

QUALITY CONTROL PROCUREMENT REQUIREMENTS (QCPRs)

Scope:

This requirements document establishes requirements for Suppliers who contribute products and/or services to Applied Aerospace Structures Corp. (AASC). These requirements pertain to the tasks necessary to substantiate product conformance to drawings, specifications, contract and Purchase Order requirements. These requirements are in addition to those tasks set forth in any other contractual document.

Applicability

This requirements document shall apply to all supplies and services when added to a Purchase Order and any related detail requirements contained in any other portion of the contract or Purchase Order.

In the event that the Supplier is required to outsource services in order to fulfill the requirements of the Purchase Order, all requirements that are pertinent and binding with regard to the Purchase Order, including copies of the latest revision process specifications, shall be flowed down and imposed in full upon the Sub-tier Supplier.

Finally, as required, only those Sub-tier Suppliers of materials and/or processes, who reside on AASC's customers approved supplier list shall be used to perform on the contract.

The Supplier is responsible for furnishing the articles which meet all requirements of the contract or the Purchase Order. Should any inconsistency occur between this specification and any other contractual document, the Supplier shall be responsible to bring to the attention of the AASC purchasing department for resolution.

Quality System

Supplier shall maintain a quality system compliant to ISO 9001 (latest Revision), AS9100 (Latest Revision), MIL-I-45208 or equivalent industry-recognized quality system or standard acceptable to AASC. Supplier's Quality System shall be approved by AASC Quality Assurance through either an On-site Supplier Quality Audit or Supplier Quality Questionnaire Desk Audit.

Prohibited Practices

Unauthorized Repairs: Without AASC Quality's written approval, Supplier may not repair by any means, parts damaged or found to be faulty during fabrication/processing. Report all discrepancies found.

Notification of Facility Change: Supplier shall not re-locate any production, manufacturing and/or processing facility during the performance of this Purchase Order, without promptly notifying AASC Buyer, and affording AASC opportunity to examine such facilities for compliance with Quality Assurance requirements.

Process Changes: The Supplier is responsible for notifying AASC and receiving written approval for any process change including equipment, tooling, material, etc., prior to the start of production.

Right of Entry

Supplier shall afford AASC and/or AASC's Customer Representatives the right to enter the Supplier's premises and

verify that contracted product conforms to specified requirements. The Government has the right to inspect any or all of the work included in the Purchase Order at the Supplier's facility.

Documentation

The Supplier shall maintain objective evidence of conformance to all requirements on file for a minimum of ten (10) years or as specified by the Purchase Order.

Safety

The Supplier shall offer their products and services in an environment that is attentive to safety for both property and personnel.

Ethics

The Supplier shall conduct their business practices in an ethical manner and shall translate such practices to their sub-tier supply base. Ethics shall be defined as financial practices and paperwork accuracy.

Nonconforming Product

When a nonconformance is discovered during manufacture and/or prior to shipment to AASC, the Supplier is required to disclose a description and the extent of the nonconformance to AASC and await further instructions. Failure to notify will classify the shipped product as a reject, and will count against the Suppliers Quality Rating.

Banned Suppliers List

Due to GIDEP Alerts or other Industry Notifications, the following Suppliers SHALL NOT be used for any type of procurement activity related to AASC Purchase Orders.

Supplier Name	CAGE Code
California Aircraft & Avionics Corp.	7RNE9
United Technologies Company LLC	9AD50
Western Titanium	04YK8
Bristol Metals/Alloys	24701
A.D. Michel Company	Unavailable
Acme Heat Treatment, Inc.	Unavailable
American Metal Supply, Inc. (AMS)	3E3S7 4UZL1
Hong Dark Electronic LTD	Unavailable
A and P Alloys	0JGL2
ITT Cannon, LLC	71468
Hypertronics	50541
Winchester Electronics	91836
Amphenol	77820
SAPA Extrusions	4FSP6
Bralco Metals (Garland, TX)	6D677
National Aluminum & Alloy Inc.	6CEZ4

Corrective Action Requests

When a quality problem is encountered with item(s) from Supplier, AASC may request a written Corrective Action Request response from the Supplier. Such requests require a timely response (30 days). Replies or request for extension of due dates

shall be directed to the AASC Buyer.

In the event that a Supplier receives a Corrective Action Request from the Government (DCMA), the Supplier is to notify the AASC buyer within 72 hours and provide a copy of the CAR and written notification on company letterhead.

FOD / Contamination Control

The Supplier shall utilize processes, which control contamination and sustain a manufacturing / product environment free of Foreign Object Debris (FOD).

QCPR-1 - Supplier Certificates of Conformance

In addition to meeting the general Scope requirements, the supplier shall furnish a legible Certificate of Conformance (CofC) with a statement attesting that the product complies with drawings and/or specifications imposed by the Purchase Order or contract. The CofC shall state that substantiating evidence is on file and available on request.

