

Purchase Order Quality Codes
KII-600-9, Revision November 1, 2018

Supplier Quality Requirements Manual SQR - 10000 is at <http://www.pccaero.com/suppliers/quality-documents/klune-north-hollywood/>

Klune Form-KII-600-9 Quality Codes is at <http://www.pccaero.com/suppliers/quality-documents/klune-north-hollywood/>

Terms and Conditions of Purchase is at <http://www.pccaerostructures.com/suppliers/#docs>

Klune KII-600-11 Purchase Order Terms Conditions, Klune KII-600-11 PO Attachment CFM (Customer Furnished Material) are cancelled.

The following Quality Clause are cancelled and replaced by SQR - 10000:

Q2 Government Source Inspection,	Q15A Soldering Certification,
Q3 Government and or Customer Right of Entry,	Q15B Welding Certification,
Q5A Inspection System Requirements,	Q16 ESD Program,
Q5B Quality Requirements,	Q17 Klune Source Inspection,
Q6A SPC, Q6A1 SPC Plans,	Q18 Preservation / Packaging,
Q6B SPC Program Approval,	Q21 Right of Entry,
Q6C Inspection Sampling Plan,	Q22 Identification,
Q7 Calibration System,	Q28 Special Process Approval Flow down,
Q8 Part / Lot Traceability,	Q29 Approved Supplier,
Q8A Inspection Data,	Q31 Flight Safety Critical,
Q8B Lot Serialization,	Q34 Fastener Quality Act,
Q8C Part / Lot Traceability,	Q35 Grain Direction,
Q8D Mechanical / Electrical Testing and Associated Data,	Q39 Process Change Control,
Q10 Certification of Compliance,	Q40 Non-Conforming Material,
Q10A Klune Supplied Certificate of Conformance,	Q41 Subcontracting By Supplier,
Q11 Certified Physical and Chemical Test Reports,	Q42 Unauthorized Changes,
Q11B Special Process Certification,	Q43 Customer / Government Furnished Property Administration and Flow Down,
Q11C Functional Test,	Q44 Foreign Object Debris (FOD) Program,
Q12 Cure Dates,	Q45 Preference for Domestic Specialty Metals,
Q13 Expiration Date,	Q47 Outside Calibration Source Requirements,
Q13A Material Safety Data Sheet (MSDS),	Q48 Goodrich Approved Processor,
Q14 Catalog Information,	Q50 Nadcap Approved Processor,
	Q51 Counterfeit Parts Prevention

General applicable Purchase Order Quality Clauses are Q9 and Q36. Also, see SQR - 10000.

Boeing product applicable Purchase Order Quality Clauses include but are not limited to D1-4426 Appendix D and Klune Quality Clauses Q9, Q32, Q33, Q36, Q37, Q38, Q44B, Q46, Q52, Q53, Q54, Q55 and Q56. Also, see SQR - 10000.

Lockheed product applicable Purchase Order Quality Clauses include but are not limited to Q49, Q9, Q46, Q52 and Q54. Also, see SQR - 10000.

UTAS product applicable Purchase Order Quality Clauses include but are not limited to Q56

Q9 First Article Inspection - First Article Inspection (FAI) required per AS9102 for the first part of the initial production run.

A new or delta First Article will be required in the following cases:

- 4.1 d this process shall be repeated, when changes occur that invalidate the original results (e.g., engineering changes, manufacturing process changes, tooling changes).
- 4.6 Partial or Re-accomplishment of First Article Inspection
 - f) The organization shall perform a full FAI or a partial FAI for affected characteristics, when any of the following occurs:
 - 1. A change in the design characteristics affecting fit, form, or function of the part.
 - 2. A change in manufacturing source(s), process(es), inspection method(s), location of manufacture, tooling, or materials that can potentially affect fit, form, or function.
 - 3. A change in numerical control program or translation to another media that can potentially affect fit, form, or function.
 - 4. A natural or man-made event, which may adversely affect the manufacturing process.
 - 5. An implementation of corrective action required to complete a previous FAI
 - 6. A lapse in production for two years shall require an update for any characteristics that may be impacted

Also, see **SQR - 10000**.

NOTE: For Lockheed Martin Aeronautics related products, all requirements of Lockheed Quality Clause Q2A apply see <https://www.lockheedmartin.com/en-us/suppliers/business-area-procurement/aeronautics/quality-requirements/clauses.html>

Q32 Boeing Hardware - All hardware purchased on this purchase order shall be obtained as applicable from a Boeing Qualified Products List (QPL).

Distributors of Hardware and Material, Ink, Primer, Fastener are used based on the distributors' ability to conform to an AS/EN/JISQ 9100, or AS/EN/SJAC 9120 quality management system. (Ref D6-82479)

If a distributor is used the distributor shall provide chain of custody traceability back to the Boeing QPL manufacturer.

Q33 Boeing Approved Processor - All processing on this purchase order shall be in accordance with D1-4426 Boeing Approved Process Sources.

