



AUBURN
701 Milwaukee Ave N
Algona, WA 98001

SUPPLIER QUALITY REQUIREMENTS

PCC Auburn's Addendum to
PCC Aerostructures SQR-10000

Approved: 4/5/2022

By: Zach Ballantyne
Manager – Quality, Engineering, Continuous Improvement

Suppliers may access this document through the link below or by making a request to PCC Auburn's Procurement Team to have a copy sent.

[PCC Aerostructures - Auburn](#)

The information and requirements contained within this document are for PCC Aerostructures – Auburn only. The responsibility for control and maintenance of this information lies with the individual listed on the cover page.

PROPRIETARY RIGHTS: PCC Aerostructures – Auburn (“PCC Auburn” or “Auburn”) proprietary rights are retained for the information contained herein. Through acceptance of the Purchase Order the recipient agrees that neither this document, nor the information contained herein in part or in whole, shall be reproduced or transferred to any other document, and that it shall not be used or disclosed to others for any purpose except as specifically authorized in writing by PCC Auburn.

CORRESPONDANCE: Any information or data submitted to PCC Auburn in support of the requirements 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 permitted.)

Table of Contents:

1. **Document Overview**
2. **Definitions**
3. **Project Specific Requirements**
 - 3.1. Part Marking
 - 3.2. Shipping & Documentation
 - 3.3. Additional Records Requirements
 - 3.4. Time-Sensitive Materials
 - 3.5. Rework, Repair, Replaced or Modified Items
 - 3.6. FAA Repair Product
4. **Customer Specific Requirements**
 - 4.1. Airbus
 - 4.2. Boeing
 - 4.3. Bombardier
 - 4.4. Cessna
 - 4.5. Goodrich Landing Gears (GLG)
 - 4.6. Latecoere
 - 4.7. Sikorsky CH-60 Program
 - 4.8. Spirit
 - 4.9. Triumph
5. **General Information**
 - 5.1. Electrostatic Discharge (ESD) Sensitive Material
 - 5.2. Protection of Sensitive Surfaces

1. DOCUMENT OVERVIEW

PCC Aerostructures Supplier Quality Requirements Manual (SQR-10000) covers all general Supplier Quality requirements, while this document addresses requirements and expectations specific to PCC Auburn and its Suppliers. This document forms a part of the Purchase Order unless otherwise specified herein. The requirements contained herein apply to all Suppliers (as applicable) and all members of their supply chain who furnish product, material, processes or services for the purpose of fulfilling the Auburn purchase order requirements. Should any conflict between this document and the SQR-10000 document occur, the SQR-10000 document shall take precedence.

2. DEFINITIONS

- **Critical Parts:** See *PCC Aerostructures SQR-10000, 7.3.*
- **DSQAR:** Designated Supplier Quality Assurance Representative (certified suppliers only)
- **FAA:** Federal Aviation Administration
- **FAI:** First Article Inspection
- **FAIR:** First Article Inspection Report
- **Flight Safety Parts:** See *PCC Aerostructures SQR-10000, 7.3.*
- **Manufacturing Plan:** A document that defines all sequential operations required to produce product.
- **Model:** 3-dimensional electronic representation of a part or assembly.
- **Processor:** Provides processing of material or product outside of normal machining operations.
- **Special Processes:** mechanical or chemical operations performed on a part where the resulting output cannot be verified by subsequent monitoring or measurement.
- **Standard Hardware:** See *PCC Aerostructures SQR-10000, 7.10.*
- **Sub-tier Supplier:** Any subsequent product/processing or service provider subcontracted by the PCC Auburn purchase order holder (“Supplier”).
- **Supplier:** PCC Auburn purchase order holder.

3. PROJECT SPECIFIC REQUIREMENTS

3.1. Part Marking

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

Supplier shall apply the actual date of manufacture, date code(s) or other control identifiers (examples below) to all deliverable material, products or hardware. Traceability information must be applied adjacent to the product identification markings. When the size of the product does not permit data application directly to the product (such as small standards), the required information shall be similarly placed on bags, tags, labels or packaging as applicable.

Examples of traceable information may include, but are not limited to:

- Part or Item Number
- Date of Manufacture
- Serial Number(s) if and when applicable
- Work Order/Lot/Batch/Control/Heat Lot Numbers
- Casting/Forging Number

Supplier Code

The supplier shall also identify all parts with the seven digit PCC Auburn assigned supplier code as noted on the purchase order (i.e., the supplier that is on contract with PCC Auburn 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.

3.2. Shipping & Documentation

Supplier shall supply required material, testing, and processing certifications with each shipment as applicable.

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.

PCC Auburn Provided Material

Suppliers shall not return PCC Auburn furnished material without written direction of PCC Auburn buyer. The material must be accounted for and documented by the supplier on a nonconformance/rejection tag. Material returned to PCC Auburn must include copies of PCC Auburn shipping documents.

3.3. Additional Records Requirements

As noted on the purchase order or engineering, examples of additional requirements are:

- Serial Number
- Interchangeable and Replaceable (I&R) designated control numbers.
I&R records shall be maintained by the Supplier and made available for PCC Auburn's review upon request. Supplier's packing sheets and/or attachments must include the PCC Auburn designated I&R control numbers as specified in the purchase order's configuration statement of work.
- Required parts traceability forms.
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.
- Controlled Planning
Suppliers shall submit to PCC Auburn at least 30 days prior to the start of manufacturing, any plans requiring PCC Auburn or Customer approval per specification or purchase order. The manufacturing plan shall contain fabrication, processing and processor name, inspection steps in sequential order as required by the applicable process specifications and/or engineering drawings. This shall also include all sub-tier associated manufacturing and/or

processing plans as applicable. Delivery of product is not permitted until supplier has received PCC Auburn approval. Upon approval, the supplier shall control all aspects of the approved plan. No deviations, including sub-tier suppliers/processors are permitted without prior authorization.

