



Level II Procedure

TITLE: QUALITY CLAUSES

Document #

QAP-33

Revision:

L

Rev. Date:

5/08/2015

What's New:

REV L

Clause A.3:

- Item #10, Clarified intent of KLX website review and revised web link for suppliers
- Added Item # 20, Calibrated tooling requirement
- Added Item # 21, added hazardous materials exclusions

Clause A.6: Added Authorized distributors certification to, or verification of OCM approval

Clause C.3: Added Frozen Goods requirements

Clause E.4: Added HAZMAT & MSDS requirements

Clause F.: Removed final paragraph – it was causing confusion in supply base – moved to its own unique clause (F.7)

Clause ~~F.7~~ Added paragraph removed from Clause F.

Clause R: Critical Notes

- 1c.) Added Vendor Controlled Items
- 5.) Added “controlled” to clarify “controlled process certifications”.

REV K

Table I: Added Middle River Design Holder

Clause *A: Format change and revised note related to multiple manufactured lots. Removed PERP note.

Clause A.3: Revised sentence 15, related to ODS Certification. Revised FOD sentence. Added requirements for material declared as scrap/unsalvageable.

Clause A.4: Removed reference to Obsolete form QAF-094

Clause A.8: Added Quality requirements for UTAS

Clause F.6: Added clause related to UTAS Part Marking Requirements

Clause P: Complete re-write

Clause R: Clarified SPOC 002. Included link to the Honeywell Portal and instructions on how to get access if the supplier don't have an account.

Clause V: Added NADCAP comment

REV J

Table I Added Lockheed Design Holder

Clause A.3 Added paragraph 16: Products shall contain no metallic mercury

Clause A.3 Added paragraph 17: Foreign Object Damage (FOD) prevention

Clause A.3 Added paragraph 18: Guidelines for ESDS (Electrostatic Discharge Sensitive) items

Clause B Revised Inspection Plan and Sampling Methodology

Clause E.3 Added Mill certification requirement

Clause F: Added paragraph regarding shipments containing multiple special processed lots within each manufactured lot

Added Clause Q1 regarding Lubrication guidelines

Clause *R Added paragraph regarding items requiring First Article per SPOC Event Table and the part number is an assembly

Clause U Defined record retention period for non-traceable, non-serialized parts

Clause V Added Internal Manufacturer Labs ISO requirements



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NOTE: This procedure requires approval of changes by Honeywell. Send proposed changes to the KLX Aerospace Solutions Document Control Board at Honeywell.

Introduction

Quality Clauses are flowed-down by the purchase order, Memorandum Of Understanding (MOU), or other contract. Product and/or orders not meeting the requirements of the quality assurance clauses QAP33.0 are subject to return and/or corrective action.

Definitions

1. **Honeywell Specification Control Part:** A Honeywell part number assigned to a commercial or off-the-shelf item. Includes 10 and 11 digit series parts (e.g., 145-525-9001, 525-8515-9001, etc.), and items designated "Specification Controlled" or "Vendor Item Control Drawing" on the blueprint.
 2. **Commercial Standard Part:** A part **not** designed for a specific application which is **manufactured to a catalog description** and identified with the manufacturer's part number.
 3. **Standard Part:** Part numbers designated as AN, AS, M, MS, NAS, SAE, etc. conforming to an established industry or U.S. specification. A standard part is defined as a part manufactured in conformance with a specification established, published and maintained by a consensus standards organization, a government agency, or holder of a design approval meeting specific criteria. The specification includes design, manufacturing, test and acceptance criteria and identification requirements.
 4. **Fastener:** A screw, nut, bolt, or stud having internal or external threads, or a load indicating washer as per the Fastener Quality Act (FQA).
 5. **Vendor Proprietary Part:** The manufacturer of the part is the design/cage-code holder. Specifications are proprietary to the manufacturer.
 6. **Customer Proprietary Part:** The customer is the design/cage-code holder.
 7. **Traceability:** Clear paper trail of certifications, test reports, material specifications, etc. including any unique numbering system applied on each page of a single certification package.
 8. Sub Clause Categories: (example F.1 or F.2). Only those clauses specifically called out on the Purchase Order are invoked. Clause "F" on a PO does not automatically invoke F.1 / F.2 etc.
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Customer Proprietary Parts Requirements Customer Proprietary Part Numbers require compliance to that Design Holder's Quality System Standard Requirements. All drawing, specification and documentation requirements of the Design Holder's Quality System must be complied with.

