



40504A

SUPPLIER QUALITY REQUIREMENTS (SQR)
Primus addendum to PCC Aerostructures SQR - 100000

Revision J

Approved

Joe Senn

Quality Assurance Director
09/28/2017

Suppliers may request this document through PCC Primus
International Document Control office via FTP portal or Primus
Supplier Quality Representative



REVISION RECORD

The latest issue of this manual may be confirmed by viewing the “Suppliers” web site (address shown on the cover), or by contacting Primus International - Auburn Division buyer

Revision	Date		Revision	Date	Revision	Date
NC	Aug 15, 2011	BY	J	Sept. 28, 2017 by CAWolf		
A	Aug 06, 2013					
B	June 20, 2014					
C	Sept 10, 2014					
D	Sept. 29, 2015					
E	October 7, 2015					
F	Jan. 11, 2016	CAW				
G	July 20, 2016	CAW				
H	Jan. 25, 2017	CAW				
I	Mar. 28, 2017	ART				

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SUMMARY OF CHANGES PAGE

Rev. NC summary of changes: Original Issue

Rev. A : page. 11 portal address inches/mm: pages 12, 13, 14 Third party; page 14 Note: SR-001, -005, -006,-007.-008,-009, -010, page 17 Gulfstream & Latecoere; page 26 URL
Page 31 Cpk 1.0; Verbiage pages 16,19,21,26

Rev. D Page 29, changed the record retention to meet regulatory requirements, removed Joseph Kalupski emails from the body of the process, and added Carol Wyant's email as the quality contact. Changed page 1 to "Joe Senn, Quality Assurance Director" for approver. Added statement to page 23, for Airbus purchasing from Distributors to add manufacturer's certificate of conformance with each shipment.

Rev. E page 21, 2.6 Part Mark Requirements, added label requirements for parts manufactured with or containing "Ozone-depleting Substances". Labels to be compliant with 40 CFR part 82 subpart E.

Rev. F

- Changed "suppliers may access this document via Supplier Portal" to "suppliers may access this document via PCC Primus International Document Control via FTP portal".
- Removed references to the supplier portal from the body of the document.
- Added Boeing Flow down requirements for FOD Prevention, added new contact information for CPARs,
- Added SR-011 for Boeing Commercial product supplier certificate of conformance (PC700 statement),
- Made grammar changes
- Added customer specific Supplier flow down requirement for Airbus AP2131-E

Rev. G

- Complete re-write to remove all aspects covered under SQR – 10000 available through PCC Aerostructures
- This document will only contain Primus Auburn Vendor specific information

Rev. H

- Update HANDLING, STORAGE, PRESERVATION & SHIPPING to include wording about preventions for the risk of comingling product during shipping from the vendor or supplier. Also added verbiage to packaging requirements.

Rev. I

- Added flow down requirements for Boeing End-Items.



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Rev. J

- Removed the following from Customer Specific Requirements-Triumph.
PO NOTES FOR 2016 DELIVERIES:
CURRENT BCA CONTRACT ENDS 07/31/16
THIS PO IS ISSUED TO SUPPORT PRODUCT WITH 2016 & 2017 DELIVERY REQUIREMENTS.
PRICING AND DELIVERY DATES TO BE REVISED UPON FINALIZATION OF NEW CONTRACT BETWEEN BCA &TAS-V



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DOCUMENT OVERVIEW

Supplier's guide to understanding PCC Aerostructures SQR – 10000 covers all general supplier Quality Requirements while this document covers Primus International -Auburn Division quality requirements and expectations as they apply to specific vendors. This document forms a part of Primus International purchase order, unless otherwise specified herein. It contains Primus specific standard quality requirements and helpful general information. This document and applicable SR documents apply to suppliers and all members of their supply chain who furnish product, material, processes, and services. Any conflicts between this document and SQR – 10000, SQR – 10000 takes precedents.

