

COVER SHEET

General

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Document Review

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Acknowledge Sheet

Dept.	Signature/Date
HR & Adm.	NA
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供应商质量要求

1. Purpose 目的

Acceptance of this document by Purchase Order acknowledgement shall be unconditional. The quality requirements noted herein does not supersede or replace Purchase Order terms and conditions and/or requirements listed in PCC Aerostructures SQR-10000 Supplier Quality Requirements Manual, but intend to act as a specific supplement to them for Primus Suzhou.

The supplier is responsible for complying with these quality requirements noted herein to meet Primus Suzhou Supplier performance expectations.

供应商确认普美苏州订单时无条件接受本文件要求。本文件所提出的供应商质量要求不可取代或替换订单合同条款和/或列在 PCC 航空结构件事业部 SQR-10000 供应商质量要求手册内的要求，而是意在作为普美苏州对其的特别补充。

供应商有责任符合此处所提及的这些质量要求，以达到普美苏州对供应商的业绩期望。

2. Scope 范围

All suppliers for product related materials and services.

所有与产品相关的材料和服务供应商。

3. Definitions 定义

Nadcap	National Aerospace and Defense Contractors Accreditation Program 美国国家航空航天和国防合同方授信项
AQS	Aerospace Quality System 航空质量体系
SCM	Supply Chain Management 供应链管理
SQE	Supplier Quality Engineer 供应商质量工程师
Supplier	“Supplier” noted herein indicates Primus Suzhou’s supplier 本文中提到的供应商均指普美苏州的供应商
Buyer	“Buyer” noted herein indicates Primus Suzhou 本文中提到的采购方均指普美苏州
PO	Purchased Order 采购订单

4. Instructions 工作指导

4.1 Quality System Requirements 质量体系要求

Supplier shall implement and maintain a quality management system in accordance with the respective standard per SQR-10000, with the following exceptions:

除以下特殊要求之外，供应商应按照SQR-10000要求实施并维护相应的质量管理体系。

- Build-to-print (including Machining Only) 按图加工（包含仅机加工）
Supplier must maintain AS9100 certification and approval from Primus Suzhou Quality Assurance & Engineering Department and Manufacturing Planning and Procurement Department.
供应商须保持 AS9100 资质并得到普美质量/工程部和计划/采购部的评估批准。
- Processor 特种工艺
Supplier must maintain AS9100 or Nadcap AQS certification in addition to Nadcap certification for special processes performed.

供应商在保持其Nadcap特种工艺资质之外还须保持AS9100 或Nadcap航空质量体系资质。

For Airbus programs, supplier shall maintain approvals as applicable per Airbus ASR.

对于空客项目，供应商应保持相应的空客ASR批准。

4.2 Supplier Sub-tier Requirements 供应商的下级供应商要求

Supplier shall NOT subcontract or relocate any work to sub-tiers unless received advanced written permission from Primus Suzhou QA Manager.

除非事先获得普美苏州质量经理的书面批准，否则供应商不允许转包任何普美苏州的工作包给下级供应商。

4.3 Management Responsibilities 管理责任

Primus Suzhou reserves the right to use other PCC Division companies' or customer's assessment, audit and qualification records as evidence of Supplier qualifications, especially for overseas Suppliers.

普美苏州保留使用其它PCC旗下子公司的或客户的评估、审核和认证结果作为供应商资质认可证据的权利，特别是对海外供应商。

Supplier shall ensure the supplied products/service, packing slip/service report and invoice match with the committed PO requirements.

供应商应确保其所提供的产品/服务、送货单/服务报告及所出具的收款凭证与承诺过的订单要求相匹配。

Supplier shall analysis and monitor the performance based on the monthly Supplier Quality Rating Report provided by Primus Suzhou to achieve Buyer's expectation and maintain the approval status.

供应商应根据普美苏州提供的每月供应商质量评价报告分析并管理业绩表现以达到买方的期望并维持批准状态。

4.4 Production Realization 生产实现

When Supplier has any technical doubt, which includes but limited to the engineering requirements in PO Notes /Drawing/ Specification/Data Set, Supplier shall officially request clarification with the use of 42803C Liaison Request Form during production realization. Supplier shall stop work and delivery until official reply from Primus Suzhou clarified the issue.