Table 1 lists examples of Customer Proprietary Cage Codes which may have special requirements. The applicable Design Holder's Quality System Requirements must be evaluated for applicable test report, approved process sources, first article inspection reports, to include frequency and format, or other specification requirements during contract review and prior to release for production.

Additional Customer Proprietary CAGE Codes may exist beyond those listed in Table 1. Their requirements must be adhered to as if their cage code were listed.

KLX Aerospace Solutions (KLX Inc.) should be contacted as necessary to ensure compliance to that Customer's Quality System Standard Requirements.

TABLE I

CAGE	Design Holder	Standard	CAGE	Design Holder	Standard
25472	BFGOODRICH CO	QA 111	24446	GENERAL ELECTRIC CO	S - 1002
03481	GOODRICH CORP	QA 111	73030	HAMILTON SUNDSTRAND CORP	ASQR - 01
92092	GOODRICH CORP	QA 111	00198	PRATT AND WHITNEY CANADA INC	ASQR - 01
71379	CESSNA AIRCRAFT COMPANY	CQRS	77445	UNITED TECHNOLOGIES CORP	ASQR - 01
99207	GENERAL ELECTRIC COMPANY	S - 1002	61858	UNITED TECHNOLOGIES CORP	ASQR - 01
07482	GENERAL ELECTRIC COMPANY	S - 1002	51563	ROHR INCORPORATED	QA 111
76301	BOEING	D590	81205	BOEING	D590
98897	Lockheed	Appendix QX Supplier Quality Requirements	1B6R3	Middle River Aircraft Systems (MRAS)	S-1007



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Clause A Certification of Conformance (C. of C.)

The supplier shall provide a manufacturer’s certification of conformance with each shipment. **The manufacturer’s certification must have a Quality Representative’s or an officer of the certifying companies’ signature and date. The signature may be electronic, manual, or physically signed and dated by an authorized company representative as stated above.** Each manufacturer’s lot in each shipment must be segregated and identified **to include quantity and lot number on each C of C to maintain lot traceability.** Number of individual lots in any one order must be limited to four (4).

Documentation showing clear traceability for the part number ordered, up to and including shipment to KLX AEROSPACE SOLUTIONS must be included for each lot in each shipment unless otherwise noted on the applicable purchase order.

There must be a clear link(s) (ex: Heat #, Lot number), that ties the entire certification package together. This includes process certifications performed by sub-tier suppliers.

All Certificates of Conformance shall include the following:

*A

- Purchase Order Number
- Part Number (as ordered on KLX AEROSPACE SOLUTIONS purchase order). Referenced part numbers are not acceptable.
- Revision Level as noted on the KLX AEROSPACE SOLUTIONS purchase order.
If no revision is noted on Purchase order, provide and certify to the latest blue print revision at time of Purchase Order placement.
 - (see Clause “R” for Honeywell specific part number requirements)
- Quantity (per each mfg lot in shipment. See details in first paragraph above)
- Manufacturer’s name and part number (if applicable).
- Lot number: lot number may be defined by any format that provides full trace to all elements of the manufactured lot – including special processes. Examples (but not limited to) could be date codes, work order numbers & heat numbers, as long as the format fulfills the requirement of full traceability for all elements of the manufactured lot.
- Serial number (if applicable)
- A statement that the parts/materials conform to all applicable drawing and specification requirements
- ** If the part is considered ITAR or EAR based upon its “original design intent”, then ITAR category or ECCN is required for "Verification of Export Compliance".
 - If the part is considered dual use, then use the Commercial classification
- Shelf life requirements including cure date (if applicable). This requirement may be met on DCC of Authorized Distributors.
- **Distributors must also include a signed Certification of Conformance (DCC).**
- **Distributor shall certify to part number ordered on Purchase Order**
- **Distributors shall maintain clear traceability to the original manufacturer for each lot in a shipment.**
- **Statement of Origin (i.e. Made in the USA)**

CRITICAL NOTE: If the shipment contains multiple manufactured lots, each lot shall be segregated and identified to maintain traceability in the shipment. Failure will result in a rejection.

