



P-7.2.3.2
Seller's Quality Requirements

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Revision Level: **B**

Page#
 1 of 6


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 1-Jun-09

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Approval	Name	Signature
Quality Manager <i>(Document Owner)</i>	Don Hulbert	Signed Original is on File.

Revision Record Cover Sheet		
Revision	Date	Change Description
A	07OCT03	Initial Release.
B	27APR09	Ref ECR# 01946 <ul style="list-style-type: none"> • Added opening statement "<i>Hard copies of this document are UNCONTROLLED, and may not be the revision currently in effect. It shall be the responsibility of the seller to ensure that they have and are utilizing the current revision at all sub-tier levels. ARC Technologies may be contacted through the Buyer/Planner or QA Department to supply this document at the current revision level.</i>" • Added "AS9100" reference in §D • Added "Anti-FOD" provisions.

	<p>P-7.2.3.2</p> <p>Seller's Quality Requirements</p>	<p>RELEASED FOR PRODUCTION</p> <p>Revision Level: B</p>
<p>Page# 2 of 6</p>	<p>PRINTED COPIES OF THIS DOCUMENT ARE *UNCONTROLLED*. PRINTED COPIES MAY NOT BE THE REVISION IN EFFECT. THE CONTROLLED, CURRENT REVISION IS POSTED ON THE ARC SERVER.</p>	<p>Print Date: 1-Jun-09</p>


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- A) Seller shall maintain an International Organization of Standards (ISO), Aerospace Standard (AS) or Military Standard equivalent quality system acceptable to Buyer for the Items (including "items" and "Work" as such terms may be used in this POs definitions) covered herein. Widely recognized Government or Industry Quality System standards should be used as guidelines. Upon Buyer's request, Seller shall provide to Buyer documentation that describe Seller's System.

- B) Seller shall provide and obtain for Buyer, Buyer's Customers, and appropriate regulatory agencies access to any and all facilities, including those facilities of Seller's subcontractors, where work on Items is being performed or is scheduled to be performed under this Purchase Order ("PO"). Buyer shall have right to perform in-process inspection, audits, and system surveillance at Seller and Seller's subcontractors' facilities as part of verification of conformance to the requirements of this PO. Work under this PO is subject to Buyer's periodic audit of Seller's compliance with Seller's internal procedures and other documents applicable to this PO. Seller shall provide, at no cost to Buyer, Government or appropriate regulatory agencies, suitable facilities at Seller and Seller's subcontractors' manufacturing locations for Buyer, Government, and regulatory agency representatives to perform compliance verification. Seller shall include the provisions of this Paragraph B in each purchase order, if any, with each of its subcontractors where work is being performed or is scheduled to be performed in connection with this PO, and shall require that this Paragraph B is inserted in all subcontracts at every tier.

Seller shall maintain complete records of all manufacturing, inspecting and testing in connection with the Items. At Buyer's election, such records shall be made available to the Buyer, Buyer's Customers and/or appropriate regulatory agencies during the performance of this PO and for at least five (5) years after completion of this PO or for such longer periods, if any, as may be specified elsewhere in this PO. Upon Buyer's request, Seller shall forward such records to Buyer at no cost to Buyer.

	<p>P-7.2.3.2</p> <p>Seller's Quality Requirements</p>	<p>RELEASED FOR PRODUCTION</p> <p>Revision Level: B</p>
<p>Page# 3 of 6</p>	<p>PRINTED COPIES OF THIS DOCUMENT ARE *UNCONTROLLED*. PRINTED COPIES MAY NOT BE THE REVISION IN EFFECT. THE CONTROLLED, CURRENT REVISION IS POSTED ON THE ARC SERVER.</p>	<p>Print Date: 1-Jun-09</p>

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Control and Processing Nonconforming Material and Corrective Action

- C) Seller shall implement and maintain a system, which provides for identification, documentation, segregation and disposition of non-conforming material and shall ensure effective, positive corrective action is taken (including repetitive nonconformances dispositioned "Use As Is" by Buyer's or Seller's material review board ["MRB"] actions) to prevent, minimize, or eliminate non-conformances. Seller's system shall ensure that nonconforming material is not used for production purposes.


