

Quality Assurance Specification

Quality Requirements

Scope

This Quality Assurance specification PJ-1037 establishes the specific quality requirements that apply when one or more of the following quality assurance requirements are specified by code on P&J Machining, Inc. purchase orders. These requirements are in addition to those set forth in any contracted document. The provisions indicated herein are an integral part of the order.

Compliance with these requirements does not reduce seller responsibility for furnishing materials and services that fully comply with all applicable drawing(s) and specification(s) requirements, nor does it guarantee acceptance of materials or services P&J Machining. In the event that materials or services are found to be defective and cannot be demonstrated by the seller to be in conformance with the purchase order requirements, P&J Machining shall have the right to reject them.

- QR 1 **GENERAL QUALITY REQUIREMENTS:** The seller shall provide and maintain an inspection system in conformance with Federal Aviation Regulation Part 21.
- QR 2 **INSPECTION SYSTEM REQUIREMENTS:** The seller shall provide and maintain an inspection system in conformance with Specification MIL-I-45208A.
- QR 3 **QUALITY PROGRAM REQUIREMENTS:** The seller shall maintain a quality program in accordance with Boeing Specification D6-82479 and or AS9100 or D1-4426 which ever is applicable.
- QR 4 **CONTROL OF CHANGES:** Seller agrees not to make any changes in materials or design which would affect the part or any component part thereof without prior written buyer approval. The Seller will identify, on the Certificate of Conformance and/or packing slip, the as built revision level of the end item product being delivered.
- QR 5 **SUPPLIER CORRECTIVE ACTION:** Seller shall, on request, on forms designated by buyer, provide statements of corrective action on failures of seller's hardware or quality system. Corrective action statements, at buyer's option, may require approval signature by buyer and Government Quality representatives. All rejected articles resubmitted by seller to buyer shall bear adequate identification including references to buyer's rejection document.
- QR 6 **P&J RIGHT OF ENTRY:** During performance of this contract, Sellers allows Buyer and Buyers customer the right to evaluate seller's facility to review, Quality System, Data, Equipment, all manufactured product for verification, and analysis by Buyer's authorized Representatives. Source Inspection or release of product prior to shipment is not required unless Seller is otherwise notified. A copy of this contract will be furnished to our Customer representative upon request.
- QR 7 **GOVERNMENT RIGHT OF ENTRY:** During performance of this contract, Sellers allows Buyer and Government representative the right to evaluate seller's facility to review, Quality System, Data, Equipment, all manufactured product for verification, and analysis by authorized Government Representatives. Government inspection or release of product prior to shipment is not required unless Seller is otherwise notified. A copy of this contract will be furnished to the Government representative upon request.
- QR 8 **SHELF LIFE AND TEMPERATURE SENSITIVE MATERIALS:** The Seller shall identify all materials and articles which have definite characteristics of quality degradation with age or environment. The Seller shall affix this information directly on the material container or article. This identification shall indicated the date useful life was initiated and the date or cycle at which the useful life will be expended. When environment is a factor in determining useful life, the identification shall include the storage conditions (i.e., temperature, humidity, etc.) required to achieve the stated life. A minimum of 75% of the applicable material/article shelf life shall remain upon receipt of the material by P&J or the material is subject to rejection and return to the seller.

QR 9 PACKAGING: Unless otherwise specified by the item drawing, specification of purchase order, the seller is responsible for assuring that all items are delivered without damage or deterioration and are efficiently and economically packed for the method of transportation and type of handling involved. Unit and intermediate packaging shall be employed as necessary to prevent damage or deterioration.

QR 10 STATIC SENSITIVE MATERIALS: The following requirements apply to materials, devices or assemblies capable of being degraded, damaged or destroyed by static electrical charges or discharges. All items shall be preserved, packaged and packed in such a manner as to preclude their exposure to the generation of discharge of static electrical potential Packaging (including unit, intermediate and shipping containers) shall be clearly marked or labeled to indicated that the contents are subject to damage or degradation by static electricity.