当供应商对于包含但不限于订单注释/图纸/适用规范/适用数据集有任何技术上的疑问时，应在生产实现中以联络申请单 42803C 的方式进行正式的问询，在得到普美苏州正式回复澄清疑问后方可继续作业和交付。

Regarding the Technical Liaison, SCM is the receiving window during sample development, and SQE is the receiving window for post-delivery. The dedicated ME/QE from Primus Suzhou is responsible for replying to the supplier technical inquiry form officially. SCM and SQE are limited to communication and coordination only but no authority to reply Liaison Request.

进行技术联络时，样品开发阶段采购为接收窗口，量产后SQE为接收窗口。普美苏州的责任制造工程师/质量工程师负责正式回复供应商技术联络问询单，采购和SQE仅限于沟通协调，不得直接书面回复技术联络问询。

4.5 Measurement and Analysis 测量和分析

Failure to comply with an acceptable performance level may result in on-site audit, or source inspection oversight.

供应商业绩未达标，将导致现场审核，或货源地检验。

4.6 Control of Non-Conforming Products 不合格品的控制

Upon receipt of Supplier Defect Report from Buyer for delivered non-conforming product, Supplier shall respond to Buyer within five (5) working days.

对于供应商交付给普美苏州后检出的不合格品，供应商须在收到普美苏州发出的供应商缺陷报告后的5个工作日内予以答复。

4.7 Corrective/Preventive Action 纠正及预防措施

Supplier shall be aware of, adopt and compliant to AS13000 Series Aerospace Standards if Suppliers serves Airbus, GKN work.

如果供应商为Airbus，GKN项目供货，则供应商应意识到、采用并符合AS13000系列航空规范。

4.8 Document and Data Control 文件及数据控制

All quality records must be legible, stored and retained in a suitable environment to prevent damage, deterioration or loss. All records shall be maintained with a scanned soft copy and a paper copy. All documentation should be completed in black permanent ink only.

所有的质量记录必须清晰，并存放在一个适宜的环境中以防损毁，破坏或丢失。所有记录必须保存一份扫描的软拷贝件和纸件。

所有的文件必须用黑色永久性墨水填写。

Drawings/specifications/datasets provided for RFQ shall be used as reference for quotation purpose only. Use of RFQ drawings for deliverable manufacturing and inspection is strictly prohibited at any time.

报价时提供的图纸/规范/数据集应仅作为参考用于报价目的。

任何时候都严禁将报价时提供的图纸用于交付产品的制造和检验。

A master list of drawings, specification, and planning sheets must be maintained and available at suppliers' facility.

供应商须保存一份图纸，规范及计划单的目录清单。

Upon Primus Suzhou's request, and in the event of termination or cancellation of this order, Supplier shall return all such information and property to Primus Suzhou or make such other disposition as directed.

根据普美苏州的要求，当订单终止或撤销时，供应商必须将普美苏州的资料及财产全部归还或按照普美苏州的指导进行处理。

5. Quality Requirements & Quality Records 质量要求及质量记录

Quality Records refer to 31101C and 31401C.

质量记录参考31101C 和31401C

6. Normative Reference 参考文件

SQR-10000	PCC Aerostructures Supplier Quality Requirements Manual
AS9100	PCC 航空结构件事业部供应商质量要求手册
	Quality management systems – Requirements for Aviation, Space, and Defense Organizations
	质量管理体系-对航空、航天以及国防组织的要求
GB15258	Formulation of requirements for chemical safety labels 化学品安全标签编写规定
31101C	Document/Data Control Matrix 文件和数据控制矩阵
31401C	Quality Records Matrix 质量记录矩阵
ASR	Airbus Supplier Requirements 空客供应商要求
20500C	Supplier Management 供应商管理

7. Appendix-Quality Documentation Requirement 附件-质量文件要求

7.1 Raw Material Supplier(A1) 原材料供应商(A1):

Supplier shall provide a Certificate of Conformance linked to Mill Cert and Raw Material Test Reports with minimum includes:

供应商须提供“合格证”并关联“原材料出厂证明”和“原材料测试报告”并至少包括以下内容：

- Primus Suzhou purchase order number with line number, also purchase order change number, if applicable.
普美苏州订单号订单以及流水线号，如适用，加上订单变更号；
- Material designation, description, specification with revision, batch number and quantity.
材料牌号、描述、规范及版本、批号和数量；
- Statement of product conformity.

