

# INDEPENDENT FORGE COMPANY QUALITY REQUIREMENTS

This Quality Assurance Specification establishes the specific requirements that apply when one or more of the following Quality Requirements (QR's) are specified by code on Independent Forge Company Purchase Orders. These requirements are in addition to those set forth in any other contractual document. The provisions indicated herein are an integral part of the Purchase Order.

Compliance with these requirements does not reduce Supplier's responsibility for furnishing materials and services, which fully comply with all applicable Drawing(s) and Specification(s), nor does it guarantee acceptance of materials or services by Independent Forge Company. In the event that materials or services are found to be defective and cannot be demonstrated by the Supplier to be in conformance with the Purchase Order, Independent Forge Company has the right to reject them.

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# INDEPENDENT FORGE COMPANY QUALITY REQUIREMENTS

## **1. INSPECTION SYSTEM REQUIREMENTS:**

The Supplier shall provide and maintain an inspection system in Conformance with:

- AS 9100 or AC7004 latest revision
- ASQC9001, latest revision
- AS9100, latest revision
- Other Quality System approved by Independent Forge Company, QA Manager.

## **2. CONTROL OF CHANGES:**

Supplier agrees not to make any changes in materials or design details or other product, which would affect part or any component part thereof without prior written Buyer approval. The Supplier will identify, on the Certificate of Conformance and/or packing sheet, the specification used to process products as indicated on the purchase order, to the latest specification revision of the date on the purchase order.

## **3. SUPPLIER CORRECTIVE ACTION:**

Supplier shall, on request, on forms designated by Buyer, provide statements of corrective action on failures of Supplier's hardware or quality system. Corrective action statements, at Buyer's option may require approval signature by Buyer Quality representative. All rejected articles resubmitted by the Supplier to the Buyer shall bear adequate identification including reference to Buyer's rejection document.

## **4. RIGHT OF ENTRY:**

(1) The Buyer, their customer and regulatory authorities shall be granted the right of access to all Supplier's facilities involved in the order and all applicable quality records.

(2) The right to verify at the Supplier's premises that subcontracted product conforms to specified requirements. Such certification shall not be used by the Supplier as evidence of effective control of quality by the supplier.

## **5. SHELF LIFE AND TEMPERATURE SENSITIVE MATERIALS:**

The Supplier shall identify all materials and articles, which have definite characteristics of quality degradation with age or environment. The Supplier shall affix this information directly on the material container of article. This identification shall indicate the date useful life was initiated and the date or cycle at which the useful life will be expended. When environment is a factor in determining use full life, the identification shall include the storage condition (i.e., temperature, humidity, etc.) required, to achieve the stated life. A minimum of 75% of the applicable material/article shelf life shall remain upon receipt of the material by Buyer or the material is subject to rejection and returned to the Supplier.

## **6. PACKAGING:**

Unless otherwise specified by the item drawing, specification or purchase order, the Supplier is responsible for assuring that all items are delivered without damage or deterioration and are efficiently and economically packed for the method of transportation and type of handling involved. Unit and intermediate packaging will be employed as necessary to prevent damage of deterioration.

## **7. MATERIAL SAFETY DATA SHEETS**

Materials(s) noted on this purchase order must be supplied in accordance with OSHA's hazard communication standard 29CFR1910-1200, OSHA instruction CPL2-262-05413 a "Materials Safety Data Sheets". All first time orders MUST be supplied with "Materials Safety Data Sheets". Materials not received in compliance with aforementioned OSHA requirements, will be subject to immediate rejection and return at supplier's expense.

In addition, if the Supplier is aware of any additional precautions and/or handling techniques instituted with regard to other customers, seller is required to submit those safeguards with MSDS. Supplier is required to forward a Toxic Substances Control Act (TSCA) certification letter to the Buyer for the product(s) purchased on this purchase order with the statement that, "every chemical component of the product(s) is listed by the Toxic Substances Control Act Inventory (P.L.94-94-969)".

## **8. IDENTIFICATION:**

Parts, assemblies and components shall be identified as specified on the engineering drawing. When identification is not specified on the engineering drawing, the product shall be identified with the part number specified on the purchase order. When items are too small to easily identify, they may be bagged and tagged with the proper identification indicated on the bag or tag. Raw material procured to Federal, Military, Aerospace or other specification shall be marked and identified per the requirements of the identification specification, which is referenced in the controlling (i.e. Federal, Military, Aerospace, etc.) specification.

## **9. CALIBRATION SYSTEM REQUIREMENTS:**

Supplier shall have a calibration system that assures compliance with ANSI/ISO/ASQ QE19011S-2008 "American Standard for calibration", any deviation or waiver to this requirement must be approved by the buyer's Material and Quality Assurance Representative.

## **10. CERTIFICATE OF CONFORMANCE:**

Each shipment will be accompanied by a legible and reproducible copy of a Certificate of Conformance, with the signature of a responsible representative stating material, process, or article being shipped meets requirements of applicable drawings or specification cited in Purchase Order. Supplier will include date of manufacture on Certificate of Conformance. If an Outsource Procurement Specification is called out on the Purchase Order, include the current revision level.

## **11. MATERIAL TEST REPORTS:**

A legible and reproducible copy of material test reports will accompany each shipment. Test reports will be identified with specification number and heat and/or cure lot number. Chemical and physical test reports will include actual numerical values for each property tested in accordance with the applicable specification. When more than one specimen is required, test results of each is required on the report. Specification and revision will be shown on each test report furnished.