Q36 Proper Revision Level - All items produced for this purchase order shall be of the same revision listed on the purchase order. In the event there is a conflict between the revision stated on the purchase order and the revision on the print supplied, immediately notify the Klune Buyer for resolution. If the specification revision is not stated the latest revision shall be used. Certificates of Conformance are to list the specification revisions and all applicable PSDs.

Q37 Boeing D6-82479, AS9100, AS9120 Flow down - The supplier is required to be AS9100 or AS9120 (latest revision) for work performed on this purchase order.

The following is for reference. Go to the website for the latest revision.

D6-82479, Appendix D

This appendix describes the quality management system requirements for Boeing suppliers as contained in 9120*. Appendix D represents the aviation, space and defense organizations quality management system standard for contracted distributors carrying out the purchase, storage, splitting or sale of products without affecting the original manufacturer's product characteristics or conformity.

Boeing Appendix D distributors must be 9120*, "Quality Management Systems - Requirements for Aviation, Space and Defense Distributors" certified by an accredited CB listed in the IAQG OASIS database http://www.sae.org/?PORTAL_CODE=IAQG

Sellers that perform or outsource manufacturing/fabrication, product installation, servicing, additional inspection or test, physical re-identification, product assembly, and/or kitting processes must conform to Appendix A.

9100** certification by an accredited CB listed in the IAQG OASIS database is an acceptable alternative to 9120* certification.

***Note:** 9120 includes all IAQG sanctioned standards including but not limited to AS9120, EN 9120 and SJAC 9120

****Note:** 9100 includes all IAQG sanctioned standards

Q38 CAD, CAM, DPD, MBD Quality System Flow down - Supplier is required to be Boeing approved to D6-51991 (latest revision), CAD, CAM, DPD, MBD Quality System Requirements, for work performed on this contract. Proof of approval is required.

Q44B FOD Program Foreign Object Debris/Foreign Object Damage (FOD) Prevention Requirements for Boeing Suppliers D6-85622 - Klune's suppliers and their sub tiers shall ensure work is accomplished in a manner preventing FOD per **D6-85622**

Q46 Standard Hardware for Government Programs - DFAR 252.225-7009 Restriction on Acquisition of Certain Articles Containing Specialty Metals https://www.acq.osd.mil/dpap/dars/dfars/html/current/225_70.htm#225.7000 flow down (all tiers) of this FAR clause are essential in the performance of this contract. The standard hardware supplier, distributor, or manufacturer (hereafter "supplier") shall supply a certification statement to Klune that the standard hardware they have supplied, distributed, and or manufactured is compliant to DFAR 252.225-7009. Supplier shall certify that the hardware supplied contains specialty metals *ONLY* from the United States of America or a qualifying country as listed in subsection DFAR 2.52.225-7001 of the Defense Federal Acquisition Regulation Supplement. Failure to include the substance of the required certifying statement will deem the subject hardware unusable for the product for which it is intended and shall result in return of the subject hardware.

Q49 Lockheed Aeronautics Approved Processor (Appendix QJ) - Processing to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company purchase order and shall be accomplished in accordance with process specifications on this purchase order and the revision in effect as of the date of this PO of Lockheed Martin Aeronautics Company Appendix QJ. All requirements of such Appendix QJ paragraph F shall be accomplished.

Appendix QJ is located at http://www.lockheedmartin.com/us/aeronautics/materialmanagement/scm-quality/scm-quality_qualityappendices.html).

The following is for reference. Go to the website for the latest revision.

Appendix QJ, Section F. Certificate of Conformance (C of C) Requirements

1. The QCS-001 Processing Source shall prepare a Certificate of Conformance ("C of C") asserting that the Items contained within this shipment are in total compliance with the requirements of this PO. A copy of the C of C shall be included in the delivery package, with process specification exceptions (e.g. pre-clean, stress-relief/bake, etch, etc.) annotated on the C of C.
2. The Process Source C of C prepared for each shipment shall include the following data elements / information:
 - a. Title, specification number (including revision letter) and QCS-001 process code of the process
 - b. Name and address of the process facility,
 - c. Buyer's assigned processor number,
 - d. Date the C of C was issued,
 - e. Purchase order and purchase order part number,
 - f. Quantity of parts (to include quantity accepted/ rejected),
 - g. Signature and title of authorized quality agent of Process Source,
 - h. Fracture durability classification or serialization per customer PO.

Q52 Prohibition on Acquisition of United States Munitions List Items from Communist Chinese Military Companies -

DFAR 252.225-7007 <https://www.acq.osd.mil/dpap/dars/dfars/html/current/252225.htm#252.225-7000>

The following is for reference. Go to the website for the latest revision.

As prescribed in 225.1103(4), use the following clause:

PROHIBITION ON ACQUISITION OF UNITED STATES MUNITIONS LIST ITEMS FROM COMMUNIST CHINESE MILITARY COMPANIES (SEP 2006)

(a) *Definitions.* As used in this clause—

“Communist Chinese military company” means any entity that is—

- (1) A part of the commercial or defense industrial base of the People’s Republic of China; or
- (2) Owned or controlled by, or affiliated with, an element of the Government or armed forces of the People’s Republic of China.