Seller shall maintain records of all non-conforming material, dispositions, assignable causes, corrective actions, and effectiveness of corrective actions for the period specified in this PO. Seller shall evaluate each non-conformance for its potential to exist in previously produced or delivered Items. If a non-conformance exists, Seller shall notify Buyer, in writing, within 24 hours for issues impacting flight safety, and, in writing, within 5 working days for all other issues. Buyer shall forward requests for corrective action, if any, to Seller when unsatisfactory performance by Seller and/or any of its subcontractors is detected by Buyer. Seller shall respond to all Buyer requests for corrective action. When requested by Buyer, Seller shall provide trend data and findings for Buyer returned Items. Seller shall assess all Buyer identified non-conformances and take the appropriate actions to ensure causes of non-conformance are corrected. If Seller is unable to verify or duplicate the non-conformance or refuses responsibility for the non-conformance, Seller shall notify Buyer. If Seller does not respond by Seller Confirmation Action Request ("SCAR") within 30 days of receipt by Seller of the non-conforming Item, Seller shall be deemed to have accepted responsibility for the identified non-conformance.

Material Review Authority (MRA) for Seller-Designed Items

Seller has Material Review Authority, except for nonconformances, which affect a parameter controlled by Buyer drawing or specification, which affects form, fit, function, interchangeability or reliability. Seller shall submit dispositions of nonconforming Items, if any, regarding any such parameter(s) to Buyer for approval.

MRA for Buyer-Designed Items

Seller dispositions are limited to scrapping of Items, eliminating the nonconformance by rework to engineering, or returning to vendor. On Items of Buyer design, Seller shall document nonconforming Items for submittal to Buyer's MRB for dispositions as required by this PO. Seller's continued processing, prior to Buyer's MRB disposition, of any Buyer-designed Items containing a nonconformance prior to Buyer's MRB disposition will be at Seller's risk.

	<p>P-7.2.3.2</p> <p>Seller's Quality Requirements</p>	<p>RELEASED FOR PRODUCTION</p> <p>Revision Level: B</p>
<p>Page# 4 of 6</p>	<p>PRINTED COPIES OF THIS DOCUMENT ARE *UNCONTROLLED*. PRINTED COPIES MAY NOT BE THE REVISION IN EFFECT. THE CONTROLLED, CURRENT REVISION IS POSTED ON THE ARC SERVER.</p>	<p>Print Date: 1-Jun-09</p>

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Additional MRA Requirements for Buyer-Designed Items

If seller has written delegated MRA, on Buyer-designed Items, Seller shall exercise such MRA except for non-conformances of a parameter that affects form, fit, function, interchangeability or reliability.

Material Review Board Submittals

Seller dispositions are limited to scrapping of Items, eliminating the nonconformance by rework to engineering, or returning to vendor. On Items of Buyer design, Seller shall document nonconforming Items for submittal to Buyer's MRB for dispositions as required by this PO. Seller's continued processing, prior to Buyer's MRB disposition, of any Buyer-designed Items containing a nonconformance prior to Buyer's MRB disposition will be at Seller's risk.

Requirements for Seller-Designed Items

For Seller-designed Items:

1. Seller has the responsibility and authority to approve and control its own processing sources, including in-house processes.
2. Seller shall ensure that the assignment of personnel is commensurate with their level of experience, training and proficiency.

Calibration


D) Seller shall maintain a calibration system that is compliant with the requirements in AS9100, ISO 9001:2000, ISO 10012-1, MIL-STD 45662A, or ANSI 2540.

Product Certifications and Acceptance

E) Seller shall prepare a Certificate of Conformance statement that Items provided under this PO meet all applicable requirements. This Certificate of Conformance shall be included with Seller's shipping document to Buyer.

