



## PCA PURCHASE ORDER CLAUSES

**"Buyer" = PCA Aerostructures Company**

**"Seller" = Vendor, Supplier, Subcontractor, and/or Agents/Representatives**

**Buyer objects** in advance to the inclusion of any additional or different terms proposed by *Seller* in acceptance or acknowledgment of purchase order. The inclusion of such terms by the *Seller* will be of no significance. Such terms will not be conditions or additional terms to the purchase order. Unless otherwise stated on the face of the purchase order, the following Quality Text Clauses shall apply.

These Quality Text Clauses will vary and will be specifically called out in every purchase order issued to *Seller*

### QC1 PHYSICAL AND CHEMICAL TEST REPORTS

*Seller* shall supply one copy of physical and/or chemical test reports for each lot, batch or heat, whichever is applicable. *Seller* shall supply original mill certification with shipment of material specified on the purchase order. The report shall show that material/parts delivered are acceptable and shall be traceable to the product being delivered. The heat number and material manufacturer shall appear on the certification. All metal alloys shall require traceability to the original heat number, and shall comply with the current material specification revision in effect when melted. The heat number and material manufacturer shall appear on the certification. Material converters are responsible for maintaining heat lot traceability and are prohibited from welding, brazing or otherwise joining coils.

### QC2 MATERIAL SAMPLE REQUIRED

*Seller* shall furnish *Buyer* a material sample cut or molded from the same material as the product supplied. *Buyer* or the material specification shall determine the size of the sample. For *Buyer*, material samples supplied shall be cut per purchase order instructions. Note: The *Buyer's* Receiving Department will deem for rejection and subject to refusal shipments made by the *Seller* without samples. Similarly, if the sample does not pass its material specification tests, the product supplied shall be considered unacceptable and will be returned to the *Seller*.

### QC3 INSPECTION REPORT

A completed copy of the *Buyer* Inspection Report (PCA-F824) shall accompany each item specified on the purchase order. 100% Inspection is required with actual recorded results for all characteristics on all parts to ensure conformance to drawing and specification requirements.

### QC4 INSPECTION AND CALIBRATION SYSTEM REQUIREMENTS

*Seller* shall maintain a documented quality system that complies with the requirements of AS9100, ISO 9000 or government requirements. Specifically, *Seller* shall maintain a documented calibration system in accordance with ISO 10012 and/or ANSI/NCSL Z540-1 and Boeing D1-9000 Section 1.11; and as a minimum, an inspection system compatible with the requirements of ISO 9002. *Seller's* quality system is subject to verification and approval at all times by *Buyer's* Quality Assurance Department.

### QC5 GENERAL ELECTRIC S-1000

*Seller* agrees to comply with the quality requirements stated under the current revision of General Electric S-1000, Part III.

### QC6 CHANGES

*Seller* shall not make any changes to the processes or materials specified under the purchase order. **Within five (5) days**, *Seller* shall notify *Buyer* in writing prior to any proposed changes to supplier controlled design, parts, materials, fabrication methods or processes, that may affect function, interchangeability or reliability of hardware delivered to *Buyer* or of any changes to facility location, ownership or quality management following a quality survey/audit by *Buyer*.

### QC7 AGGREGATE QUANTITY SHIPMENT VARIANCES

*Seller* shall supply quantities for the net amount ordered. Any variance reflected on the purchase order shall be approved by *Buyer's* appropriate purchasing representative prior to shipment. Unauthorized shipments received will be returned to *Seller* at *Seller's* expense.

### QC8 ACCEPTABLE OVER SHIPMENT ALLOWANCES

Removed

### QC9 VARIABILITY REDUCTION PROGRAM

*Seller* shall implement Statistical Control Procedures when applicable. A detailed Statistical Process Control (SPC) Histogram and/or Control Chart with recorded Cpk shall accompany each shipment. The report shall include evidence of conformance to all the elements including material and processes. All specified key characteristics shall be recorded. The report may be the *Seller's* format and shall list drawing characteristics consistent with customer supplied data. The report shall show the part number, revision level and PO number, run time and verified dimensional Cpk. *Buyer* reserves the right to witness the actual inspection or to require spot checks to verify the data.