Casting & Forgings

Castings and forgings procured in support of PCC Auburn purchases of machined parts must have documented evidence of PCC Auburn/Customer qualification acceptance prior to production. All chemical analysis and physical test certifications shall also be provided for castings and forgings.

Distributors

PCC Auburn does not accept raw materials, standard hardware, or other items from pass through distributors that have not been procured directly from the manufacturer, unless certified copies from the original mill/certifications/test reports are available or without prior written approval from PCC Auburn.

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 PCC Auburn should be grounds for disqualification.

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

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.

Distributors wishing to provide "Value Added" services shall be approved to Primus International's Supplier Quality System Survey Level 2 (AS9100 Less Design).

3.4. Time-Sensitive Materials

Suppliers of time-sensitive materials shall provide the 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 time-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 specifications.

3.5. Rework, Repair, Replacement, or Modified Items

The 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 PCC Auburn'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).



- The original configuration and qualification status of the item(s) remains in effect (as applicable).
- All applicable nonconformance document numbers or other references are attached to ensure traceability.

3.6. FAA Repair

The 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 PCC Auburn, supplier shall provide a complete copy of the final inspection work order, which details the entire scope of work performed.

PCC Auburn 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.

4. CUSTOMER SPECIFIC REQUIREMENTS

Suppliers shall ensure compliance with the following requirements as applicable.

4.1. Airbus

Suppliers are required to use Airbus approved processors for the processes requiring Airbus Approval by the appropriate specification.

The supplier shall meet the quality requirements of AIRBUS GRAMS Requirements AP2190. If the supplier is selected as a Key Contributing party 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.

4.2. Boeing

- End-Items
When supplying product to PCC 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>.

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

- 787 Program
In addition to the Quality System requirements, the sub-tier must be MBD/DPD approved prior to accepting the purchase order. If the supplier is not MBD/DPD approved, they must request an IGES file with an inspection plan before they can proceed with the purchase order.
Suppliers shall be compliant with the requirements of D6-51991. Unless stated otherwise, suppliers to PCC Auburn shall be responsible for creating the necessary tools and media for manufacturing and inspection from the data transferred engineering model.
- Designated Parts
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.

4.3. Bombardier

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’.

4.4. Cessna

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.

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.

4.5. 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.

4.6. Latecoere

For 421Z parts, Suppliers are required to use approved suppliers 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.

4.7. Sikorsky CH-60 Program

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.

4.8. Spirit

Supplier shall adhere to MAA1-10042-1, Supplier Quality Assurance Manual.

Suppliers are required to document and complete all First Article Inspections in accordance with AS9102, MAA1-10042-1, and MAA100-2-2.

Suppliers utilizing digital product definition shall adhere to MAA1-10009-1.

4.9. 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.

5. General Information

5.1. Electrostatic Discharge Sensitive Material

Suppliers delivering Electrostatic 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.

5.2. 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 as required per applicable engineering and/or specifications.

All threaded items shall have thread protection. Caps or equivalent protection will suffice for external threads.

REVISION RECORD:

Rev.:	Date:	By:	Rev.:	Date:	By:	Rev.:	Date:	By:
NC	15-Aug-2011	BY	I	28-Mar-2017	ART			
A	6-Aug-2013		J	28-Sep-2017	CAW			
B	20-Jun-2014		K	5-Apr-22	SNL			
C	10-Sep-2014							
D	29-Sep-2015							
E	7-Oct-2015							
F	11-Jan-2016	CAW						
G	20-Jul-2016	CAW						
H	25-Jan-2017	CAW						

SUMMARY OF CHANGES:

- NC: Original Issue.
- A: Page 11 – portal address inches/mm; Page 12-14 – Third party; Page 14 – Note SR-001, SR-005, SR-006, SR-007, SR-008, SR-009, SR-010; Page 17 – Gulfstream & Latecoere; Page 26 – URL; Page 31 – Cpk 1.0; Pages 16/19/21/26 – verbiage.
- D: Page 29 – Changed the record retention to meet regulatory requirements. Removed Joseph Kalupski emails from the bod of the process, and added Carol Wyant’s email as the quality contact. Change 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.
- 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.
- 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 requirements for Airbus AP2131-E
- 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.
- 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.
- I: Added flow down requirements for Boeing End-Items.
- 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



AUBURN
701 Milwaukee Ave N
Algona, WA 98001

PRODUCT WITH 2016 & 2017 DELIVERY REQUIREMENTS. PRICING AND DELIVER DATES TO BE REVISED UPON FINALIZATION OF NEW CONTRACT BETWEEN BCA & TAS-V.

- K: Updated logo. On cover page, revised "SQR-100000" to "SQR-10000". Changed "Primus International – Auburn Division" to "PCC Aerostructures – Auburn" in all cases. Updated document owner. Otherwise full re-write to remove redundancies covered by PCC Aerostructures' SQR-10000. Full re-format.