



PURCHASE ORDER QUALITY REQUIREMENTS

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Only the quality requirements identified in the Chenega Manufacturing Services purchase order shall apply:

100 Limited Life Material

Materials or articles subject to degradation with age shall be marked in a manner to indicate the date of manufacture or cure date, batch/lot number, shelf life expiration date and any special considerations required to achieve the stated life. SDS to be included. No more than 20% expired shelf life at time of delivery.

101 First Article Inspection

Supplier first article inspection is required on 1 piece of the initial shipment on this order. Acceptance shall be based on drawing requirements, purchase order, and specifications. Supplier shall submit a complete first article inspection report with each article.

102 Certificate of Conformance (Standard)

Supplier must state that the shipment of articles on this order conform to applicable material and/or process specifications. Supplier must retain on file material test results and process records, as applicable, including supplier certifications. The C of C certifies that a product or service has met all applicable drawing and purchase order requirements.

102A Certificate of Conformance (Detailed)

Supplier must state that the shipment of articles on this order conform to applicable material and/or process specifications and/or standards. All specifications and standards must be identified in the C of C. Supplier must retain on file material test results and process records as applicable, including supplier certifications. The C of C certifies that a product or service has met all applicable drawing and purchase order requirements.

102B Seller / Manufacture Certificate of Conformance (Deliverable)

Seller shall include a Certificate of Conformance (C of C) with each shipment for Goods identified on shipping document. If Seller is not a manufacturer (or service provider), in addition to the Seller's C of C, the following shall also be included:

- A manufacturer's (or service provider's) C of C
- A Certificate of Conformance and Supply Chain Traceability (CoCT) - A certificate of conformance that provides evidence that the parts were obtained directly from the Original Component Manufacturer (OCM) or approved manufacturer

The following shall be included on Seller's and/or Manufacturer's C of C and/or shipping document with each shipment:

- Seller's name and address and reference to Buyer's contract number and line item number. (Seller's C of C)
- Manufacturer's (or service provider's) name and address. (Manufacturer's (or service provider's) C of C)
- A statement attesting that Goods provided under this contract conform to all contract requirements.



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- Part number and dash number (as specified by Purchase Contract (PC)) for each item
 - Revision level / version (as specified by PC) to which the Goods were manufactured (or serviced)
 - Traceability information, if required, representative of each item - to include the lot trace (e.g., date, batch, heat) or the individual item trace (e.g., serial number)
 - When multiple item manufacturers (or service providers) and/or multiple lots are included in one shipment, Seller shall separate and identify respective manufacturer's (or service provider's) lots, and indicate each lot quantity
 - If goods are Buyer furnished, so indicate on C of C by part number and quantity
 - Additional documentation requirements defined by the item specification as applicable
- When applicable, the following shall be included on Seller's CoCT with each shipment:
- Name, address and phone number of the OCM authorized distributor
 - Statement that the supplier is an OCM authorized source
 - Boeing purchase order/purchase contract number
 - Part number
 - Part manufacturer (OCM)
 - Lot code/Date code as applicable
 - Quantity
 - A statement attesting that Goods provided under this contract conform to all contract requirements.
 - CoCT Date

103 ESD Control

The supplier shall have in place the requirements for an ESD program in accordance with MIL_STD_1686 to minimize the effects of ESD on parts, assemblies and equipment.

104 Preservation and Packaging

The item shall be preserved, packed and packaged in accordance with good commercial practice unless otherwise directed by the buyer. The shelf life for delivery preparation shall be 2 years.

105 Manufactured Goods Traceability

Supplier will retain for review upon request applicable documentation (i.e. test reports, shipping reports or certifications to show clear traceability to the manufacturing lot or batch number.

106 Raw Material Traceability

Supplier will retain for review upon request applicable documentation (i.e. test reports, shipping reports or certifications to show clear traceability to the manufacturing lot, heat or batch number.

107 Record Retention

Records and other objective evidence of inspection testing, assembly, and fabrication will be retained by the supplier for a minimum of 7 years after completion of the contract unless otherwise specified. These records shall be identified and stored to enable the records to be readily located and retrieved.



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108 Discrepancies

During supplier performance, any deviations noted from established drawings or specifications must be reported to the Buyer immediately. No deviation will be considered without written confirmation from the Buyer.

109 Supplier Inspection System

The supplier shall document, implement and maintain effective procedures that satisfy the intent of ISO 9001:2015, Quality Management Systems.

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The supplier shall document, implement and maintain effective procedures that satisfy the intent of AS9100D, Quality Management Systems.

111 Serviceable Condition

The items returned for rework shall be reworked so the item shall: (1) be inspected and cleaned to remove any foreign material; (2) pass acceptance test and/or inspection; (3) is free of rust and corrosion; and (4) have no cosmetic deficiencies; (5) defective parts replaced; (6) have the item returned to an original configuration; (7) ensure any loose parts normally supplied with the new component are provided if specified on the purchase order. An acceptance test or inspection report stating compliance to this QC clause and reference to the purchase order, part number and serial number shall be returned with the item. The report shall include the nature of the failure and specific rework performed.

