

SUPPLIER QUALITY REQUIREMENTS (SQR'S)

Q01 MANDATORY AMRO SOURCE INSPECTION

When specified on individual Purchase Orders, Amro Source Inspection shall be performed at supplier's facility prior to shipment to Amro, and at required process operations, as directed by Amro.

Q02 OPTIONAL AMRO SOURCE INSPECTION

Amro reserves the right to inspect any and/or all work on this Purchase Order at the supplier's facility. The supplier will be notified in advance of shipping date if Amro source inspection is required. Source package will include all material certifications, applicable weld certifications, applicable outside processing certifications, FAI data, in process inspection data and 100% final inspection data. All source inspection shall be completed prior to packaging. All product shall be readily available for visual and dimensional inspection if applicable.

Q03 OPTIONAL CUSTOMER SOURCE INSPECTION

Amro Customer reserves the right to inspect any and/or all work on this Purchase Order at the supplier's facility. The supplier will be notified of shipping date if Customer source is required.

Q04 GOVERNMENT SOURCE SURVEILLANCE

The Government has the right to inspect any or all of the work included in the Purchase Order at the supplier's facility.

Q05 GOVERNMENT SOURCE INSPECTION

Government inspection is required prior to shipment from the supplier's facility. Upon receipt of this order, promptly notify the government representative who normally services your facility so that appropriate planning for government inspection can be accomplished.

Q06 PRODUCT ASSURANCE SYSTEM REQUIREMENTS

The supplier shall have Product Assurance system and procedures detailing the following minimum requirements:

1. Safety
2. Training / Certification
3. Record retention
4. Traceability
5. Procurement control
6. Manufacturing, fabrication, process control
7. Metrology control
8. Stamp control
9. Non-conforming product control

The supplier's product assurance system is subject to initial survey and approval by Amro and it's Customer. Subsequent surveys or audits, including subtier supplier and processors may be conducted before or after issuance of a Purchase Order. The supplier shall be notified of deficiencies and shall follow-up and ensure that deficiencies are promptly corrected. Corrective action shall be subject to review and approval by Amro's Quality Assurance.



Q07 QUALITY PROGRAM REQUIREMENTS

The seller shall have developed and maintain a quality program in accordance with Mil-Q-9858, including a measuring instrument calibration system in accordance with Mil-Std-45662.

Q08 INSPECTION SYSTEM REQUIREMENTS

The seller shall have developed and maintain an inspection system in accordance with Mil-I-45208, including a measuring system in accordance with Mil-Std-45662.

Q09 NON-CONFORMING DOCUMENTATION

Any deviation to Amro's requirements set forth in this Purchase Order shall be documented and submitted to Amro for disposition prior to product shipment from supplier's facility.

Q10 METROLOGY / ACCURACY

All test and measurement equipment used in the performance of this Purchase Order shall be certified against a standard having greater accuracy. Random and systematic error in any article or material measurement process shall not exceed 10% of the tolerance of the parameter being measured. When ASTM, ASA, ISA, Military Standards or other Aerospace Industry recognized standard test methods are used in physical, chemical, analytical, optical and/or environmental measurement processes, the tolerance ratio established in those test standards shall apply.

Q11 RAW MATERIAL CERTIFICATION

Three legible copies of the material certification as furnished by the raw material supplier shall accompany each shipment.

Q12 CHEMICAL TEST REPORTS

Materials furnished in fulfillment of this order must be accompanied by three legible copies of certified test reports of the chemical properties of the material.

Q13 PHYSICAL TEST REPORTS

Materials furnished in fulfillment of this order must be accompanied by three legible copies of certified test reports of the physical properties of the material.

Q14 CERTIFICATION OF COMPLIANCE

The seller shall include with each shipment legible copies of a certifying statement that attests to the seller's compliance with all the requirements of the Purchase Order. The certificate shall be signed by an authorized representative of the supplier. Certificate of Conformance shall include material certification traceability (Q 28).