### QC10 BUYER SOURCE INSPECTION

*Buyer* source inspection is required. Inspection shall be conducted at the *Seller's* facility and shall be requested and accomplished prior to shipment. When the items on the Purchase Order are ready for inspection, notify the *Buyer's* purchasing representative so that coverage can be arranged. Drawings, specifications and/or other pertinent data, as required by Purchase Order, shall be made available to the *Buyer* Quality Representative, at the time of material presentation.

### QC11 FAA/CUSTOMERS RIGHT OF ENTRY

*Seller* agrees that its facility, fabrication inspection system, methods and procedures are subject to the Federal Aviation Administration (FAA) or Government Agencies surveillance and investigation. All other *Buyer's* customers reserve the right of entry into the plant to verify the quality of work and materials at any/all production stages, as well as compliance to procedures and specifications.

### QC12 FIRST ARTICLE INSPECTION

A detailed first article inspection report is required. The report shall be on *Buyer* Inspection Report (PCA-F824 or equivalent AS9102 compliant documentation) and shall list all drawing characteristics. The report shall include evidence of conformance to all elements including material and processes. Each drawing characteristic shall be complete with the tolerance in an adjoining column. The measured condition shall be recorded. The report shall show *Buyer* part number, revision and purchase order number. *Buyer* shall be notified in advance when the first article inspection is scheduled and reserves the right to witness the actual inspection or to require spot checks to verify the data. This first article shall consist of one piece. This piece shall be identified and packaged separately along with the report when shipped with the production parts.



#### QC13 GOVERNMENT SOURCE INSPECTION REQUIRED

Government inspection is required prior to shipment of this material from *Seller's* facility. *Seller* is responsible for providing the Government Inspector with verifiable evidence that product meets the requirements of the subcontract or purchase order. Upon receipt of this order, promptly notify the Government Representative who normally services *Seller's* facility so that appropriate planning for Government Inspection can be accomplished. Provide a copy of this order to the Government Representative or if none, to the nearest Army, Navy, Air Force, or Defense Supply Agency inspection office. In the event the representative or office cannot be located, notify *Buyer's* Purchasing Representative immediately.

#### QC14 RELATED REGULATORY REQUIREMENTS

The provisions of executive order 11246, as amended by executive order 11375 (Equal Employment Opportunity), 38 USC 4212 (Vietnam Era Veterans Readjustment Assistance Act), and Section 503 of the Rehabilitation Act of 1973 (Handicapped Regulations), implementing regulations found at 41 CFR 60-1 & 2, 41 CFR 60-250 and 41-CFR 60-741 are hereby incorporated by reference.

#### QC15 SPECIAL PROCESSES

Each special process including but not limited to: soldering, cleaning/etching, passivation, welding, brazing, plating/coating, heat treating, magnaforming/swaging, electro polishing, acid pickling, impregnating, bonding, glass sealing, shot peening, silkscreening, magnetic particle/penetrant, X-Ray or N-Ray inspections, when required by either a Government, ASTM, or other process specifications shall be performed by OEM approved suppliers only. A list of approved special processors will be provided when required and upon request by the *Seller*. Each shipment shall include a report or certification of adequate data as to where the processing was accomplished, including processing source name and address. When required, laboratory testing facilities used to verify compliance to special processing requirements shall be duly accredited laboratories in accordance with Public Law 106-34, otherwise known as the Fastener Quality Act (FQA) or ISO17024.

#### QC16 CERTIFICATE OF CONFORMANCE

*Seller* shall submit with each shipment a Certificate of Conformance stating that the items furnished to *Buyer* are in conformance to the PO/Drawing requirements applicable to the items delivered. Any recognized aerospace, military and/or industry standard, when imposed by the drawing, specification or PO shall be specifically stated on the certification. *Seller* shall have on file all material, chemical and physical test reports and C of C's for processes performed by sub-tier suppliers and shall make these documentation available for review by *Buyer's* Representative upon request. As a minimum, each supplier and/or sub-tier certification shall contain the following information: (a) PO Number (b) Lot Number (c) Quantity Shipped (d) Part Number (e) Name and address of the company issuing the certification (f) The date of issue and (g) Signature and title of the *Seller's* authorized representative.

