



## QUALITY CODES

- Q001 The Purchaser may, upon request and during regular business hours, conduct a survey of the Seller's Facility to evaluate its ability to comply with Purchase order requirements.
- Q002 The Seller shall have and maintain a quality assurance program as identified below. The program shall be subject to the Purchaser's audit and approval. Revision levels shall be to the latest revision level applicable at the time of purchase order issuance.
- A. AS9100 Aerospace Basic Quality Assurance System Standard
  - B. MIL-Q-9858
  - C. MIL-I-45208/Part 21
  - D. AITF 16949
  - E. ISO9001 Quality Systems-Model for Quality Assurance in Design/ Development Production, Installation and Servicing
  - F. ISO/ IEC 17025
  - G. QE-STD-1 (CSI)
  - H. FAR Par 21
  - I. Distributor System Minimum Requirement for Control of Quality
    - a. Receiving Inspection
    - b. Material Traceability
    - c. Storage Control
    - d. Quality Documentation
    - e. Non-Confirming Material Control
    - f. Packaging and Shipping Control
- Q003 All of the Seller's gaging, measuring, and testing equipment used in the manufacture or acceptance of items on this purchase order shall be calibrated against standards traceable to the National Institute of Standards and Technology or International Standards.
- Q004 All materials supplied must meet the current revision of the applicable specification and FAR/ DFARS clause 252.225.7036 when requested.
- Q005 Seller's material review board authority is not authorized in this purchase order. Any nonconformity to the purchase order, drawing, specification, or other applicable documents must be submitted to the Purchaser, through the Purchaser's Purchasing Department, for the Purchaser's MRB approval prior to shipment. The request must identify the root cause of the nonconformance and describe the implemented corrective action taken by the Seller.
- Q006 Nonconforming material rejected by the Purchaser and returned to the Seller shall be subjected to the quality requirements of the original purchase order. The units shall be retested or re-inspected as required by the purchase order specifications. New quality documentation, reflecting the retest and/or re-inspection results shall be generated and included with the returned material(s).



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- Q007 Failure of the Seller to deliver documentation required by the purchase order to support each shipment shall be cause for the rejection and return of the shipment to the Seller.
- Q008 The items supplied on this purchase order shall be subject to sampling to an approved statistical sampling plan upon receipt. Should the sample fail to pass the sampling criteria, the lot shall be rejected, or may as conditions dictate, be subject to subsequent Purchaser's re-inspection, re-sampling, or 100% lot sorting at the Purchaser's facility. The costs associated with such re-inspection, re-sampling and/or lot sorting may, at the Purchaser's option, be charged to the Seller. Any such charges shall be subject to the Purchaser's review with the Seller.
- Q009 The Seller shall submit with each shipment for each melt, heat, lot, or batch, evidence attesting compliance to the chemical and/or mechanical property requirements of the applicable drawing, specification and purchase order. Evidence of compliance shall be transmitted in the following forms:
- A. Chemical composition by an actual composition analysis test report
  - B. Mechanical properties by an actual test results report
- Q010 The Seller shall submit with each shipment of parts or material a Certificate of Conformance (CoC) attesting that the item's shipped are in compliance with all purchase order and applicable specification requirements. The CoC shall also state that all inspection and/or test results documenting the item's compliance the purchase order are available for examination by the Purchaser upon request. The CoC shall be signed by the Seller's authorized representative. Direct reference to the Purchaser's purchase order number, item part number, item revision level, and the quantity shipped must be made. The CoC described herein requires a "stand alone" document. The typical certification statements that appear in packing lists or invoices are not sufficient and will not be accepted to satisfy this requirement.
- Q011 A sample (1 piece unless otherwise specified) taken at random from the first production run after acceptance by the Seller's inspection department must be submitted to the Purchaser. Data for all characteristics, including actual recorded readings for measurable characteristics, must accompany this sample. **The first article data shall be included with the first shipment in a separate envelope identified as "First Article Data" and included in box #1 of the shipment.** The presentation of this data may be:
- A. At the Seller's plant under surveillance of the Purchaser's Quality Assurance Representative. The seller shall notify the Purchaser at least five (5) working days in advance of presenting the sample and production lot.
  - B. By the Purchaser, at the Purchaser's plant, upon receipt of the sample, production lot, and seller's inspection data.
  - C. By the Seller at the Seller's plant with the results reported to the Purchaser with the shipment of the sample, the production lot, and the Seller's inspection data.



