

**TABLE OF CONTENTS**

1	PURPOSE.....	1
2	DEFINITION.....	1
3	AUDIT OF SPECIAL PROCESSES....	2
4	UX REQUIREMENT.....	2

**1 PURPOSE**

The purpose of this document is to define the Critical Part requirements to Suppliers.

**2 DEFINITION AND MARKING**

A Critical Part is a component or assembly that has been determined to have a direct, significant impact on product performance, service disruption, and cost in the event of a defect.

A 'Critical Part' will be recognized by the reference to this same Purchase specification 84A234308 on GE Transportation's Drawings / Purchase Specifications.

Purchase Specifications: The following statement shall be in the purchase specification directly prior to the Part Number list as shown in the example below:

Example:

***Suppliers shall refer to 84A234308 for additional requirements.***

P.N.	Description
P5	(description -----)

Drawings:

Critical Part Drawings shall contain the following statement in the Notes section of the drawing:

***Additional Supplier requirements documented in 84A234308***

**3 AUDIT OF SPECIAL PROCESSES**

Suppliers of Critical Parts that utilize Special Processes (as defined below) are to pass a special process audit subject to GET Supplier Quality review and approval, that is performed by GET Supplier Quality, or a third party (Such as a TPG or NADCAP registrar or equivalent), or performed using the AIAG Special Process System Assessments

TPG is the Transportation and Power Generation accreditation and NADCAP is the National Aerospace and Defense Contractors Accreditation Program.

The special process audit is required for suppliers that utilize a special process during the manufacture of a Critical Part if at least one of the following conditions is met:

Author: Patrick Muller	Approval: Ram Misra, John Butler		84A234308  Sheet 1 of 3
Revised: GE Trans. Engineering 06/23/2015	BUS. AREA:	DIST:	

This Drawing is the Property of GENERAL ELECTRIC COMPANY, TRANSPORTATION SYSTEMS DIVISION. This drawing is loaned upon the express condition that it shall not be reproduced in any manner, and shall be returned upon demand. It is submitted for evaluation purposes and it, and the information contained therein, shall not be otherwise used nor disclosed to third parties without written permission of General Electric Co.

Supplier Status	Special Process Audit required if
Existing Supplier	DPMO > 500 on Part for rolling 12 month period for the Part (or Part family if no Part history) or SAP cases, or Field Failures for Special Process failure in the past 18 months
Engineered Systems Supplier	Not mandatory. Supplier Quality may perform Special Process audits to verify special process control.
New Supplier	required, except Engineered Systems
All	Supplier Quality can require TPG Special Process audit based on DPMO, SAP, or Field Failure history

a.

Example Special Processes are as follows:

- Heat Treat
- Wiring
- Printed Circuit Board
- Pickling
- Welding
- Castings
- Forgings
- Non Destructive Testing
  - o Penetrant Inspection
  - o X-ray/Radiographic Inspection
  - o Magnetic Particle Inspection
  - o Ultrasonic
- Shot Peen
- Brazing
- Soldering

#### 4 UX REQUIREMENT

Suppliers of UX Critical Parts are subject to the same requirements for Critical Parts as detailed above in Section 3.

Author: Patrick Muller	Approval: Ram Misra, John Butler		84A234308  Sheet 2 of 3
Revised: GE Trans. Engineering 06/23/2015	BUS. AREA:	DIST:	

This Drawing is the Property of GENERAL ELECTRIC COMPANY, TRANSPORTATION SYSTEMS DIVISION. This drawing is loaned upon the express condition that it shall not be reproduced in any manner, and shall be returned upon demand. It is submitted for evaluation purposes and it, and the information contained therein, shall not be otherwise used nor disclosed to third parties without written permission of General Electric Co.

**REVISION HISTORY:**

The following table lists revisions made to this document:

Revision	Description	Date	Author
0	Initial Release	04/17/2013	Patrick Muller
A	Removed requirement for ongoing control (supplier first pass yield) and updated Critical Part Marking section and Critical Part Definition	06/03/2014	Patrick Muller/ S. Lymangrover
B	Updated to define Special Processes and clarify special process audit conditions	07/29/2014	S. Lymangrover
C	Removal of Third-Party Audit Conditions. Added UX requirement.	06/23/2015	S. Lymangrover
D	Added audit conditions, removed annual audit requirement	05/31/2017	R. Misra, J. Butler

Author: Patrick Muller	Approval: Ram Misra, John Butler		84A234308  Sheet 3 of 3
Revised: GE Trans. Engineering 06/23/2015	BUS. AREA:	DIST:	

This Drawing is the Property of GENERAL ELECTRIC COMPANY, TRANSPORTATION SYSTEMS DIVISION. This drawing is loaned upon the express condition that it shall not be reproduced in any manner, and shall be returned upon demand. It is submitted for evaluation purposes and it, and the information contained therein, shall not be otherwise used nor disclosed to third parties without written permission of General Electric Co.