QR 11 MATERIAL SAFETY DATA SHEETS: Material(s) noted on this purchase order must be supplied in accordance with OSHA's hazard communication standard 29CFR1910-1200, OSHA instruction CPL2-2.38 dated August 5, 1985 and Washington state codes 296-62-05413 "Materials Safety Data Sheets". Materials not received in compliance with aforementioned OSHA requirements and Washington State codes will be subject to immediate rejection and return at supplier's expense.

In addition, if Seller is aware of any additional precautions and/or handling techniques instituted with regard to other customers, you are requested to submit those safeguards with MSDS.

Send a Toxic Substances Control Act (TSCA) certification letter to the P&J Buyer for the product(s) purchased on this purchase order with the statement that every chemical component of the product(s) is listed by the Toxic Substances Control Act Inventory (P.L. 94-94-969).

QR 12 IDENTIFICATION: Parts, assemblies and components shall be identified as specified on the engineering drawing. When identification is not specified on the engineering drawing, the product shall be identified with the part number specified on the purchase order. When items are too small to easily identify, they may be bagged and tagged.

Raw material procured to Federal, Military, Aerospace or other specifications shall be marked and identified per the requirements of the identification specification which is referenced in the controlling (i.e. Federal, Military, Aerospace, etc.) specification.

QR 13 CALIBRATION SYSTEM REQUIREMENTS: Seller shall have a calibration system that assures compliance with Military Specification MIL-STD-45662, " Calibration System Requirements." Any deviation or waiver to this requirement must be approved by P&J's Material and Quality Assurance Representatives.

QR 14 STATEMENT OF CONFORMANCE: The Seller shall certify that the product delivered conforms in every aspect to the contractual and technical requirements of the Purchase Order, engineering drawing(s), specifications and standards referenced therein. Where by the P&J Purchase Order, inclusive of all documents referenced therein, parts, materials and processes have been procured from approved sources. The Statement of Conformance document shall be signed by a representative of the Seller.

SHIPMENT DOCUMENTATION:

- (1) Each shipment by the Seller shall be accompanied by a Statement of Conformance in accordance with the above.
- (2) When the items or the items contained within an assembly, sub-assembly or detail part on this Purchase Order are supplied by a distributor, a copy of the Statement of Conformance from the true manufactured must accompany each shipment.

QR 15 MATERIAL TEST REPORTS: A material test report for raw material(s) is required and shall contain the following:

- (1) name/number of the specification with which the material is in compliance.
- (2) The lot, batch, heat lot or other traceable designation (i.e. purchase order number, invoice number, etc.).
- (3) The reports shall contain the actual test results and or indicate the percentage of each element that makes up the chemical and or physical properties of the raw materials(s).
- (4) A statement of conformance to the applicable specification.

SHIPMENT DOCUMENTATION:

Each shipment must be accompanied by a legible unaltered copy of the test report, unless verified and validated by a P&J Quality Assurance Representative at the Sellers facility.

QR 16 CERTIFIED TEST DATA: Certified Test Data is required and shall contain quantitative test results versus quantitative requirements and permissible tolerance(s) for values measured and shall indicate factual information necessary to demonstrate conformance to the requirements reflected on the engineering drawing, governing specification or purchase order.

SHIPMENT DOCUMENTATION:

Each shipment must be accompanied by a legible unaltered copy of the test report, unless verified and validated by a P&J Quality Assurance Representative at the Sellers facility.

QR 17 APPROVED PROCESS REQUIREMENTS: Special processes (i.e. testing, heat treat, nondestructive testing, etc.) when required by the process specification must be performed by sources approved by the customer (process document owner).

The Seller is responsible for assuring that the processing source has in their possession a current customer approval of their processing capability for the processes to be performed, prior to their performing the process.