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- Q012 When delivered items are found to be nonconforming by the Purchaser, a Corrective Action Request (CAR) may be sent to the Seller. The completion and return of the CAR must be within the time allotted on the request form. Abnormal delays in the Seller's response to the CAR will affect the Seller's quality performance rating. The Seller's corrective action must be effective and permanent in elimination of the root cause. The Seller's response must document the following:
- A. Root cause(s) of the nonconformance(s)
  - B. Failure analysis, when required by the CAR
  - C. Corrective action(s) implemented by the Seller
  - D. Effectively by date, or serial/lot number
  - E. Effect of the failure on previously shipped items

Such statements as “cautioned operator,” “changed tool,” and/or “modified operation” are not acceptable. The completed CAR shall be submitted by Seller to the Purchaser, through the procurement organization, for the Purchaser’s Quality Assurance review and concurrence.

- Q013 The Seller shall advise the Purchaser, in writing, prior to incorporating any design, material or process changes on items specified on this purchase order. This notification must be transmitted to the Purchaser, through the Purchaser's procurement organization, and the changes cannot be incorporated without written approval from the Purchaser. This notification in no way relieves the seller from meeting the requirements of the drawings and specifications applicable by the purchase order.

- Q014 General Electric Aircraft Engines specification S-1000 (to current revision level) applies to this purchase order.

- Q015 Purchaser's approval of pre-production sample(s) is required **prior** to initiating production. The Seller shall prepare pre-production samples in accordance with the quantities defined by the purchase order for submission to, and approval by, the Purchaser prior to the first production run. The samples must be representative of the intended manufacturing procedures, processes, and equipment to be utilized during production. The Seller shall submit inspection data (including the actual recorded readings of measurable characteristics), which indicates evidence that the sample(s) chosen is in compliance to all requirements, along with the sample(s). The purchaser's procurement organization shall advise the seller of the disposition of the sample(s) and the subsequent release to proceed with production. No process changes may be made after the approval of the pre-production sample without first notifying the Purchaser so that the need for additional samples may be mutually determined. The necessary inspections shall be accomplished as follows:
- A. At the Seller’s plant under the surveillance of the Purchaser’s Quality Assurance Representative. The Seller shall notify the Purchaser at least five (5) working days in advance of presenting the sample and production lot.
  - B. By the Purchaser, at the Purchaser’s plant, upon receipt of the sample, production lot, and the Seller’s inspection data.
  - C. By the Seller, at the Seller’s plant, with the results reported to the Purchaser with the shipment of the sample, the production lot, and the Seller’s inspection data.



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- Q016 Material Safety Data Sheets must accompany or precede shipment of material.
- Q017 Material furnished under this purchase order is subject to Government acceptance at the Purchaser's plant.
- Q018 "SCRAP DISPOSAL: Parts scrapped at your facility are required to be mutilated beyond use prior to disposal.
- Q019 Certifications, inspection and testing documentation shall be maintained for a minimum of seven (7) years, unless noted otherwise by purchase order requirements.
- Q020 Prior to shipment, source inspection shall be performed by the Purchaser at the Seller's facility. The Seller shall notify the Purchaser at least three (3) working days in advance of the intent to ship and withhold each shipment pending the necessary actions of the Purchaser's Quality Representative. The Seller shall provide all the necessary inspection/test data, facilities, equipment and personnel required by the Purchaser's Quality Representative. Final acceptance of the product will be either at the Purchaser's facility or a site designated by the Purchaser. All inspection and/or test results documentation shall be retained by the supplier and made available for examination by the Purchaser upon request. This includes all supporting subcontractor documentation.
- Q021 The Purchaser's customer and/or government regulatory agencies shall have, upon notification, access to the Seller's facility to determine and verify the quality of product and adequacy of Quality Assurance Systems at all production stages of items intended for incorporation with the Purchaser's products. Such auditing shall, in all case, be coordinated by the Purchaser's procurement group.
- Q022 The Seller **shall not** submit with each shipment of parts or material a Certificate of Conformance (CoC) attesting that the item's shipped are in compliance with all purchase order and applicable specification requirements. All inspection and/or test results documenting the item's compliance to the purchase order **shall be** available for examination by the Purchaser upon request. A Certificate of Conformance in accordance with Q010 shall be available to the Purchaser upon request.
- Q023 The Seller shall adhere to the following inspection criteria for Mechanical / Physical Properties. First Piece Inspection, A systematic process of Interim Production Tracking and a final inspection process following AQL level 4.0, which shall include the last piece produced in the current production run.