产品符合性声明:

- (d) Test Result includes Physical Properties, Chemical Composition, and etc.
测试结果包括物理特性、化学成分等等;
- (e) Any attached reports and relative lot number from other source to link the traceability to the mill cert.
任何附件报告及关联至原材料出厂证明的相关批次号;
- (f) The signature and/or stamp of the authorization release personnel.
授权放行人员的签章。

The supplier shall assure the following during packaging and delivery:

在包装及交付时, 供应商必须检验以保证:

- (a) The materials are as ordered by Primus Suzhou and are complete and properly identified.
材料是按照普美苏州采购的要求并完全进行了标识;
- (b) The materials must be identified by label or tag stating the raw material number, Purchase Order Number and Line Number.
所有材料必须用标牌或标签进行标识, 说明原材料号、订单及流水线号;
- (c) Different type of material must be packed separately and identified.
不同类型的材料必须单独包装并做相应的标识;
- (d) Different Item or Heat Lot of material must be identified.
不同项或热处理批次的材料必须做相应的标识;
- (e) Packaging is required by the purchase order and is to assure adequate protection during delivery.
要求进行合适的包装以保证交付过程中的充分保护;
- (f) Unless otherwise specified, except originated raw material thickness or diameter, any cutting/sawing/water-jetting dimension (i.e. width, length, near-net-shape profile) shall be within $-0/+0.125$ inch (or $-0/+3.00$ mm in Metric) of nominal size.
除非特殊注明, 所有经过割料/锯料/水切割原始毛料后的尺寸公差(比如宽度、长度、外形轮廓等等), 必须在名义值的 $-0/+0.125$ 英寸(当公制时 $-0/+3.00$ 毫米), 但此处不包括初始毛料的厚度或者直径尺寸;
- (g) Delivery documents required by the purchase order are correct, complete and legible.
订单上要求交付的文件必须正确、完整以及清晰。

7.2 Machining, Sub-tiers and Processors(A1/A2) 机加工和特种工艺供应商(A1/A2):

Machining, Processing Supplier or Purchased in Completed Supplier shall deliver with each part item the following listed items:

每项货品交付时, 机加工供应商、特种工艺供应商或完全采购供应商须附上:

- (a) Supplier's FAIR (First Article Inspection Report), if applicable. 如适用, 供应商首件检验报告;
- (b) Certificate of Conformance. 合格证;
- (c) Dimensional Inspection Report and/or Special Process Report), if applicable. 如适用, 尺寸检验报告和/或特种工艺报告;
- (d) Packing Slip. 装箱送货单。

Electronic copy is preference. 首选电子版报告

No Blanco or white corrector allowed for any corrections. Corrections or cancellations must be signed and dated by editor legibly.

不能用涂改液或修正液进行修改。如有更正或删除必须清晰且附有修改者的签名并注明日期。

First Article Inspection Report 首件检验报告

Please refer to the AS9102 for detailed requirements. Any questions regarding FAI shall be directed to Primus Suzhou Quality Assurance.

详细要求参见AS9102，如有任何关于首件检验的疑问，可向普美苏州质保部咨询。

Net-inspect online is preference. 首选 Net-inspect。

FAI Notes 首件检验注意事项：

- (a) Record actual dimensions and general notes conformance, 100% in black permanent ink on specified form.
在指定的表格上用永久性黑色墨水100%记录检验的实际尺寸记录及通用注释的符合性记录；
- (b) Primus Suzhou's part number, including drawing number and dash number.
普美苏州的零件号，包括图号及件号；
- (c) Primus Suzhou's part revision number.
普美苏州的零件版次号；
- (d) First Article has to be tagged with traceability information.
首件须挂牌标示追溯信息；
- (e) Primus Suzhou's reference number. (P.O#, Job# etc.)
普美苏州的参考号（订单号、工单号等）；
- (f) Type/ID of measuring instruments.
量具的类型/编号；
- (g) Unit of measurement stated must be in accordance with the drawing, i.e. Metric or Imperial.
使用的测量单位必须符合图纸的要求，如公制或英制；
- (h) Inspector's signature and/or stamp.
检验员签名和/或印章。
- (i) Unless otherwise agreed, the supplier's FAI must be accepted before product is shipped to Primus.
除非得到普美的同意，供应商必须在FAI被批准后才能发货。