DEFINITIONS:

- **5 Why:** The 5 why's process refers to the practice of asking up to five times why a failure has occurred in order to get to the root cause or causes of a problem (the actual number of why's is not as important as arriving at the root cause).
- **8D:** The 8D process (problem awareness, launch team, contain, diagnose, action, verify, prevent, and closure) is a problem solving method for product and process improvement.
- **APQP:** Advanced Product Quality Planning. Qualitative methodology used to move a product or process from concept to full deployment with emphasis toward customer needs being met.
- **Approved Supplier Status:** see "Supplier Status"
- **Berry Amendment:** The DFARS clause 225.222-7014, Preference for Domestic Specialty Metals requires that any specialty metals incorporated into articles to be delivered to the DoD shall be melted in the United States its possessions or Puerto Rico or in certain qualifying countries.
- **Cause-Effect/Fishbone/Ishikawa/ diagrams:** This approach is used in identifying and organizing the possible causes of a problem. The brainstorming focuses on machine, environment, human, measurement, and method.
- **CA:** Corrective Action
- **CI:** Continuous Improvement
- **Control Plan:** Living document that outlines how inputs/outputs of the process steps are controlled in order for the end product to meet customer expectations.
- **Counterfeit parts:** product that is or contains items misrepresented as having been designed and/or produced under an approved system or other acceptable method. The term also includes approved work that has reached a design life limit or has been damaged beyond possible repair, but is altered and misrepresented as acceptable.

- **Critical Parts:** Any part identified as a key Fatigue Critical, Fracture Critical, and Maintenance Critical, air worthiness or flight safety, with a history of QN's and/or escapes, or identified as critical by the customer.
- **DASP:** Delegated Approved Supplier Program
- **Delegated Supplier:** see "Supplier Status"
- **Disclosure:** A notification by a supplier or processor of a discrepancy on product which has already shipped to PAD or PAD's customer.
- **DSQAR:** Designated Supplier Quality Assurance Representative (certified suppliers only)
- **DoD:** Department of Defense
- **EAR:** Export Administration Regulations. Generally, commercial exports from the United States are covered by the EAR and are administered by the Bureau of Industry and Security (BIS) at the U.S. Department of Commerce.
- **ECN:** Engineering Change Notice.
- **Escape:** Nonconforming product delivered to either a PAD facility or a PAD customer.
- **FAA:** Federal Aviation Administration
- **FAI:** First Article Inspection
- **FAIR:** First Article Inspection Report
- **Flight Safety Parts:** Any part, assembly or installation whose failure, malfunction or absence would cause loss of or serious damage to the aircraft and/or serious injury or death to the occupants.
- **FMEA:** Failure Mode Effect Analysis. FMEA is a risk assessment tool that examines potential product or process failures, evaluates risk priorities, and helps determine counteractive actions to avoid the identified problems.
- **Flow down:** the process of ensuring that all levels of sub-tier suppliers receive ALL detailed information to properly plan, manufacture, process, and ship product. Includes engineering drawings, specifications and quality requirements.
- **FOD:** Foreign Object Debris- Contamination of product by foreign matter such as dirt, unauthorized fluids or oils, chips, grit, machine shavings; or damage such as scratches and dings caused by improper handling or packaging; loose parts or materials such as rivets, nuts, bolt safety wire, washers or tools used in assemblies which can potentially cause failure or damage to the assembly. Unlike similar parts comingled during packaging/handling or transportation.
- **Hold Supplier Status:** see "**Supplier Status**"