## **12. CERTIFIED TEST DATA:**

A legible and reproducible copy of certified test data will accompany each shipment of material, parts, or assemblies. Test will be identified with specification number and heat and/or cure lot number. Chemical and physical test data will include actual numerical values for each property tested in accordance with the applicable specification. Specification and revision will be shown on each report furnished. Test data will include the following statement (or equivalent): "Test reports are on file and available upon request".

## **13. APPROVED PROCESS REQUIREMENTS:**

A legible and reproducible copy of special process certifications (i.e. test, heat treat, nondestructive testing, etc.) will accompany each shipment of material, parts, or assemblies. Special processes will be performed to the latest revisions, (process specification owner) and approved sources.

## **14. FIRST ARTICLE INSPECTION:**

A legible and reproducible copy of the Suppliers First Article Inspection (FAI) performed on the initial part or lot (as applicable) at the detail; sub assembly and/or assembly level will accompany applicable shipments. The results of the FAI shall indicate 100% conformance to engineering drawing characteristics, special processes, functional test, and laboratory requirements. Subsequent (Delta) FAI's shall be performed and sent with applicable orders if tooling rework or modification and/or change(s) in supplier's manufacturing method occur. Engineering drawing revisions will require a new FAI incorporate the differences and/or tool proofing inspection. The First Article Inspection will include a complete, independent, and documented physical and functional inspection process to verify that prescribed production methods have produced an acceptance item as specified by engineering drawings, planning, purchase order, engineering specifications, and/or other applicable design documents.

# INDEPENDENT FORGE COMPANY QUALITY REQUIREMENTS

## **14.1. FIRST ARTICLE INSPECTION TO AS9102:**

A legible and reproducible copy of the Suppliers First Article Inspection (FAI), compliant with AS9102 latest revision, performed on the initial part or lot (as applicable) at the detail, subassembly and/or assembly level will accompany applicable shipments. The results of the FAI shall indicate 100% conformance to engineering drawing characteristics, special processes, functional test, and laboratory requirements. Subsequent (Delta) FAI's shall be performed and sent with applicable orders if tooling rework or modification and/or change(s) in supplier's manufacturing method occur. Engineering drawing revisions will require a new FAI incorporating the differences and/or tool proofing inspection. The First Article Inspection will include a complete, independent, and documented physical and functional inspection process to verify that prescribed production methods have produced an acceptance item as specified by engineering drawings, planning, purchase order, engineering specifications, and/or other applicable design documents. If the product has been produced for the Seller within 2-years a complete new FAI is required.

## **15. REPORT OF DISCREPANCY:**

Any departure from drawing specifications or other purchase order requirements must be documented by the Supplier and submitted to the Buyer for consideration and disposition. A copy of this disposition document must accompany each affected shipment.

## **15.1. REPORT OF ESCAPE:**

The Supplier, upon discovery of a shipment / delivery of nonconforming product must provide a notice of disclosure to the Buyer within 48 hours of discovery.

## **16. TRACEABILITY/LOST AND BATCH CONTROL:**

Supplier must maintain lot and batch control of raw materials to purchased items. Supplier must provide positive trace ability of manufactured parts and assemblies to raw materials through the use of lot/batch, serial numbers or date of manufacture, as applicable, for all items in the shipment.

## **17. SUPPLIER RECORDS:**

The Supplier shall maintain records of product delivered to buyer for a period of fifteen years, or as required by Customer.

## **18. KEY CHARACTERISTICS:**

The Supplier shall maintain applicable statistical control charts for key characteristics identified by the customer drawings. A copy of the key characteristics statistical control charts must accompany all items in the shipment to the Buyer.

## **19. SUPPLIER FLOW DOWN TO SUB-SUPPLIER:**

The Supplier shall flow down to sub-tier suppliers, the applicable requirements in the purchasing documents, including key characteristics where required.

**INDEPENDENT FORGE COMPANY  
QUALITY REQUIREMENTS**

**SUPPLIER CATEGORIES (SCOPE):**

**OP Outside Processors**

(Finish, Heat Treat, Boeing D1-4426 process suppliers)

**OS Outside Services**

(Calibration, Outside Test Labs)

**RM Raw Material**

(Raw Materials used in fabrication of Customer Product)

**SP Standards, Parts & Hardware**

(Fasteners, bushings, latches, catalogue parts, etc.)

**APPLICABLE QUALITY REQUIREMENTS BY CATEGORY:**

**OP ~ Outside Processor**

QR Notes for Purchase Orders: 1, 2, 3, 4, 6, 9, 10, 13, 15, 15.1, 16, 17 & 19

**OS ~ Outside Services**

QR Notes for purchase Orders: 1, 2, 3, 4, 6, 9, 10, 12, 15, 15.1, 16, 17 & 19

**RM ~ Raw Material**

QR Notes for purchase Orders: 1, 2, 3, 4, 5, 6, 7, 9, 10, 11, 15, 15.1, 16, 17 & 19

**SP ~ Standards, Parts & Hardware**

QR Notes for purchase Orders: 1, 3, 4, 5, 6, 7, 8, 9, 10, 15, 15.1, 16, 17 & 19