FAIR shall include but not limited below items 首件检验报告集应至少包含以下项目：

- (a) AS9102 Form 1, Form 2 and Form 3. AS9102 表1，表2和表3；
- (b) CoC.合格证；
- (c) Raw Material Certs. 原材料证书；
- (d) Chemical Consumable Certs, if applicable. 化学品证书，如适用；
- (e) Standards Certs, if applicable. 标准件证书，如适用；
- (f) Processing Certs, if applicable. 特种工艺证书，如适用；
- (g) Test or Functional Reports, if applicable. 测试或功能性报告，如适用；
- (h) PO. 客户订单；
- (i) Balloon Drawing. 尺寸 / 特性泡泡图；
- (j) CMM Report. 三坐标检验报告；

- (k) Point Map, if required by customer. 测量点阵图, 如客户要求;
- (l) Sub-tier Reports, if applicable. 次级供应商报告, 如适用;
- (m) Manufacturing order copies. 制造工单拷贝件。

Certificate of Conformance 合格证

Certificate of Conformance is required from Supplier for ensuring parts and/or materials compliance with applicable purchase order, drawing, specification and revision requirements.

供应商需提供零件及/或材料的合格证或证书以证明符合订单、图纸、规范及版次的要求。

The Certificate of Conformance shall consist of 合格证须包含以下信息:

- (a) Primus Suzhou's part number, including drawing number and dash number. 普美苏州的零件号, 包括图号和件号;
- (b) Primus Suzhou's part revision number. 普美苏州的零件版次号;
- (c) Quantity of parts. 零件数量;
- (d) Serial number of parts, including prefixes and suffixes for machined parts, when parts are required to be serialized. 零件系列号, 包括机加零件的前后缀, 当零件有系列号的要求时;
- (e) Purchase order number, P.O line number and change number of the P.O, if applicable.
订单号、订单流水线号以及订单变更单号, 如适用;
- (f) A list of all special process, inclusive of processes performed, name of supplier, certificate number and date.
所有特种工艺的清单, 包括执行的工艺, 供应商名称, 证书编号及日期;
- (g) Statement of product conformity. 产品符合性声明;
- (h) All release documents must be signed by the suppliers Quality manager or approved nominees.
所有发放的文件必须由供应商质量经理或认可的指定人员签名。

Inspection/Test Report 检验/检测报告

Dimensional Inspection/Test Reports shall minimum include 尺寸检验报告/检测报告至少须包括:

- (a) Primus Suzhou's part number, including drawing number and dash number.
普美苏州的零件号, 包括图号和件号;
- (b) Primus Suzhou's part revision number.
普美苏州的零件版次号;
- (c) Total quantity of parts inspected, quantity of acceptance and quantity of rejection.
检验零件的总数, 接受及拒收数量;
- (d) Serial number of parts, including prefixes and suffixes when parts are required to be serialized.
当零件有系列号要求时, 须为零件标识系列号, 包括前后缀;
- (e) Processing Report shall state the performed process specification which required by purchase order. Process shall include revision, class, type etc.

For example, if PO state cadmium plate in accordance with BAC5701, type II, class 2, and test report shall reflect also.

特种工艺报告须注明订单上要求的工艺规范。工艺须包括版本、等级、类别等等。

例如: 假如订单注明了按照规范BAC5701, II类, 2级进行镀镉, 报告同时须反映其版本、等级和类别。

- (f) Primus Suzhou's reference number. (PO#, Job# etc.)