- **ITAR:** International Traffic in Arms Regulations
- **Key characteristics:** per SAE AS9103 (ref. section. 3.1).
- **Manufacturing Plans:** A detailed sequential document that defines all operations required to produce product.
- **May:** a clause that contains the verb “may” is strongly recommended.
- **Model:** 3 dimensional electronic representation of a part or assembly.
- **MRB:** Material Review Board.
- **NADCAP:** (formerly National Aerospace and Defense Contractors Accreditation Program) an international standards setting organization for the aerospace and other industries.
- **OEM:** Original Equipment Manufacturer
- **PAD:** Primus International – Auburn Division
- **PQR:** Product Quality Representative.
- **Prime:** Airframe Customer.
- **Processor:** Provides processing outside of normal machining operations.
- **Proprietary products:** products designed by the supplier (ref. section 4).
- **RPN:** Risk Priority Number. A formulated value used in various quality analyses such as an assessment of supplier performance, to quantify risk, to manage the Continuous Improvement process, or to provide insight into the relative value or significance of a particular fault or failure.
- **SHALL:** a clause that contains the verb “shall” is a mandatory requirement (will result in a major audit finding if not in place)
- **Special Processes:** mechanical or chemical operations performed on a part
- **SPC:** Statistical Process Control.
- **Standard Hardware:** A part or material that conforms to an established industry or national authority published specification, having all characteristics identified by text description, National/Military Standard Drawing, or catalog item (ref. AS9102A).
- **Sub-tier:** Any subsequent product/processing or service subcontracted by the PAD purchase order holder (Tier 1).
- **Supplier:** Provides product or service (typically airworthy products for aircraft installation).
- **Supplier Status:** PAD uses following supplier status levels:
 - **Approved:** Suppliers compliance with all Primus International SQA expectations. Purchase orders may be placed with the supplier.
 - **Certified/Delegated:** Approved suppliers who have been authorized to perform product verifications to release their shipments to PAD or other PAD approved destinations. Purchase orders may be placed with the supplier.
 - **Suspended:** Supplier suspended in Primus International – Auburn Division ERP system - Syteline. PAD purchase orders cannot be awarded.
- **Tier 1:** PAD purchase order holder
- **Validate/Validation:** the actual performance of intended use or actual measurement of the final product.
- **Verify/Verification:** the authentication or truth or accuracy by such means as facts, statements, citations, etc.

Correspondence

Any correspondence or Data submitted to Primus International – Auburn Division in support of the requirement contained herein are to be in English.

Documented measurements will be derived using equipment that measures in the original native engineering unit of measure (e.g. engineering dimensions in English must be measured with equipment capable of measuring in inches. Mathematical conversions are not allowed.)

PROJECT SPECIFIC REQUIREMENTS

PART MAKING REQUIREMENTS

Supplier shall mark all deliverable products and documents in accordance with the purchase order, manufacturing planning, or engineering drawing/specifications in that order of precedence.

Note: In the event there is a conflict between the requirements defined below and the engineering drawing and/or specifications, the drawing/specification take precedence.

In addition, supplier shall apply the actual date of manufacture, date code(s) or other control identifier number (see examples below) to all deliverable hardware. Information must be applied adjacent to the hardware's identification markings and must be traceable to Supplier's build documentation. Hardware produced in lots, batches, groups, etc., shall have traceable control information applied. When size of hardware, or Supplier's automated stamping process does not permit data application to individual hardware (such as standard parts), the information shall be similarly placed on bags, tags, or labels as applicable. Examples of traceable information may include, but are not limited to:

- Part Number
- Date of Manufacture
- Serial Number (if Applicable)
- Lot Number or
- Control Number or
- Batch Number or
- Casting Number or
- Work Order Number



Example: 65B011113 (part number as defined on purchase order) 123456 (Primus International assigned supplier code number)
01/30/08 (date of manufacture) 234567 (serial number) 34567 (control number /batch number/work order number/lot number/Casting number/work order number/etc...) and
Verification stamp.

Seller shall label products which contain or are manufactured with ozone-depleting substances in the manner and to the extent required by 42 U.S.C. 7671j (b), (c), and (d) and 40 CFR Part 82, Subpart E.

Definition of an "Ozone-depleting substance," as used in this clause, means any substance the Environmental Protection Agency designates in 40 CFR Part 82 as--

- (1) Class I, including, but not limited to, chlorofluorocarbons, halons, carbon tetrachloride, and methyl chloroform; or
- (2) Class II, including, but not limited to hydrochlorofluorocarbons.