Q15 PROCESS / PROCESSOR

Manufacturing and inspection processes and procedures used in the performance of this Purchase Order must be accomplished by process sources and procedures approved by Amro and Amro's Customer.

Q16 SPECIAL PROCESS APPROVAL

Special process suppliers are responsible for compliance to the applicable specifications, including customer special process approval, whether the operation is performed within their facility or by subcontractors.



Q17 PROCESS CHANGE

A change is defined as “any change including personnel, equipment, material, tooling, etc., subsequent to the start of production.” The supplier is responsible for supplying Amro with a list of all personnel performing work on LMET Program and to notify Amro of additions/deletions to this list. Supplier is also responsible for notifying Amro of any intended changes to equipment, material, tooling, etc., and obtaining written authorization for said changes from Amro prior to implementation. Supplier is also responsible to obtain Amro and LMMSS approval in writing to any deviation and/or exception to procurement specification.

Q18 RIGHT OF ENTRY / CUSTOMER ACCESS

Access to your facility (documents, personnel, equipment, material and facilities) shall be made available to Amro Fabricating Corporation, its customers and regulatory agencies, to determine and verify the quality of the work, records, and material.

Q19 SUBCONTRACTING WORK

Seller is prohibited from subcontracting any portion of the work to be performed as specified in this Purchase Order, unless authorized by the buyer in writing.

Q20 RECORDS

Seller shall maintain records of manufacturing and traceability of materials used in the fabrication of the product produced in fulfillment of this Purchase Order. The records shall be maintained for a period of 7 years after completion of the Purchase Order and be made available for review to the buyer upon request.

Q21 SPC FLOW DOWN

Seller shall demonstrate the ability to provide statistical evidence of variability for KEY characteristics. Seller to certify that they have a system capable of meeting Boeing’s D1-9000, AQS, or similar quality requirements.

Q22 SERIALIZATION

Each item furnished on this Purchase Order will be identified with a non-recurring serial number. Where the size of the item prohibits identification, the serial number will be marked on an identification tag or label and be securely attached to each item.

Q23 Digital Product Definition (DPD)

Seller is required to obtain Buyer approval as a DPD-capable supplier if Seller receives, downloads, and/or uses Computer Aided Design (CAD) geometry in any format AMRO furnished digital datasets are reference only (not design or inspection authority) until DPD approval status is obtained

Q24 Digital Product Definition (DPD)

The seller shall have developed and maintain a Digital Product Definition program in accordance with Boeing document D6-51991.



Q25 Supplier Inspection Reporting Requirements

Supplier shall submit with each shipment / delivery of Purchase Order items one copy of an Inspection report. Reflecting 100 percent inspection verification of all drawing characteristics and specify the corresponding actual measurement results. Inspection reports will include Purchase Order number, detail or assembly number as indicated per purchase order. Inspection reports shall include signature and/or stamp of person within your organization performing inspection process.

Q26 DFARS Requirements

DFARS Specialty Metal Clause 252.225-7014 Alt. 1 requirements are applicable to this purchase order.

Q27 Bond Control of AMRO property or material

Supplier shall have a designated area with BOND/ MRB that shall retain AMRO product/ properties or materials.

Q28 Material Traceability

Supplier shall maintain material traceability of all materials used (AMRO FURNISHED) throughout process and delivery. Documents related to all processing shall reference heat lot and material purchase order numbers as applicable throughout all processes on process (Shop Traveler) and Certificate of conformance.

Q29 FOD – Foreign Object Detection

Supplier shall insure the following is applied: A Foreign Object (FO) is defined as a substance, debris or article alien to hardware or system which could potentially cause damage. The object may be foreign to an area or system and may be ingested by, or lodged in a mechanism. Foreign Object Damage (FOD) is defined as any damage attributed to a FO that can be expressed in physical or economic terms, which may or may not degrade the product's required safety and/or performance characteristics. Control of this process is required.