#### QC17 SHELF LIFE ITEMS

Materials or articles having characteristics subject to degradation with age shall be marked in a manner to indicate the date of manufacture and expiration date in addition to standard identification requirements. Batch numbers and special storage or handling conditions shall be included when applicable. Material Safety Data Sheets (MSDS) shall also be provided where there is a danger to health from material being purchased.

#### QC18 PACKING/PACKAGING

*Seller* shall ensure that all items shipped under this Purchase Order are adequately packed and/or packaged to prevent damage, contamination and/or deterioration. Unless otherwise specified on the Purchase Order, *Seller* shall use best commercial practices in packaging to prevent damage, contamination and/or deterioration to all items during transit.

#### QC19 MERCURY FREE CERTIFICATION

Each shipment shall be accompanied by one legible and reproducible certification of mercury free material. The report shall contain the signature and title of the authorized representative of the certifying facility and shall conform to the specification requirements. This certification could be furnished as part of the Certificate of Conformance specified in Clause QC16.

#### QC20 NONCONFORMING MATERIAL CONTROL & LATENT DEFECT NOTIFICATION/ROOT CAUSE AND CORRECTIVE ACTION

If nonconformances are detected during manufacturing or inspection, the *Seller's* Quality Assurance personnel shall **Submit for Buyer's review**. The *Seller* shall segregate and control the nonconforming material to assure no further work is accomplished on the discrepant item(s) until *Buyer's* disposition is obtained. The material shall be held at the *Seller's* facility pending direction from *Buyer*. When *Buyer's* review is completed, the disposition shall be provided to the *Seller* immediately. **Internal nonconformances in the Seller's daily operations shall be evaluated for the potential to exist in previously produced or delivered hardware. If a potential latent defect is determined, a written notice to Buyer is required within 24 hours of discovery.**

**Root Cause and Corrective Action:** When requested in writing by *Buyer*, *Seller* shall provide proof of corrective action, root cause and corrective action for any deficiencies deemed supplier responsibility on Corrective Action Request, Forms F13-01 or F14-01. Failure to respond in a timely and/or effective manner may result in future on-site review, source inspection at supplier's facility, being placed on purchase order hold status and/or removal from the PCA Approved Supplier List (ASL).

#### QC21 SCREW THREAD GAUGING SYSTEM REQUIREMENTS

*Seller*, providing thread forming processes or threaded product, shall comply to requirements specified in the applicable specification. Unless otherwise specified, all threads shall comply with System 22 requirements per ASME B 1.3 and reference Mil-Std-8879, Mil-Std-7742, or FED-STD-H28 guidelines as applicable.

#### QC22 PREFERENCE FOR DOMESTIC SPECIALTY METALS

This contract requires compliance with DFARs 252.225-7014. These requirements shall apply to *Seller* and shall be flowed to all *Seller's* sub-tiers who provide specialty metals pursuant to this contract.

"As prescribed in 225.7002-3(b)(1), use the following clause:

#### PREFERENCE FOR DOMESTIC SPECIALTY METALS (JUN 2005)

(a) *Definitions*. As used in this clause—

(1) "Qualifying country" means any country listed in subsection 225.872-1 of the Defense Federal Acquisition Regulation Supplement.

(2) "Specialty metals" means—

(i) Steel—

(A) With a maximum alloy content exceeding one or more of the following limits: manganese, 1.65 percent; silicon, 0.60 percent; or copper, 0.60 percent; or

(B) Containing more than 0.25 percent of any of the following elements: aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, or vanadium;

(ii) Metal alloys consisting of nickel, iron-nickel, and cobalt base alloys containing a total of other alloying metals (except iron) in excess of 10 percent;

(iii) Titanium and titanium alloys; or

(iv) Zirconium and zirconium base alloys.



(b) Any specialty metals incorporated in articles delivered under this contract shall be melted in the United States or its outlying areas.

(c) This clause does not apply to specialty metals—

(1) Melted in a qualifying country or incorporated in an article manufactured in a qualifying country; or

(2) Purchased by a subcontractor at any tier.