Label products in the manner listed below:

Warning

Contains * _____, a substance(s) which harm(s) public health and environment by destroying ozone in the upper atmosphere.

OR

Warning

Manufactured with * _____, a substance(s) which harm(s) public health and environment by destroying ozone in the upper atmosphere.

* Seller shall insert the name of the substance(s).

Primus requires that the provisions/requirements set forth above be included in Seller's direct supply contracts as well as the obligation that they be flowed to the sub-tier supply chain. For the purposes of this note, the Supply Chain shall mean Seller's direct and indirect suppliers performing value-added activity on the products and services. It focuses on direct and lower-tier suppliers.

The supplier shall also identify all parts with the seven digit Primus International assigned supplier code as noted on the purchase order (i.e., the supplier that is on contract with Primus International directly). Note: Not required for the following:

- Metallic raw materials (Excluding Casting & Forgings if called out in PO)
- Non metallic raw materials
- Mechanical standard parts/hardware
- Electrical components/hardware paints, sealants and chemicals
- Paints, sealants and chemicals.



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SHIPPING & DOCUMENTATION REQUIREMENTS

Note: Supplier's shall not return Primus International furnished material without written direction of Primus International buyer. The material must be accounted for and documented by the supplier on a nonconformance/rejection tag. Material returned to Primus International must include copies of Primus International shipping documents.

Suppliers shall provide a packing sheet for each separate shipment. Packing sheets or attachments shall include the following information:

Minimum Requirements (All Suppliers and Distributors: All Products)

- a) Supplier's company name and address
- b) Primus International's purchase order number, change order number and applicable P.O. Line Item(s) and part numbers.
- c) Denote applicable design drawing revision and applicable engineering changes (ADCN, EO, etc) as stated in Primus International's purchase order, or later revision.
- d) A "Certificate of Conformance (C of C)" document that provides written assurance that all work performed in connection with Primus International's purchase order conforms to purchase order requirements. This can be a separated document from the packing sheet or included on the packing sheet. Note: The original signature and/or stamp of Supplier's authorized Quality representative is required and must be dated. Secured computer generated signature are acceptable. Additionally, the certification statement must state the suppliers Quality Assurance department has inspected the parts and they adhere to all contract requirements, applicable drawings and/or specifications.

Deliverable Documents.

Supplier shall apply the actual date of manufacture, date code(s) to the shipping document and/or "Certificate of Conformance", signed by the Supplier's designated Quality representative. Note: Supplier must clarify the type of information being provided by typing the words "Date Code", "Control Number," etc. next to the information provided. When the shipment of deliverable items includes multiple dates, codes, control numbers, etc., each must be listed on the "Certificate of Conformance" for metallic product will contain hardness and conductivity values

Note: For Boeing Commercial "Designated Parts", each shipment certification shall include the Boeing approval memo number and the date and/or the revision level of the designated manufacturing plan used to produce the Designated Parts.

Sub-tier supplier/Processor Certifications

If Supplier is not the original fabricator, processor or assembly source of the product(s) which make up the deliverable end item(s), supplier shall obtain and retain on file Sub-tier Supplier/Processor certifications and test results. Supplier's Sub-tier Supplier/Processor certifications and test results shall be made available to Primus International upon request

Records Additional Requirements as Applicable:

- a) Serial Number
- b) Interchangeable and Replaceable (I&R) designated control numbers.
- c) Required parts traceability forms associated with Section 2. 10, 2.12 and 2.26 d) Traceable Records. **Supplier shall maintain parts traceability records as required per applicable drawing requirements.** Supplier's Certificate of Conformity package shall include parts traceability data. For Fracture Critical items, supplier certification must include the date and/or revision level of the manufacturing plan used and when the plan was approved.

Purchased completed Part Suppliers, Sheet Metal Part Suppliers, Composite/Nonmetallic Part Suppliers, Casting & Forming Suppliers, and Raw Material Manufacturers.