In addition, the CofC must specify the following:

- Part Number
- Serial Number (if applicable)
- Revision of specification on Purchase Order (to include all Engineering Changes)
Note: if the specification revision of available raw stock is different from that stated on the P.O., it is the responsibility of the Supplier to notify AASC and obtain the required approval prior to shipment.
- The latest revisions of material or process specifications are required unless specific revision is stated on purchase order.
- Quantity
- AASC Purchase Order number and Line Item.
- The Reports / CofC shall include the name, title and signature of the Supplier's Authorized Quality Representative.
- **Counterfeit Parts** - Distributors or brokers that supply non-electrical standard parts, such as fasteners, nuts, washers, springs, O-rings, inserts, and pins, must have a certification from the Original Component Manufacturer (OCM) / Original Equipment Manufacturer (OEM), and that certification shall be delivered with each lot/ shipment. Parts shall not be used or reclaimed and misrepresented as new.
- **Chain of Custody** - The Supplier shall maintain and provide evidence of Test authenticity (chain of custody) back to the OCM/OEM. The Certification shall clearly identify the name and location of all of the supply chain intermediaries from the original manufacturer to the final source of the product delivered to AASC.

The CofC shall be attached to the Packing Slip, and shall accompany each shipment. Articles will not be accepted in AASC's system, and Payment cannot be provided to Supplier, unless a CofC is provided.

QCPR-2 - Source Inspection: Onsite

The items specified on the face of the Purchase Order require inspection by AASC Quality Assurance and/or Government representative(s) prior to packaging and shipment from the fabricating facility. Notification of the materials impending completion and availability for source inspection will be made not less than seventy-two (72) hours in advance to the AASC buyer.

The selection of material for source inspection may be random sampling by the AASC representative or 100% of the lot, at the representative's discretion. The supplier shall provide all necessary facilities, equipment, documentation and personnel required to perform this inspection at no additional cost to AASC. Records of processing, process control, conformance verification, and other evidence of quality system operation may be required.

Objective evidence of AASC or government source inspection must accompany each shipment of material. When the requirements of QCPR-2 are waived, it shall be at AASC's discretion and written authorization of such waiver must accompany each shipment. Acceptance of material shall be accomplished at AASC's facility unless otherwise specified in writing. Evidence of inspection at the supplier's facility does not constitute acceptance, and transfer of ownership of the material shall be as specified by the Purchase Order.

QCPR-2A - Source Inspection: Desktop

The items specified on the face of the Purchase Order require objective evidence to demonstrate full compliance with the purchasing requirements. This may include, but not be limited to a complete certification package, photographs, dimensional inspection reports, and any other supporting documentation that applies. The selection of materials shall be done by random sampling at the Suppliers facility.

Objective evidence shall be submitted via email directly to the Buyer. Approval of data shall be communicated with a C of C, which has been signed off by Program Quality Engineering. This C of C will be submitted to the Supplier via email by the Buyer as authorization to proceed with the shipment of the material. A copy of this approval C of C is required to accompany the paperwork included with the material shipment.

QCPR-3 - Special Processes or Processing:

Special processes or processing, which may include, but not limited to welding, brazing, heat treating, metal forming, surface preparation, film or plating applications, and non-destructive testing, will require performance to the specification(s) and/or Purchase Order requirements as called out in the detailed description. As applicable, approval shall be required prior to any changes to processing equipment prior to completion of Purchase Order.

QCPR-4 - Test Reports:

When required by this Purchase Order, the Supplier will provide various reports with each shipment. These reports shall be identifiable to the materials submitted and shall contain

objective evidence of conformance to the specification imposed by this Purchase Order. The reports shall include the name, title and signature of the Supplier's Authorized Quality Representative.

QCPR-4A - Chemical and Physical Test(s)

These reports must contain the Specification Lot, Roll, Batch or Serial Numbers applicable to the material submitted. They shall also delineate the specific requirement(s), test methods and results obtained.

Material/ Process Certifications

Raw Material Suppliers/Distributors shall include a copy of the original mill / origin of manufacture and any required secondary independent test laboratory certification(s) with the shipment of deliverable material. In addition, material must meet any other contractual requirements as stated in the Purchase Order, and any applicable DFARs.

The Supplier shall maintain and provide evidence of Test authenticity (chain of custody) back to the OCM/OEM. The Certification shall clearly identify the name and location of all of the supply chain intermediaries from the original manufacturer to the final source of the product delivered to AASC.

Material / Process Requirements

Supplier shall maintain a copy of all suppliers procured raw material certifications, which must be readily retrievable and shall include material specification, dimension/ description, alloy and condition. The supplier shall maintain the original mill / origin of manufacture certification and any secondary independent test laboratory certification(s) if any additional process was done after original certification for procured material that shall include physical properties, chemical analysis and lot number(s). In addition, material must meet any other contractual requirements as stated in the Purchase Order, and any applicable DFARs.