ALTERNATE I (APR 2003)

As prescribed in 225.7002-3(b)(2), substitute the following paragraph (c) for paragraph (c) of the basic clause, and add the following paragraph (d) to the basic clause:

(c) This clause does not apply to specialty metals melted in a qualifying country or incorporated in an article manufactured in a qualifying country.

(d) The Contractor shall insert the substance of this clause, including this paragraph (d), in all subcontracts for items containing specialty metals.

#### **QC23 CONTRACT/DRAWING DIRECTED SOURCE/QUALIFIED PRODUCTS LIST**

This item/service is to be procured from a listed source.

#### **QC24 ROCKWELL HARDNESS/ELECTRICAL CONDUCTIVITY TEST:**

Verification is required. Certifications shall show actual readings as well as specification requirements (High and Low).

#### **QC25 SERIALIZATION/TRACEABILITY**

Requirement that all parts have unique serial numbers (S/N) and/or Job Numbers (JN) maintained and/or assigned. Maintain S/N and/or JN traceability at all stages of manufacturing or processing. Indicate S/Ns and/or JNs on all certification, shipping reports and/or other documentation as applicable.

#### **QC26 BUYER FURNISHED DOCUMENTS/ TECHNICAL OR PROPRIETARY DATA**

All drawings, specifications, mylars, or related data are to be returned upon completion of the PO or Contract. All data provided to support manufacturing or process of this order is proprietary and shall not be reproduced in whole or part, and shall be returned upon completion of the PO or Contract.

#### **QC27 CUSTOMER-FURNISHED PROPERTY**

All tooling utilized in this order is Buyer (Customer) Furnished and shall be returned with final shipment of product unless stated otherwise in this PO or contract. While tooling is in Seller's possession, tooling shall be kept clean and protected. For Boeing IDS tooling, D950-11059-1 is hereby imposed.

#### **QC28 SUBCONTRACTING**

Subcontracting all or part of the work procured on this PO without Buyer's written approval is prohibited. All approved subcontracted operations shall meet all provisions of the PO and be certified by the subcontractor.

#### **QC29 FLOWDOWN: Boeing**

Boeing's D1-9000A Quality System Requirements are hereby imposed.

#### **QC30 FLOWDOWN: Northrop**

Northrop's (SQR) Quality System Requirements are hereby imposed.

#### **QC31 FLOWDOWN: Lockheed**

Lockheed's Attachment "Y" Quality System Requirements are hereby imposed.

#### **QC32 FLOWDOWN: Lockheed's Appendix QX "Quality Requirements Seller Quality Requirements"**

For PCA Purchase Orders (PCA Vendor codes 008448 and 681627)

"Processing to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company purchase order and shall be accomplished in accordance with process specification(s) on this purchase order and the revision in effect as of the date of this PO of Lockheed Martin Aeronautics Company Appendix QJ. All requirements of such Appendix QJ paragraph 12.a.-f. shall be accomplished. Appendix QJ is located at [www.lmaeronautics.com/material-management/](http://www.lmaeronautics.com/material-management/)."

#### **QC33 LATEST SPECIFICATION REVISIONS**

The supplier shall use the latest specification revision as published in this PO or Contract. A current copy of Process Specification Revision Levels (PCA-F06-03) can be obtained by fax/e-mail through the Buyer's Representative.

#### **QC34 Foreign Object Debris/Damage Prevention**

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 incident.

#### **QC35 Lockheed Q4R FOD Prevention Clause**

Seller shall maintain a FOD prevention program in accordance with the requirements of Lockheed Quality Clause Q4R and assure same requirements are flowed down to Seller's subcontractors at every tier. The complete text of Clause Q4R can be found at the following web address: <http://www.lmaeronautics.com/material-management/> under Quality Appendices.

#### **QC36 Buyer Supplier DPD/MBD**

Seller's Compliance to Boeing DPD/MBD Requirements D6-51991. The engineering contained within this PO is digitally controlled per Buyer's Procedure AWI-42-24. Outside sources are required to be DPD/MBD approved by Buyer. Seller will not outsource any DPD/MBD work pursuant to this PO without written authorization.