“United States Munitions List” means the munitions list of the International Traffic in Arms Regulation in 22 CFR Part 121.

- (b) Any supplies or services covered by the United States Munitions List that are delivered under this contract may not be acquired, directly or indirectly, from a Communist Chinese military company.
- (c) The Contractor shall insert the substance of this clause, including this paragraph (c), in all subcontracts for items covered by the United States Munitions List.

DFARS 252.225 is at
<https://www.acq.osd.mil/dpap/dars/dfarspgi/current/index.html>

Q53 Boeing H900 - The terms and conditions of H900 apply to this purchase order.

H900 is located at Doing Business with Boeing, under Quality Clauses (located under Terms, Conditions & Provisions), under Common Clauses, under HXXX General Legal/Flow down http://www.boeingsuppliers.com/idscommon/clauses/clause_h.htm

The following is for reference. Go to the website for the latest revision.

H900 includes:

A General Requirements: 1 Buyer's Use of Data and Information, 2 Order of Precedence, 3 Subcontracting, 4 Badging Requirements for Foreign Persons, 5 Security Requirements for Access to Premises Owned or Controlled By Buyer or the Government, 6 Safeguards, 7 Reserved, 8 Electronic Commerce Accounts, 9 Reserved, 10 Ethical Business Conduct, 11 Foreign Content Reporting, 12 ITAR Registration Requirements, 13 Export Licensing Information / Offshore Procurement, 14 Buyer Approvals, 15 Reserved, 16 Industrial Participation Commitment, 17 Reserved, 18 Defective Cost or Pricing Data, 19 Business Size Representations and Certifications, 20 Delivery Payment Terms 21 Import Commercial Invoicing, 22 Invoice and Payment for Material under Labor Hour / Time and Material Contracts, 23 Advanced Shipping Notice (ASN), 24 Supplier Packaging Requirements, 25 Counterfeit Goods, 26 Material Substitution Prohibition, 27 Government Property, 29 Reciprocal Waiver of Claims - Qualified Anti-Terrorism Technology, 30 Representations and Certifications, 31 Special Tooling

B Additional Site / Program Requirements: 1 Process Standards/Specifications Supersession List, 2 Authorized Equivalent Parts List, 3 Approved Materials Substitution List, 4 Change Notification.

(Issuing Location/Program Site - Long Beach): 1 Bar Coding Requirements, 2 Disposition of Nonconforming Material

(Issuing Location/Program Site - St. Louis): 1 Additional Contract Provisions

(Issuing Location/Program Site - Puget Sound): 1 Supplier Disclosure

Q54 ITAR Registration Requirements - Supplier/Seller shall comply with International Traffic in Arms Regulation §122.1, Registration requirements.

<https://www.gpo.gov/fdsys/search/pagedetails.action?collectionCode=CFR&searchPath=Title+22%2FChapter+I%2FSubchapter+M%2FPart+122&granuleId=CFR-2012-title22-vol1-sec122-1&packageId=CFR-2012-title22-vol1&oldPath=Title+22%2FChapter+I%2FSubchapter+M%2FPart+122&fromPageDetails=true&collapse=true&ycord=1130>

Q55 Boeing D607 Material Substitution Prohibition

D607 is located at Doing Business with Boeing, under Quality Clauses (located under Terms, Conditions & Provisions), under Common Clauses, under DXXX Material, BDS Terms and Conditions Clause Number: D607,

http://www.boeingsuppliers.com/idscommon/clauses/clause_d.htm

The following is for reference. Go to the website for the latest revision.

D607 includes:

- A. Unauthorized Material Substitution (General)
- B. Metallic Materials (Specific)
- C. Specification Supersession:
- D. Reports (Full Pedigree from melt to final product)
- E. Chain of Custody (Disguising intermediate ownership)
- F. Source of Additional Information
- G. The substance of this Article shall be flowed in all subcontracts at every tier

Q56 Boeing Q011S Supplemental Quality Requirements

Q011S is located at Doing Business with Boeing, under Quality Clauses (located under Terms, Conditions & Provisions), under Common Clauses, under QXXX General Legal/Flow down, BDS Terms and Conditions Clause Number: Q011S,

<http://www.boeingsuppliers.com/clauses/clauses.html>

The following is for reference. Go to the website for the latest revision.

Q011S includes:

- 1. Change in Quality Management Representative
- 2. Change in Quality Management System
- 3. Change in Manufacturing Line, Facility Location or Process
- 4. Natural Disaster Occurrence
- 5. English Language
- 6. Seller's Subcontractors
- 7. Seller's Change Notification Process

Q56 UTAS Supplemental Quality Requirements - ASQR01

The requirements of ASQR-01 Supplier Quality System Requirements are applicable.

<http://www.utc.com/suppliers/pages/aerospace-supplier-quality-requirement-documents.aspx>

The following is for reference. Go to the website for the latest revision.

ASQR01 includes:

Supplier shall have a process for on-going verification of visual acuity and color vision for individuals performing product inspection.