SHIPMENT DOCUMENTATION:

Each shipment must be accompanied by a legible unaltered copy of the certification form the processing source demonstrating compliance with the specification for the processes performed and that the processor is/was approved by the customer to perform the processes at the time the product was processed. If this certification is verified and validated by a P&J Quality Assurance Representative at the Sellers facility, it may be retained by the Seller.

QR 18 FIRST ARTICLE INSPECTION: The Seller shall perform a First Article Inspection Report (FAIR) on the initial part or lot (as applicable) at the detail, subassembly and/or assembly level. The results of the FAIR shall indicate 100% conformance to engineering drawing characteristics, special processes, functional test and laboratory requirements. The FAIR requirement once invoked continues to apply even after initial compliance. Partial or complete re-accomplishment of the FAIR for affected characteristics is required for the following events:

1. A change in the design affecting form, fit or function of the part.
2. A change in manufacturing source(s), processes, inspection method(s), location, tooling or materials with the potential of affecting fit, form or function.
3. When required as part of corrective action for a part number with repetitive rejection history (typically, a part with three repeated rejections or as required by customer).
4. A change in numerical control program or translation to another media.
5. A natural or man-made occurrence that may adversely affect the manufacturing process.
6. A lapse in production for two years or as specified by customer.

SHIPMENT DOCUMENTATION;

- (1) A copy of the PJ-1019, FAIR shall be sent with each applicable shipment of a part number configuration to P&J.
- (2) All First Article pieces shall be identified as such in the shipment to P&J.

QR 19 REPORT OF DISCREPANCY: Any departure from drawing specifications or other purchase order requirements must be documented by the Seller and submitted to the P&J buyer for consideration and disposition. A copy of this disposition document must accompany each affected shipment.

SHIPMENT DOCUMENTATION:

A copy of the dispositioned document must accompany each affected shipment to P&J.

QR 20 TRACEABILITY/LOT AND BATCH CONTROL: Seller must maintain lot and batch control of raw materials to purchased items. Seller must provide positive traceability of manufactured parts and assemblies to raw materials through the use of lot/batch or serial numbers.

SHIPMENT DOCUMENTATION;

Shipping documents shall identify the lot/batch or serial number, as applicable, for all items in the shipment.

QR 21 P&J MACHINING, INC. SOURCE INSPECTION: P&J Source Inspection is required prior to shipment. The Seller shall notify the Buyer three (3) days in advance. Seller shall, upon request, provide a copy of this purchase contract to the P&J representative serving their plant.

SHIPMENT DOCUMENTATION:

1. Evidence of P&J Source Inspection

(acceptance stamp on shipping document) must accompany each shipment of product to P&J.

2. In the event of a waiver of Source Inspection, in accordance with the above, the "Source Acceptance Waiver Shipment Authorization" Form #PJ-1004 must accompany each applicable shipment of product. P&J Contracts must complete Source Inspection Waiver PJ-1004. After completion of PJ-1004, form is routed to vendor to apply with applicable shipment.

QR 22 MATERIAL CERTIFICATION AVL/QPL SOURCES: Material on this Purchase Order shall be procured from customer approved suppliers as indicated on the applicable customer Approved Vendor Listing (AVL) or Qualified Product List (QPL).

SHIPMENT DOCUMENTATION:

Each shipment of QPL product on this Purchase Order shall include a copy of the QPL listing of the manufacturer.

QR 23 ASSIGNMENT: Neither this purchase order nor any interest therein shall be assigned or transferred without prior written approval of Buyer. Buyer reserves the right, and it may at any time assign this purchase order and any and all rights hereunder to the Government.

QR 24 CANCELLATION: Buyer reserves the right to cancel this order without penalty if prices or deliveries specified by the Seller upon the acknowledgment copy of this order are unsatisfactory or if shipments are not made as promised. Buyer further reserves the right to cancel a portion or all of this order for any reason upon payment of all agreed reasonable costs and a reasonable profit based upon such costs.

