of Review shall be established by the Supplier in real time during the session.

The successful completion of the Production Investment Review may be required for the continuation of the Production Investment process.

#### 6.2.2 Review notification

The Supplier shall inform in writing the Buyer sufficiently in advance of the date and the agenda of the Production Investment Review, at least one month before the date of the Review.

This notification shall be accompanied by the list of documents to be analysed during the Production Investment Review.

The Buyer shall confirm in writing his participation (and the eventually Customer/Purchaser-NHI Industries representatives participation) at least two weeks before the planned date.

#### 6.2.3 Documentation to be provided

The necessary documents for the Production Investment Review shall be made available for the Buyer at least one month before the foreseen date.

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Unless otherwise specified in the contract or the purchase order, the following documents are required:

- Declaration of Design and Performance (DDP),
  - Equipment Test Specification (ATS) and Acceptance Test Procedure (ATP),
  - Simplified Definition File identifying the adopted configuration,
  - Quality Assurance Plan,
  - Configuration Management Plan,
  - Risk Management Plan,
  - Production Plan including:
    - Production concept allowing identification of the technical solutions, methods and adopted processes for the production as well as the industrial organisation,
    - Manufacturing route, Inspection and Test Plan,
    - Production schedule (including Reviews and First Article Inspection).
  - Critical parts list and Critical part file,
  - The list of the Manufacturing/Inspections Files with the designation of the specific tools/means,
  - Special processes list and the validation status,
  - Specific tooling/test means list,
  - Delivery Data Package (model),
  - Conditioning and storage sheets,
- Level of detail will be compatible with contractual clauses for Intellectual property of Supplier

#### 6.2.4 Place and language

Unless otherwise specified in the Contract, the Production Investment Review shall be held at Supplier premises.

Unless previous agreement between the Buyer and the Supplier, the English language shall be used.

#### 6.2.5 Participants

The Buyer shall provide the Supplier, at the latest one week before the foreseen date, with the list of participants to the Production Investment Review.

Buyer representatives will participate to each Production Investment Review.

The participation of the Customer/Purchaser representative to the Production Investment Review should be subject to specific arrangement by the supplier's subject to Governmental Quality Assurance activity

The Customer/Purchaser may participate, as listener, to Production Investment Reviews.

#### 6.2.6 Minutes of the Production Investment Review

Minutes of Review shall be established by the Supplier in real time during the session.

#### 6.2.7 Action Sheets

When to a problem raised during the Production Investment Review, the answer is not deemed sufficient, an Action Sheet shall be established in order to well identify the concern and to follow the progress of the answer until the solving.

The required actions shall be accompanied with completion deadline.

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After completion of all mandatory actions, the Buyer will formally inform the Supplier of the completion of Production Investment Review.

## **7 PRODUCTION INVESTMENT REVIEW PROGRESS**

The Production Investment Review shall start with:

- The presentation of the contractual status,
- The status of the delivered documentation.

The following activities shall be addressed during the Production Investment Review:

- Definition,
- Quality Assurance Plan,
- Production Plan,
- Production schedule,
- Critical parts and special processes,
- Delivery and storage conditions,
- Configuration Management Plan,
- Acceptance process,
- Industrial risks,
- Minutes, Action Sheets,
- Conclusion.

## **8 PRODUCTION INVESTMENT REVIEW VALIDATION**

The final validation of the Supplier Production Investment Review will be declared after the acceptance by Quality department of the First Article Inspection Report.