Changes to Seller's Operations

F) Seller shall notify Buyer, in writing, of any change in status of its quality system as a result of any Government or regulatory agency action. Seller shall also notify Buyer, in writing, upon any relocation or transfer of manufacturing operations, or change in any organization or procedure that could impact Item quality.

	<p>P-7.2.3.2</p> <p>Seller's Quality Requirements</p>	<p>RELEASED FOR PRODUCTION</p> <p>Revision Level: B</p>
<p>Page# 5 of 6</p>	<p>PRINTED COPIES OF THIS DOCUMENT ARE *UNCONTROLLED*. PRINTED COPIES MAY NOT BE THE REVISION IN EFFECT. THE CONTROLLED, CURRENT REVISION IS POSTED ON THE ARC SERVER.</p>	<p>Print Date: 1-Jun-09</p>

File Name: Sellers Quality Requirements.doc

Selection and Control of Seller's Sub-tier Sources

- G) Seller's quality system shall include procedures for determining the capability of sub-tier suppliers, prior to issuance of Seller's PO. When the Seller performs a Quality System Survey or Evaluation for a sub-tier supplier facility, the results of each survey or evaluation shall be documented. Seller is responsible for ensuring all materials, services and components it procures for incorporation into the Items conform to all requirements of this PO.

Seller shall define and establish a program for determining the need for periodic re-audit or reevaluation of Seller's sub-tier suppliers. Prior to production and award of subcontracts, Seller shall institute a program that will ensure control of the quality of all Items procured by Seller in support of this PO. Seller shall include the applicable portions of this PO in each of its purchase orders, if any, with each of its subcontractors where work is being performed or is scheduled to be performed in connection with this PO and require that, where applicable, such portions are inserted in all subcontracts at every tier.


Anti-FOD (*Foreign Object/Debris*) Provisions

Seller shall maintain a FOD prevention program. Seller's FOD prevention program shall include the review of design and manufacturing processes to identify and eliminate foreign object entrapment areas and paths through which foreign objects can migrate. Seller shall ensure work is accomplished in a manner preventing foreign objects or material in deliverable Items. Seller shall maintain work areas and control tools, parts and materials in a manner sufficient to preclude the risk of FOD incidents. Seller shall document and investigate each FOD incident and ensure elimination of the root cause of each such incident.

Whenever and/or wherever FOD entrapment or foreign objects can migrate, Seller's FOD prevention program shall include Seller's periodic self-assessment of its internal FOD prevention practices, including each respective subcontractor's FOD prevention program at every tier to measure effectiveness of program compliance to requirements. Seller's FOD prevention program shall provide initial and periodic FOD training to Seller's employees. Seller shall provide records of such self-assessment and training to Buyer, upon request.

Seller's FOD prevention program shall contain, at a minimum, the following elements:

3. Design & Manufacturing Process Review
4. Performance Measurement
5. Training
6. Material Handling and Parts Protection

	<p>P-7.2.3.2</p> <p>Seller's Quality Requirements</p>	<p>RELEASED FOR PRODUCTION</p> <p>Revision Level: B</p>
<p>Page# 6 of 6</p>	<p>PRINTED COPIES OF THIS DOCUMENT ARE *UNCONTROLLED*. PRINTED COPIES MAY NOT BE THE REVISION IN EFFECT. THE CONTROLLED, CURRENT REVISION IS POSTED ON THE ARC SERVER.</p>	<p>Print Date: 1-Jun-09</p>

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7. Housekeeping
8. Tool Accountability
9. Hardware Accountability
10. Lost Items Search and Documentation Process
11. Physical Entry Control into FOD Critical Areas
12. FOD Focal Point(s)

Prior to closing inaccessible or obscured areas and compartments during assembly, Seller shall inspect for foreign objects/materials. Seller shall ensure that tooling, jigs, fixtures, and test or handling equipment are maintained in a state of cleanliness and repair sufficient to prevent FOD. By delivering Items to Buyer, Seller shall be deemed to have certified to Buyer that such Items are free from any foreign materials that could result in FOD.

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