Supplier shall provide the raw material certifications that were provided by the original mill. Mill certifications shall include conformance with the applicable material specification as noted on Primus International's purchase order, material description, alloy and condition, physical properties, chemical analysis, and heat lot number. If the raw material was purchased from a distributor, include the distributor's certificate of conformance along with the mill certification (Recertification by any means other than by the original mill is not authorized). Castings and forgings procured in support of Primus International Purchases of Machined parts must have documented evidence of Primus International/ Customer qualification acceptance prior to production. All chemical analysis and physical test certifications shall also be provided for castings and forgings. This category also applies to machined/sheet assemblies where the assembly consists of the machine/sheet metal part and standard hardware such as bearings, bushings, nut-plates, and/or sleeves.

Distributors of Standard Parts/ Hardware/Raw Materials

Primus International does not accept raw materials from pass through distributors (Level 3) that have not been procured directly from the manufacture, unless certified copies from the original mill are available or without prior written approval from Primus International.

Purchase of recertified raw material or raw material that has departed from direct control of the manufacturer is prohibited. Attempts to make such sales to Primus International should be grounds for disqualification.

Primus International approved distributors of raw material shall provide certified copies of manufacture's test reports with each shipment.

- c) Primus International classifies a supplier as an approved distributor for a specific manufacturer when the distributor has written authorization from the manufacturer to

responsibility to provide a copy of the manufacture's authorization letter to Primus International upon request.

Distributors shall ensure that Standards, Parts/ hardware/ material is marked in accordance with specifications requirements. Original mill marking shall be affixed and legible on raw materials and shall not show signs of tampering or altering.

Primus International does not accept standard hardware or other items from pass through distributors (Level 3 Quality system approval) unless they are procured directly from the manufacturer or a copy of the original manufacturer certification/test report is provided. In addition, hardware or other items that have been altered by a pass through distributor will not be accepted without prior written permission by Primus International. Distributors wishing to provide "Value Added" services shall be approved to Primus International's Supplier Quality System Survey Level 2 (AS9100 Less Design; See Table 1)

Note: for elements 5 and 6 above Non USA suppliers of raw Materials may not be used without written approval from Primus International Quality, unless the supplier is listed an approved manufacturer in the respective procurement specification. Request for consideration/ deviation can be submitted via email to the PAD Buyer.

Note: Distributors of Airbus products must provide confirmation of compliance to the following Airbus requirement: The Distributor-Stockists shall send the two following Certificates of Conformity with the delivered products and this even if the supplier uses an Airbus approved Distributor-Stockists. 1. The Distributor –stockist's Certificate of Conformity. 2. A copy of products Manufacturer's Certificate of Conformity. (Note: per Airbus requirement AP2190.5 module 3.1.1.3).

Suppliers of Age- Sensitive Materials

Provide original manufacturing/cure date, lot number(s), expiration date or length of shelf life (if indefinite, so state), and any special storage/handling instructions. Note: For age sensitive rubber products, Supplier's "expiration date" or "length of shelf life" data is not required if the cure date and applicable specification number are stamped on the deliverable hardware. Supplier is responsible to determine if acceptance test report submittal is required in accordance with applicable material specification.

Rework/Repair/Replacement/Modified Items

Supplier's Certification of conformance and/or packing sheet (if it contains the C of C statement) document shall reflect the following requirements for rework, replacement, repair or modification of items returned to Supplier, including work performed by Supplier at Primus International's facility.

The item(s) have been reworked, repaired, replaced, or modified (as applicable), in accordance with respective nonconformance documents of Purchase Order.

The item(s) meet the requirements of the engineering document(s). c) The original configuration and qualification status of the item(s) remains in effect (as applicable). d) All applicable nonconformance document numbers or other references to insure traceability.



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FAA Repair

Supplier shall provide a complete serviceable tag with Maintenance Release Statement, FAA Form/Tag 81303 in accordance with FAR, Part 43. Any airworthiness Directives (AD's) or Service bulletins (SB's) required by contract or the FAA shall be documented on the 8130-3, including level of compliance.

