



SPX Precision Components Quality Notes

Supplier Quality Assurance Requirements – Quality Clauses

Revision 1 – February 1, 2011

1. All special processes required by the Purchase Order must be performed by sources that are approved by the prime customer, and to the latest revision of the applicable process specification.
2. Copies of all material, processing, and test certifications must accompany each shipment of parts if required by the engineering drawing, blueprint, applicable specification or the Purchase Order.
3. Originals or Copies of chemical and physical analysis certifications must accompany each shipment of parts for all supplier purchased material. SPX PC PO, job number and/or reference number must be noted on each certification.
4. Parts must be 100% inspected and accepted by the supplier. Rework that must be performed by SPX PC will be debited from the suppliers invoice.
5. All parts with a non-conformance to the drawing requirements must be tagged with the discrepancy. The packing slip should note the discrepancy along with the numbers discrepant (including affected Serials Numbers if applicable).
6. First Article Inspection is required for 1) first time production, 2) equipment, tooling, process or die changes that may affect form, fit or function, or 3) if there has been a 2 year production break. The FAI shall be performed by the supplier for each dash number. The FAI report shall indicate the actual measurement of each characteristic on the drawing, parts list and Op sheet (if applicable). The preferred FAI format is AS9102. An amended FAI report containing the measurements of the dimensions affected, is required for any configuration changes.
7. During the performance of this Purchase Order, SPX precision Components, its customer and/or regulatory agencies, have the right of access to the supplier's facility and their sub-tier supplier's facilities, in order to determine and verify product quality, records, processes and material. SPX PC's acceptance of a process or product does not absolve the supplier of the responsibility to provide acceptable product, nor does it preclude subsequent rejection by our customer.
8. All parts must be protected against damage and corrosion during delivery and performance utilizing standard commercial packaging procedures, except where a contract specific packaging requirement is identified in the purchase order.
9. The supplier must ensure that materials utilized in the performance of this order (whether customer, SPX or supplier furnished), are segregated and controlled to ensure traceability and prevent intermingling with other materials.
10. If applicable, assigned serial numbers shall be maintained throughout all manufacturing cycles and shall be identified on both the parts and all documentation provided
11. For all close tolerance holes (.0015" or less) GO and NO GO gauging techniques are not acceptable. Inspection equipment utilized must have the capability to attain a measurement of 10% of tolerance being inspected, e.g. dial bore or air gauging. (Reference ANSI/NCSL-Z540-1-1994 and ISO-10012)
12. Suppliers of Bell Helicopter raw material must use domestic milled material.
13. Parts requiring bushing installation per BAC 5435 must comply with BAC-5435, PSD #6-34 (Sealant Installation of Bushings).
14. Performance on this order is subject to BOEING D6-82479 requirements if either the Engineering Drawing of the supplied Operation sheet requires a key or critical characteristic.
15. This is a designated part (Ref: D6-1276/D36002). A forging manufacturing plan must be written per applicable specification(s) and submitted for Boeing approval prior to fabrication of production forgings. Certifications for first and subsequent lots of production forgings shall indicate the Boeing approval memo number for the particular forging part/dash number produced.
16. This is a Northrop Grumman fracture/maintenance critical part. When NDT is required, the source performing such inspection must have a written NDT procedure that has been approved by Northrop Grumman. Certifications supplied must indicate customer approval.
17. This is an F-18 part. When NDT is required, the source performing such inspection must have a written NDT procedure that has been approved by Northrop Grumman and the McDonnell Douglas Corp. Certifications supplied must indicate customer approval.
18. Supplier must flow down requirement for raw material supplier to be approved by the prime customer.
19. Purchase orders for Standard Hardware of assemblies that include Standard hardware (i.e., BAC, AN, NAS, STM, MIL, etc.) are to be satisfied with material of the latest specification revision level in effect and must comply with all obsolescence/supersede criteria when applicable.