QR 25 CONFIDENTIAL: Seller shall not disclose any details connected herewith to any third party without written consent of Buyer.

QR 26 TOOLS AND MATERIALS: The Seller is to furnish all standard tools, taps, dies, cutters, gauges and fixtures. Buyer will furnish special tools for Seller's convenience where these are available, but it is expressly understood that in so doing Buyer makes no guarantee whatsoever as to the accuracy of the tools furnished. By the acceptance of this order, Seller agrees to furnish the items ordered in accordance drawings and applicable specifications. No designs, tools, patterns, or drawings supplied by Buyer to Seller for use in manufacture of articles contracted for herein, shall be used in the production, manufacture or

design of any other articles for any other Buyer nor for the maintenance of production of larger quantities than those specified except with the express consent in writing, of Buyer. At the termination of this contract they, together with all excess materials, shall be disposed of as Buyer shall direct. All such designs, tools, patterns, drawing and materials supplied by Buyer shall be segregated by Seller in Seller's plant, and wherever possible, clearly marked as to be easily identified as belonging to Buyer. Where materials are furnished by Buyer, title to and/or the right of immediate possession of such materials in all stages of construction shall be and remain in Buyer.

- QR 27 **INSURANCE, RISK OF LOSS AND STATUS OF SELLER:** All materials, tools, designs, patterns, drawings, and other personal property belonging to Buyer, furnished by Buyer to Seller shall be at Seller's risk from loss or damage from all hazards, except that Buyer, for Buyer's sole benefit, shall insure such materials, etc., against loss or damage resulting from fire, lightning, cyclone, tornado, windstorm and hail, explosion, earthquake, aircraft or vehicles, smoke, sprinkler leakage, flood, strike, riot, civil commotion, vandalism and malicious mischief, but such insuring shall not relieve Seller from liability for Seller's negligent acts or omissions. All such materials, etc., while in Seller's possession shall be at Seller's sole risk from all hazards, in the event that Seller is required to enter premises owned, leased, occupied by or under the control of Buyer during the performance of services ordered hereunder or during delivery or installation of the materials or articles herein contemplated or during the performance of services otherwise required to be furnished by Seller. Seller agrees that Seller will, before coming upon such premises, obtain and keep insurance coverage indemnifying and holding harmless Buyer, its officers and employees from any liability or loss by reason of property damage or personal injury of whatsoever nature of kind occurring during or as a result of the performance of such services and/or delivery and/or installation. Such insurance shall be in standard form for property damage and public liability and in reasonable limits.
- QR 28 **PURCHASE ORDER LIMITATIONS:** No change or modification on the face of this order or by agreement or otherwise shall be binding upon Buyer until accepted in writing by its authorized representative. The Buyer shall have the right to make changes in drawings, plans, or specifications relating to articles on order or in the place of delivery of said articles, and the Seller shall comply with such changes immediately upon notification thereof. If any such changes causes any increase in the cost of said articles, an equitable adjustment shall be made between Buyer and Seller and the order modified in writing accordingly. All claims for adjustments in prices resulting from such changes must be made within thirty days from notice thereof.
- QR 29 The INCOTERMS 2000 for all orders from Buyer will be Free on Board (FOB) if by ocean and Delivery Duty Unpaid (DDU); otherwise, Boeing will pay for freight per Boeing's standard routing instructions. When Buyer's order requests delivery outside the United States of America, the Import of Record will be the Buyer placing the order. Title and risk of loss shall pass at place of shipment (i.e. for orders shipped directly from a mill, title and risk of loss shall pass when Boeing, or its designee, assume control of the Material; for orders shipped from Boeing, or Boeing's service provider, title and risk of loss shall pass at Boeing, or Boeing's service provider's, shipping dock and Buyer will maintain adequate insurance to cover shipments at the time title and risk of loss transfer to Buyer).