Work must be performed by a FAA FAR 145 approved repair station. When requested by Primus International, supplier shall provide a complete copy of the final inspection work order, which details the entire scope of work performed.

Primus International is required to monitor supplier for compliance to the FAA Anti Drug and Alcohol Misuse Prevention Program (AAMPP). When requested by Primus International, supplier agrees to provide objective evidence that employees are being tested as required by the AAMPP.

FAA FAR, part 21 (Certification Procedure for Products and Parts)

Suppliers of new FAA products/parts shall provide documented evidence of traceability to FAR Part 21, Quality System Requirements, with each shipment. Suppliers of approved serviceable replacement parts shall provide with each shipment documented objective evidence of traceability to FAA FAR 21 as outlined by Advisory Circular No.2062 latest revision. Supplied parts shall be airworthy and acceptable for aircraft/aeronautical installations to all specifications called out contractually.

Assemblies/subassemblies

All deliveries must be accompanied with legible Certificate of Compliance (C of C) or equivalent with each kit. The supplier must certify that all material/parts have been processed, inspected and tested in accordance with the purchase order and engineering requirements. The supporting data is on file and will be made available for Primus International review upon request.

Any deviations/waivers associated with material/parts in the assembly are to be listed on the packing slip/ C of C along with the affected part number.

A first article inspection (per section 2.8) is required against the assembly part number as well as each individual part within the assembly. Note: Only the assembly level FAI is required to be entered in Net-Inspect. Detail parts within the assemblies require FAI's in accordance with AS9102.

Note: Any additional Data package requirements will be itemized on the respective Purchase Order and/or associated planning configuration sheet.

INTERCHANGEABILITY AND REPLACEABILITY (I&R) REQUIREMENTS

Supplier shall review Primus International's purchase order and associated drawing(s) to determine if Interchangeability & Replace-ability (I & R) features apply to Supplier's deliverable hardware and/or statement of work.

I & R records shall be maintained by Supplier and made available for Primus International's review upon request. Supplier's packing sheets and/or attachments must include the Primus International designated I & R control numbers as specified in the purchase order's configuration statement of work.

MANUFACTURING PLAN SUBMITTALS FOR CRITICAL PARTS

Note: "Critical Parts" are parts identified on engineering drawing as Fracture, Durability, Fatigue, Maintenance, as well as designated parts, Flight Safety Critical, and Identifiable parts.

Supplier shall submit to Primus International at least 30 days prior to start of Manufacturing plans requiring Primus International and/or Primus International Customer approval per specification/purchase order requirement shall be submitted to Primus International at least 30 days prior to start of production, or as required by applicable specification. Manufacturing plans shall be submitted to Primus International – Auburn Division (PAD) for review and approval through their respective PAD buyer.

The manufacturing plan shall contain fabrication, processing, processor name, and inspection steps in the sequential order required by the applicable process specification(s) and/or engineering drawing(s). This shall also include all sub-tier associated manufacturing and/or process plans.

Upon approval of supplier's manufacturing plan, Supplier shall control all manufacturing, processing, testing and inspections as stated in the approved plan. No deviations, including Supplier's sub-tier suppliers/processors, are permitted without Primus International's – Auburn Division (PAD) written authorization.

Delivery of product is not permitted until Supplier has received Primus International approvals.

Suppliers shall ensure compliance with the following additional requirements:

Customer Specific Requirements

AIRBUS

Suppliers are required to use Airbus approved processors for the processes requiring Airbus Approval by the appropriate specification. The list of processes requiring approval can be found in the specification "MASTERLIST ME0721033. The list of Approved processors (QSPL) is located at <http://www.airbus.com/tools/airbusfor/suppliers/>. The supplier shall meet the quality requirements of AIRBUS GRAMS Requirements AP2190. Airbus specifications and material QPL are located on the primus supplier portal.

If supplier is selected as a Key Contributing parties for the Airbus Program that is identified on the Purchase Order, the supplier must meet the requirements of AP2190 Appendix A & B of this document.