112 Serialization

Parts and /or assemblies will be serialized. The supplier will assign a distinguishing number that is maintained throughout the life of the product and is not reassigned to another unit of the same part number. Assembly, test and final acceptance records will be maintained by the serial number assigned.

113 Test Reports

Supplier will provide one legible copy of actual test reports with each shipment. Reports must contain the purchase order number, part number, the specification and revision and heat and/or lot numbers if applicable. Test reports must contain the signature of the responsible representative performing the test.

114 Identification Marking of Parts

Parts within the assembly, subassemblies, components or kits will be identified and marked per applicable specifications and drawings. If the identification marking is not specified, items shall be marked as follows:

- a. Commercial off the shelf: parts will either be marked directly on the part or on the part's package, carton or container per best commercial practice.
- b. Parts manufactured to specific drawings or specifications: shall be marked in accordance with MIL-STD-130. Small items can be bulk marked or tagged.

115 Product Quality Assurance Representative



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CMS source inspection is required prior to shipment. The supplier shall notify CMS Quality Manager 5 working days in advance of the time the items will be available for inspection. Approval authority is limited to granting approval for shipment of items to the Buyer's facility. Free access will be granted to the source inspector to the facilities and equipment used for inspection and/or testing. Any nonconformances detected will be identified with a corrective action. If the supplier's performance dips requiring source inspection it will be at the supplier's expense. Evidence of the source inspection will be documented by CMS with a copy transmitted to the supplier.

116 Special Processes

Suppliers shall submit their procedures for special processes to CMS QC for review and approval prior to performing any special processes. Any changes to the process such as personnel, parameters or equipment will require resubmittal. Suppliers shall be responsible for special processes subcontracted and have on file and available for review, certifications of special processes performed such as heat treating, welding, anodizing, plating, chemical films, prime/paint and cleaning.

117 Corrective Actions

Acceptance of this Purchase Order obligates the Seller to perform, upon request, a corrective action investigation when discrepant material is received by the Buyer. A written report shall be furnished, within a reasonable time period, which is specific and conclusive to prevent a recurrence of the discrepancy.

118 100 Percent Dimensional Conformance

The supplier shall perform 100 percent inspection and recording of variable (actual) data for each piece of this order. The inspection record shall identify each characteristic the allowable tolerance limits and the actual dimension recorded. The report must also indicate inspection method and type of gauge used. This record shall be submitted with each shipment. Temporary serial numbers shall be assigned if the parts are not serialized.

119 Process Certification

For the initial shipment against a Purchase Order a certification containing the signature and title of an authorized representative for all special processes shall be submitted. If any changes occur per QC 116 a new process certification shall be submitted.

120 Time and Temperature Sensitive Material

Time and temperature storage conditions must be attached to the packing sheet and accompany each shipment to be delivered hereunder. The outermost shipping box must be marked to indicate as such and the Temperature Storage Range in degrees.

121 Calibration

The supplier shall provide calibration certification specifying the supplier's contact details, service type, certificate number, equipment identification, test location, test date, test conditions, test methodology, acceptance limits, relevant standards and calibration results.



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122 Supplier Proof of Calibrated Test and Measurement Equipment

The supplier shall provide a spreadsheet of the test and measurement equipment used and a copy of the current calibration record for all T&ME used for the specified part on the PO and any sub-assemblies tested or measured.

123 Quality Management System

The Supplier shall have a Quality Management System (QMS) that complies with International Organization for Standards AS9100 Rev D and certified by an approved third party accreditation agency. If the Supplier does not meet the above requirements, the Supplier shall develop a Quality Program Plan to document plans and approaches for the implementation of an AS9100 Rev D Quality Management System. The Quality Program Plan shall be submitted to Chenega Manufacturing Services for approval.

124 Fasteners – Grade 5 and Higher

The supplier shall provide a certification of the chemical and physical analysis of a sample of fasteners supplied with each order. The certification shall contain the following:

- (a) Complete actual composition as well as the specification number the material complies with.
- (b) Actual hardness measurement readings
- (c) Actual tensile strength values
- (d) Identity of manufacturer's logos being supplied (logo must be registered with the Defense Industrial Supply Center)
- (e) Country of manufacture

125 Counterfeit Parts

The supplier shall develop and implement a comprehensive counterfeit parts and assembly prevention and control plan to prevent the introduction of counterfeit parts and assemblies into items delivered to Chenega Manufacturing Services.

Counterfeit parts are a part, component, module or assembly whose origin, material, source of manufacture, performance or characteristics are misrepresented. This includes but is not limited to parts that have been marked or remarked to disguise them or falsely represent the identity of the manufacturer. Also included are defective parts or surplus material scrapped by the original manufacturer, and previously used parts reclaimed and sold as new.

In the instance of detection of counterfeit parts by the supplier, CMS is to be notified immediately. Notification is to be flowed down to sub-tier suppliers if applicable.

Acceptance of this purchase order and performance hereunder, the seller certifies that the articles furnished in the quantities indicated and against referenced purchase order were supplied in accordance with this purchase order and contain no counterfeit parts.

126 Weld Inspection

For any welding required by the technical data package, 100% weld inspection (in accordance with the weld specification callout) is required.