QCPR-4B - Dimensional Inspection Report Attributes

These reports must contain the date and results of the dimensional measurement of the material or items submitted. The report shall state the Part Number, description of the dimension and the attribute results of the measurement in a format acceptable to AASC. The Supplier shall maintain evidence of the inspections performed which may include a list of the tool(s) or equipment used to obtain the measurement and their calibration dates.

QCPR-4C - Characteristics Inspection Reports - FAI

These reports must contain the date and actual measurement results of the measurements of the characteristics of the items submitted. The reports must state the Part Number, Serial or identification number(s), and description of the requirement and actual results of the measurement. The Supplier shall maintain evidence of the inspections performed which will include a list of the tools or jigs to obtain the results and their calibration status. Reports requested for First Article Inspections shall comply with requirements and format of AS9102.

QCPR-5A - AASC Approved Material Sources**Counterfeit Parts**

Distributors or brokers that supply non-electrical standard parts, such as fasteners, nuts, washers, springs, O-rings, inserts, and pins, must have a certification from the Original Component Manufacturer (OCM) / Original Equipment Manufacturer (OEM), and that certification shall be delivered with each lot/ shipment. Parts shall not be used or reclaimed and misrepresented as new.

Chain of Custody

The Supplier shall maintain and provide evidence of Test authenticity (chain of custody) back to the OCM/OEM. The Certification shall clearly identify the name and location of all of the supply chain intermediaries from the original manufacturer to the final source of the product delivered to AASC.

QCPR-5B - AASC Approved Process Sources

Subcontracted processing of end-item deliverable parts or material must be made from AASC approved processing sources. Contact AASC Buyer or Quality Assurance Representative for written approval prior to contract award.

QCPR-6 - Removed / Not Used**QCPR-7 - Prohibited Materials**

The use of tin, zinc, and cadmium is prohibited as specified in the following subparagraphs. Supplier shall include a statement of compliance certifying to the following subparagraphs. Any exceptions shall be approved in advance by the Buyer.

- a. Tin. The use of pure unalloyed tin is prohibited as a surface finish for space hardware, including the surface finish on components or parts used inside a hermetic cavity or encapsulated within an assembly. (For example, terminations on chip capacitors in hybrids shall not consist of pure tin; the potted portion of leads on devices that are encapsulated shall not be plated with pure tin.) Solder-dipped tin alloy finishes shall contain at least three percent lead or at least three and a half percent silver. All other tin and tin alloy finishes shall contain at least three percent lead.
- b. Zinc. The use of pure zinc is prohibited as a surface finish for space hardware. Un-plated brass (an alloy containing copper and zinc as the main constituents) containing greater than 21 percent zinc is prohibited. Brass with greater than 21 percent zinc is acceptable if the brass is over-plated with a minimum of 50 micro-inches of nickel, or 100 micro inches of either copper or gold. Un-plated alloys other than brass that contain greater than 10 percent zinc are prohibited. Un-plated alloys other than brass alloys that contain greater than 10 percent zinc are acceptable if they are over-plated with a minimum of 50 micro-inches of nickel, or 100 micro-inches of either copper or gold. Zinc or alloys containing zinc that are sealed within a hermetic cavity are acceptable.
- c. Cadmium. The use of pure cadmium is prohibited as a

surface finish for space hardware. Un-plated alloys containing greater than five percent cadmium are prohibited. Alloys containing greater than five percent cadmium are acceptable if they are over-plated with a minimum of 50 micro-inches of nickel, or 100 micro-inches of either copper or gold. Cadmium or alloys containing cadmium that are sealed within a hermetic cavity are acceptable.

Receiving Codes

Receiving Codes (RC), which appear on Purchase Orders are pertinent to AASC Receiving Inspection procedures and are not the responsibility of the Supplier.

- RC1 - Sample inspection to ANSI Z1.4, AQL=4.0, unless modified by direction of the QAE.
- RC2 - Special receiving inspection instructions. If written special instructions have not been provided upon receipt of material, call the project QAE.
- RC3 - Laboratory acceptance testing required. The material or an acceptable sample shall be forwarded to the Materials Test Lab as required.
- RC4 - Sample inspection to BSI 8.1-4, Boeing Receiving Inspection Lot Sampling. Unless otherwise specified, all inspection defaults to an IRR of 90%.
- RC5 – Time and Temperature Sensitive (TATS) Material. Refer to Extended Description, Lab Data Sheet or Material Specification for shipping and storage temperature requirements.
- RC6 – Preferred Supplier - Reduced Receiving Inspection (RRI) Supplier process requirements are active. (Requires specific Supplier approval).