CH-60 PROGRAM (SIKORSKY)

The requirement of Sikorsky Aircraft document ASQR01 is applicable in its entirety. The latest revision posted by Sikorsky at the time of Purchase Order acceptance will apply, the document is available at the following URL:

<http://suppliers.utc.com/sqd/ASQR/index.htm>

787 PROGRAM (BOEING)

In addition to the Quality System requirements identified in Table 1, the following additional requirements apply to all Purchase Orders that the sub-tier must be MBD/DPD (D6-51991 document) approved prior to accepting the purchase order. If the supplier is not MBD/DPD approved by PAD, they must request an IGES file with an Inspection plan before they can proceed with the purchase order, unless have prior approval by PAD's Supplier Quality Manager.

Suppliers to Primus International – Auburn Division (PAD) shall be capable of CATIA 5 data transfer and conversant in GD&T dimensional tolerance. Unless contractually stated otherwise, the Suppliers to Primus International Aircraft shall be responsible for creating the necessary tools and media for manufacturing and inspection from the data transferred engineering model.

BOEING END-ITEMS

When supplying product to Primus Auburn where Boeing is the end-product customer, the Boeing Purchase Order Notes listed below must be met as applicable for the work being performed. The Purchase Order Notes can be found at the following link:

<https://suppliers.boeing.com/PONOTES/index.asp?Page=Home>.

If you are unable to access the link above, please contact Primus Purchasing or Quality departments to obtain the detailed requirements. It is the responsibility of the supplier to ensure the current requirements are available at the time the Primus Purchase Order was accepted by the supplier.

Boeing PO Note:	Subject:
A17	Export Control
C35	Import Control
Q09	Quality Records
Q13	Certificates of Conformance
Q15	First Article Inspection (AS9102)
Q29	Boeing Form X31764 Compliance
Q31	Boeing's Production Certificate 700
Q47	Maintenance, Repair & Overhaul
Q48	Use of Net-Inspect for First Article Inspection
Q49	FAA-PMA Part Marking
R04	Boeing Approved Planning
S68	Boeing and/or FAA Right of Entry
S78	Rework Acceptance
T88	Ozone Depleting Substances
U40	Notification of Escapement

CESSNA PROGRAMS

Suppliers are required to use Cessna approved processors for the processes requiring Cessna Approval. The list of processes requiring approval can be found at www.supplier.cessna.com

Suppliers must be aware that certain Cessna raw material specifications have a qualified parts list. Material procured to these specifications must be procured from approved sources, listed in the applicable specification.

First article Inspection (FAI) data shall be entered into Net-Inspect- Reference paragraph 2.8 of this document for further FAI instructions.

Suppliers with delegation programs for procured product must meet the requirements of AS9015, Supplier Self Verification Process Delegation Programs. This standard must be flowed down to all levels of the supply chain.

GOODRICH LANDING GEARS (GLG)

Suppliers are required to use approved suppliers for processing and raw material in Goodrich Landing Gears (GLG) Document 300 Appendix A Certified Supplier Listing. Quality system must be in compliance with GLG Document 300.



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LATECOERE "421Z" PARTS

Suppliers are required to use approved supplier for processing and raw material per D14426 Boeing Approval Report. For some special processing supplier are required to refer Latecoere qualified Special Process List per Q0195QR and Q0298QR.

BOMBARDIER "EMCM 001"

Suppliers are required to use approved supplier for processing and raw material. For raw material refer 'EMCM 001' and for processing refer 'Approved Supplier List'.

TRIUMPH

Supplier shall (a) comply with AS9100 (current version) and (b) continue to be bound by and shall adhere to the terms and conditions set forth on the Supplier Agreement with the Boeing Company with respect to these goods (Agreement No 65225- 1492). The terms and conditions within The Boeing Company / Supplier Agreement take precedence over the terms and conditions referenced within this order.