普美苏州的参考号（订单号、工号等）；

- (g) Results from inspection of design characteristics shall be expressed in quantitative terms for variable data. "Accept or Fail" only apply on attribute data.
设计特征中的变量数据的检验结果应以数值形式表示，“合格或不合格”仅适用于属性数据；
- (h) Hardness/EC Test result and/or Surface Finish Thickness result is required, if applicable
硬度、电导率的测量结果和/或表面涂层厚度的测量结果，如适用；
- (i) 100% visual inspection and record is required.
100% 目视检查并记录；
- (j) Type/ID of measuring instruments used, if applicable
使用的量具类型/编号，如适用；
- (k) Unit of measurement stated must be in accordance with the drawing, i.e. Metric or Imperial.
测量单位必须符合图纸的要求，如公制或英制
- (l) Inspection's signature and/or stamp.
检验员签名及/或印章；
- (m) Authorized approval signature and/or stamp by the QA Supervisor or QA Manager.
质量主管或经理的批准授权签名及/或印章。

Packaging and Delivery 包装及交付

The supplier shall assure the following issues during packaging and delivery:

在包装及交付时，供应商必须检验以保证：

- (a) The articles are as ordered by Primus Suzhou and are complete and properly identified.
零件是按照普美苏州采购的要求并完全进行了标识；
- (b) All parts must be identified by label or tag stating the Part number, Purchase Order Number and Line Number. Purchase Order information should be presented in this format: PO XXXX/XX and SIV XXXX/XX (XXXX = PO No., XX = Line No.)
所有零件必须用标牌或标签进行标识，说明零件号、订单及流水线号；订单的信息格式如示：PO XXXX/XX and SIV XXXX/XX (XXXX = 订单号，XX = 流水线号)；
- (c) The part number with different Purchase Order must be packed separately and identified accordingly.
不同订单的零件必须单独包装并做相应的标识；
- (d) Packaging is required by the purchase order and is to assure adequate protection during delivery. Parts should be individually packed and no contacts between parts are allowed.
要求进行包装以保证交付过程中做到充分的保护。零件必须独立包装，零件之间不允许接触；
- (e) All parts without surface finish protection must be preserved or oiled with approved protective oil as per list of approved protective oil specification, unless otherwise stated.
除非另有说明，没有表面涂层保护的零件都必须按照规范列出的保护油进行保存或油封；
- (f) Delivery documents required by the purchase order are correct, complete and legible.
订单上要求交付的文件必须正确、完整以及清晰。

7.3 Chemicals Supplier (A3) 化学品供应商(A3):

Suppliers who provide chemicals direct used on deliverable items, such as paint, sealant, adhesive, grease. shall deliver with each part item the following listed items:

每项货品交付时，提供直接用于交付产品的化学品的供应商，如油漆、密封

剂、粘接剂、润滑油等须附上：

(a) Certificate of Conformance. 合格证；

(b) Packing Slip. 装箱送货单。

Electronic copy is preference. 首选电子版报告

No Blanco or white corrector allowed for any corrections. Corrections or cancellations must be signed and dated by editor legibly.

不能用涂改液或修正液进行修改。如有更正或删除必须清晰且附有修改者签名并注明日期。

Chinese version of chemical label and safety specification (SDS) shall be provided.

须提供中文版本的化学品标签和安全技术说明书（SDS）

7.4 Calibration and Test Service Supplier (Category B) 校验和测试服务供应商(B类):

Calibration Report/Certificate shall minimum include below listed information

校验报告或证书里必须至少包括以下资料：

(a) Report/Certificate number. 报告或证书号；

(b) Batch/Lot number or any relevant traceability reference number of measuring equipment.
批号或任何可追溯到量具的参考号；

(c) Code or model number and description of measuring equipment. 量具编号或型号以及量具的描述；

(d) Range, resolution, class and accuracy. 范围、分辨率、等级和精确度；

(e) Reference documents for the calibration/calibration standard. 校验时所引用的参考文件或标准；

(f) Primus Suzhou PO number (optional). 普美苏州的采购单号(可选)；

(g) Description of measurement standards used in the calibration. 校验时所使用的计量标准仪器；

(h) Result of the calibration. 校验结果；

(i) Calibration date, calibration personnel and approve personnel. 校验日期，校验者和审核人。

7.5 Distributor and Stockist 经销商和代理商:

When purchasing through distributor or stockist, Buyer shall provide detail and specify the requirement of ordered articles.

当通过代理和中介商进行代采购时，买方订单须详细列明该项采购品的规格与要求。

Distributor and Stockist shall purchase from the customer-approved source only.