20. Items on this Purchase order are for Boeing Aircraft use and must comply with all Boeing engineering requirements, including the D-590 and D1-4426 specifications for the particular item(s) ordered.
21. In compliance with EPA regulations, supplier must submit a yearly letter of disclosure stating, either positive or negatively, whether or not ozone depleting substances have been used in the performance of the Purchase Order. Any positive statements must name the substance(s) used, all well as the specific items they were used to manufacture.
22. Items on this Purchase order are for Sikorsky Aircraft use and must be controlled and labeled/marked per applicable Sikorsky Aircraft requirements.
23. Original Manufacturer's Certification is required from a Qualified Products List Approved Source.
24. Supplier is to machine 100% complete LESS the processing and finishing to the B/P and the P/L revision levels called out below and to the Revision maintenance records enclosed.
25. Supplier is to machine 100% complete INCLUDING the processing and finishing to the B/P and the P/L revision levels called out below and to the Revision maintenance records enclosed.
26. Part number and grain direction are to be clearly marked on all material.
27. Confirm in writing. Do not duplicate. Inspection Required.
28. Vendor to supply all raw material and certifications.
29. Material should be skidded/boxed/packaged separately by Part Number. Do not co-mingle material. If the material is co-mingled by the supplier, SPX PC will debit the supplier for SPX labor to separate the material.
30. Parts must comply with the requirements of DFARS 252.225-7014, "Preference for Domestic Specialty Metals," and Alternate 1.
31. The supplier shall maintain a Quality Management System that is compliant to ISO9001:2008 or AS9100. Suppliers who do not meet this requirement must have written authorization from SPX PC to deliver product.
32. Supplier must submit a Certificate of Conformance summarizing all processes and test performed on the parts, along with the name of each facility utilized.
33. Supplier shall manufacture inspection aids per this Purchase Order. Configuration is to be coordinated with SPX. SPX PC reserves the right to inspect and verify all inspection aids prior to supplier part fabrication. All inspection aids must be delivered with the final part shipment.
34. If a retention period for quality records, certifications and documentation is not specified in a prime contract requirement, these records must be maintained for a period of 50 years after final payment of this purchase order. After this time, the supplier shall not destroy such records without giving SPX PC ninety days advance written notice.
35. Material consigned to the supplier may not be substituted by any other material to complete the order requirements. If an item is scrapped in excess of the scrap allowance, it is the supplier's responsibility to immediately notify the SPX buyer in writing, otherwise the supplier may have to run a small lot. The supplier will be liable for the replacement costs, and accountable for all material consigned.
36. Upon receipt of a drawing from SPX PC, it is the supplier's responsibility to thoroughly review and understand the drawing geometric tolerance symbols, and to be capable to comply with the requirements prior to manufacturing. Technical questions shall be submitted to the SPX buyer in writing.
37. This Purchase Order requires SPC to be performed by the supplier.
38. Suppliers will be notified when acceptable quality ratings are not met for 2 consecutive periods. If, after 90 days, no improvement is made, the supplier will be removed from the SPX PC AVL.
39. Government Source Inspection is required.
40. Customer Source Inspection is required.
41. If an SPX First Piece Inspection is required, the supplier must advise the SPX Quality department with 24 Advance Notice of part coming due for inspection. Acceptance by SPX does not release the supplier of any liability to manufacture the part to the specifications, drawings or Purchase order requirements.
42. BOEING MESA Standard Q-Note – Production: Quality records must be maintained, and be accessible within a reasonable time, for 7 years after completion of this Purchase Order. Boeing document EPB-119 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable. Certification must contain Material Control (MC) number (for raw material only).
43. BOEING MESA Standard Q-Note – O&R: Quality records must be maintained, and be accessible within a reasonable time, for 7 years after completion of this Purchase Order. Boeing document EPB-1 20 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable. Certification must contain Material Control (MC) number (for raw material only).
44. BOEING Philadelphia Standard Q-Note – Production: Quality records must be maintained, and be accessible within a reasonable time, for 50 years after completion of this Purchase Order. Boeing document EPB-119 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable.
45. BOEING Philadelphia Standard Q-Note – O&R: Quality records must be maintained, and be accessible within a reasonable time, for 50 years after completion of this Purchase Order. Boeing document EPB-1 20 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable.
46. DoD/AMCOM Standard Q-Note – Production: Quality records must be maintained, and be accessible within a reasonable time, for 7 years after completion of this Purchase Order. DoD document QE-STD-1 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable.
47. DoD/AMCOM Standard Q-Note – O&R: Quality records must be maintained, and be accessible within a reasonable time, for 7 years after completion of this Purchase Order. DoD document QE-STD-2 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's 8-* that are applicable.
48. Sikorsky Standard Q-Note: Quality records must be maintained, and be accessible within a reasonable time, for 40 years after completion of this Purchase Order. Sikorsky documents ASQR-01 and SA908S apply. Certification must state "Parts and/or services are destined for Sikorsky Aircraft"
49. Columbia Standard Q-Note: Quality records must be maintained, and be accessible within a reasonable time, for 50 years after completion of this Purchase Order. Columbia document CHI-M-1336 applies.
50. GENERAL QUALITY REQUIREMENTS Newington CT (REVISED 1/28/2011): Compliance with AS9100 OR ISO 9001 (latest revisions) is required; Compliance ANSI / NCSL Z540-1-1994 OR ISO 10012-1:2003 is required; All certifications must include Purchase Order Number, Part Number(s), Part Number Revision(s), Serial Number(s), Operation Number(s), Specification(s) and Revision Level(s), Amendments and PSD's as applicable, an Authorized signature and typed name and title of signatory. For Raw Material (Boeing Mesa only) a Material Control (M/C) Number is also required; These PO requirements must be flowed down to all sub-tier suppliers as applicable; Sub-tier suppliers must be on Prime's "Approved List" as applicable; Supplier shall notify SPX Purchasing IN WRITING for approval of changes in product and/or processes; Supplier must have written authorization from SPX Purchasing prior to making any changes to product and/or processes; Supplier shall notify SPX Purchasing IN WRITING when a delivered product and/or affecting process nonconformance is discovered or suspected (including suspect counterfeit parts); Nonconforming product cannot be shipped to SPX without written authorization from SPX Purchasing; SPX, its customer's and regulatory authorities retain the right of access to all facilities involved in this order and all applicable records; Quality documentation records and certifications must be maintained for a period of 50 years after final payment of this PO. After this time period the supplier shall not destroy such records without giving SPX Purchasing and Quality ninety days written notice. IF BAC Specifications apply; refer to Boeing document D1-4426 for PSD's and certify to PSD's 8-* that are applicable. If Sikorsky part the certification must state "Parts and/or services are destined for Sikorsky Aircraft". If supplier uses Boeing/Government supplied tooling in the performance of this PO, Boeing document D950-11059, SEC. 9 APPLIES.

51. Flight Safety Part: Flight Safety Part – Supplier must submit manufacturing plan and associated traveler to SPX PC Engineering for approval. Once approval is received and approved, the plan and traveler cannot be updated/changed and used to process product without re-submittal and approval.
52. Boeing document D950-11059, Section 9 – Boeing/Govt "Each Use Condition Check" applies when using SPX supplied BAC/Govt tooling or gages.

COPYRIGHT © 2008 SPX PRECISION COMPONENTS | ALL RIGHTS RESERVED