GENERAL INFORMATION

PURCHASE ORDER TERMS AND CONDITIONS

Primus International "Contract terms and Conditions" information which describe Primus International's purchase order requirements are available via the supplier's Primus procurement agent/buyer.

HANDLING, STORAGE, PRESERVATION, AND SHIPPING:

Foreign Object Debris (FOD):

Suppliers shall have a written procedure which addresses elimination of Foreign Object Debris (FOD), reference NAS 412 as a guideline.

Minimum requirements shall include:

- Review of design and manufacturing process
- Performance measurement
- Training
- Material handling and part preservation

- Preventative measures will be taken to prevent comingling of similar parts. Visual aids may include separate packaging of each lot, with traceability information on the outside of each lot packaged, closed boxes or containers, one PO line item per box, separate pallets for similar parts, and may include interim part marking of parts or packaging, color coded labels to keep similar parts segregated, and to maintain separation and traceability to build documentation. Comingled similar parts may be considered as nonconforming and FOD.
- Housekeeping
- Tool and hardware accountability
- Work is accomplished in a manner to prevent FOD
- PAD has the right to perform FOD audits
- Supplier shall perform periodic self-assessments
- Physical entry control into FOD controlled areas
- Flow down requirement to sub-tiers- For Boeing Commercial Product: FOREIGN OBJECT DAMAGE/DEBRIS AND PRODUCT PROTECTION & PRESERVATION REQUIREMENTS, SELLER shall establish specific requirements and procedures for the control of Foreign Object Debris/Damage, and shall have controls which are being implemented to ensure cleanliness of work areas. These requirements and procedures must have its basis and encompasses all the elements found in the Aerospace Industries Association (AIA) National Aerospace Standard (NAS) 412 entitled FOREIGN OBJECT DAMAGE / FOREIGN OBJECT DEBRIS (FOD) PREVENTION or equivalent as determined by Boeing Supplier Quality Assurance. This FOD control program must extend to components and assembly storage, workshops and if present, hanger facilities. Boeing may request that metrics be established for tracking performance of resolution of FOD non-conformances and non-compliances and the results of the disposition of the non-conformances and non-compliances.
- SELLER shall also establish specific requirements and procedures for the protection and preservation of product.
- The SELLER shall preserve and protect the product during internal servicing process and delivery to the intended destination in order to maintain conformity to requirements. As applicable, preservation shall include identification, handling, packaging, storage and protection. Preservation shall also apply to subcomponent parts of a product. Items intended for maintenance shall be segregated from those items not intended for maintenance use or from new or serviceable product.
- Preservation and protection of product shall also include and where applicable in accordance with product requirements provisions for cleaning, FOD prevention including detection, and removal of foreign objects, special handling for sensitive products, marking and labeling including safety warnings, shelf life control and stock rotation, and special handling for hazardous materials.

Electro Static Discharge sensitive material:

Suppliers delivering Electro Static Discharge sensitive product shall ensure its protection during the manufacturing process and identification per MIL-STD-1686 and ESD packaging for delivery (connector caps, bags, and bubble sheets) per MIL-STD-2073 and MIL-HDBK-263.

Protection of sensitive surfaces:

Machined parts with finished or semi-finished unprotected (not plated) surfaces will be delivered with these surfaces covered with protective oil. All threaded items shall have thread protection. Caps or equivalent protection will cover external threads.

Packaging Specifications:

- Preventative measures will be taken to prevent comingling of similar parts. Visual aids may include separate packaging of each lot, with traceability information on the outside of each lot packaged, closed boxes or containers, one PO line item per box, separate pallets for similar parts, and may include interim part marking of parts or packaging, color coded labels to keep similar parts segregated, and to maintain separation and traceability to build documentation. Comingled similar parts may be considered as nonconforming and FOD.

The packaging of product shipped to Primus International – Auburn Division (PAD) shall ensure minimum protection from transit damage:

Reference ASTM-D9351-98 for “Standard Practice for Commercial Packaging”

Reference MIL-STD-2073-1D for “Standard Practice for Military Packaging”