经销商和代理商必须仅从客户批准的货源方采购。

For Airbus Programs, Distributor/Stockist shall ensure all material products (defined as materials, semi-finished products, standard parts and specified parts) delivered to the Buyer are:

对于空客项目，经销商/代理商必须确保所有交付给买方的材料产品（定义为原材料、半成品、标准件和特定件）是：

- Purchased from Airbus approved sources and 采购自空客批准的货源且
- Qualified by Airbus and 被空客认证过且
- Defined in the joint contract with Airbus 在空客的联合合约中被定义

For Airbus Program, apart from this above requirement for Distributor/Stockist, all the requirements applicable to Suppliers (i.e. manufacturer) are applicable to the Distributor/Stockist as well.

对于空客项目，除了上述要求之外，所有适用于制造供应商的要求也适用于经销商和代理商。

It is responsible of Distributor and Stockist to 经销商和代理商有责任：

- (a) Perform reports verification to ensure articles description, specification, batch, due date (if applicable), test result (if applicable) etc. are meet the requirement.

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进行报告查证以确保订购品名称、规格、批号、有效期（如适用）、试验结果（如适用）等事项满足于订单要求；

- (b) Perform necessary inspection on Primus Suzhou ordered articles. Records of inspection results shall be maintained on file at the supplier and shall be available upon request.

为中国普美订购品进行必要的检验。检验结果的记录须保存并维护在供应商处以便有需要时可提供；

- (c) Ensure label and packaging is match with Primus Suzhou ordered articles.

确保标识和包装与普美苏州订购品一致；

- (d) Monitor, audit and evaluate its source.

监管、审核以及评估它的供应商。

Distributor and Stockist shall provide their own Certificate of Conformance with minimum includes:

经销商和代理商必须提供自己的“合格证”至少包括以下内容：

- (a) Primus Suzhou purchase order number with line number, also purchase order change number, if applicable.

普美苏州订单号订单以及流水线号，如适用，加上订单变更号；

- (b) Material designation, description, specification with revision, batch number and quantity.

产品号、描述、规范及版本、批号和数量；

- (c) Statement of product conformity.

产品符合性声明；

- (d) Any attached reports and relative lot number from other source to link the traceability to the original cert.

任何附件报告及关联至出厂证明的相关批次号；

- (e) The signature and/or stamp of the authorization release personnel.

授权放行人员的签章。

8. Revision History 版本记录

Rev	Date	Description
New	2006-03-01	Original release
A	2007-03-16	Chinese version added. Minor changes on certain sentence.
B	2007-09-24	Collate and correction on typo error.
C	2009-01-12	Document revised: sentence and paragraph re-arranged, the requirements described and split into 5 types of supplier.
D	2009-05-07	Section 2.7(3) to add "NC parts" tags and notification requirement. Section 8 to describe supplier quality rating. Section 10 to add notification of change in supplier status.
E	2009-11-02	Section 2 revised: sentence and paragraph re-arranged, requirement on Sub-Con Machining and Special Processing revised.
F	2011-05-16	Add change notice of product and/or process, manufacturing facility location into section 10.
G	2011-10-31	Add airbus GRAMS requirement in section 2.1.

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H	2014-06-05	Change 'Primus Customer approved supplier' to 'Legacy supplier' in 2.1 and Add customer requirements in 2.2.1. section 4.
I	2017-08-22	Add Section 11 Prevention of Counterfeit Parts, and 12 Ensuring that persons are aware of.
J	2017-12-27	Remove section 2.3 item 3, section 2.5 item 1 and section 11 covered in the SQR10000 Rev C Change section 3 item 1 "ISO/IEC 17025 and CNAS-CL01" to "ISO/IEC 17025 or CNAS-CL01".
K	2018-03-30	Reconstruct and revise the entire procedure in accordance with SQR10000 Rev D.
L	2018-05-31	Remove redundancies per PCC divisional review comments. Add Technical Liaison requirement to section 7.
M	2018-08-28	Add FAIR item list in section 14.3.
N	2018-09-10	Add MO requirement for FAIR item list in section 14.3.
P	2019-06-12	Document reorganize, update supplier category, add quality documentation requirement for chemicals supplier in section 8.3 and cutting/sawing/water-jetting dimension general tolerance requirement in section 8.1
Q	2024-03-04	Revise section 4.1 from "AP2190" to "ASR". Re-struction the format per 31702C.
R	2024-04-25	Add (i) to FAI Notes in section 7.2, add "Net-inspect online is preference" in FAIR.

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