All required documentation shall be completely legible, and reproducible. KLX Aerospace Solutions will review documentation for compliance to requirements, legibility, and reproducibility by electronic scanning and/or copying.

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<p>A (cont)</p>	<ul style="list-style-type: none"> At KLX Aerospace Solutions discretion, we reserve the right to invoke source inspection. <p>Shipments that do not comply with requirements are subject to rejection, return, and/or and formal corrective action.</p>
<p>A.1</p>	<p><u>DFAR 252.225-7009 specialty metals applies</u> Compliance options include:</p> <ol style="list-style-type: none"> A statement of “conformity per DFAR 252.225-7009” on the Certificate of Compliance or associated paperwork. Certification to the Country of Melt Copy of original mill certification to validate Country of Melt Specialty Metals Certification posted in the International Fasteners Institute website Certificate of Conformity stating all Purchase Order or Contract requirements have been met.
<p>A.2</p>	<p><u>ASQR-01 Supplier Quality System Requirements (UTC End Use)</u></p> <p>The supplier must ensure that all specifications within ASQR-01 are met. These requirements include but are not limited to:</p> <ul style="list-style-type: none"> ASQR-07.5 Control of Software AQSR-15.1 Handling, Storage, Packaging, Preservation and Delivery ASQR-20.1 Supplier Sampling Requirement UTCQR-09.1 Process Certification Requirements <p>ASQR-01 Compliant must appear on the certificate of conformance or associated paperwork.</p>



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1. Specific Purchase Order text takes precedence over the QAP 33.0 clauses.
 2. KLX Aerospace Solutions, its customers, and regulatory agencies shall have the right of entry, upon reasonable scheduling, to any place necessary to determine and verify the quality of contracted work, records and material. The supplier shall provide facilities, equipment and personnel as necessary for the task.
 3. All documents must be one-sided, 1 certification per page, legible, reproducible, and no larger than 8 ½" x 11" in size.
 4. For Honeywell proprietary parts, the Honeywell SPOC manual and drawing will take precedence over this document.
 5. When Vendor Substantiation Engineering Approval (VSE) is denoted, it is a supplier obligation to obtain General Electric (GE) approval, prior to quoting or producing hardware. Vendor is also responsible for obtaining GE approval for all changes prior to quoting or producing hardware.
 6. Certifications and test reports supplied in fulfillment of orders must be in English
 7. Records and certification packages related to items sold to KLX Aerospace Solutions, must be available if requested, within 48 hours of request.
 8. Thorough contract review required. Any/All differences between KLX Aerospace Solutions quote or Purchase Order and supplier's ability to provide product as ordered, must be resolved in writing, prior to Purchase Order acceptance.
 9. Where product has been determined to have an ASL / QPL, the manufacturer must be approved on the current applicable document for the part number ordered. Manufacturer's contract review is responsible for assuring this approval prior to sale. If product received is not manufactured or supplied from an approved source, the product will be rejected.
 10. Vendor shall review KLX Aerospace Solutions web site prior to contract/P.O. acceptance to ensure Contract Review is performed to the most current requirements of QAP 33. By accepting the contract/P.O., the Vendor is certifying this requirement has been met. <http://www.klxaerospace.com/supplier-resources/supplier-communications/>.
- Quality Alerts and other pertinent information to these reviews may also be found here.
11. Changes or corrections to records, regardless of the media, shall be made as follows: draw a single line through the old data, enter the correct data, date, and apply stamp or initials or signature of individual making the correction. No erasures, covering, or "white-out" allowed.
 12. **Subcontract policy:** KLX Aerospace Solutions suppliers shall ensure flow down to, and compliance with, all applicable Purchase Order requirements to their sub-tier suppliers, including approved Special Process providers when required by design owner.
 13. **Prohibited practices:**
 - a. Unauthorized repair of another owner's design hardware
 - b. Unauthorized processing in manufacturing when processes are subject to specification control by buyer.

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A.3
Cont.

14. Supplier shall ensure that the current configuration of all drawings, specifications and instructions required by the Contract/Purchase Order, are used for manufacturing, inspection and testing.

15. Class I Ozone Depleting Substances (ODS) shall not be used in the design, test, manufacture, integration and assembly, handling, transportation, operations, maintenance or disposal of the hardware/components delivered to this order.

16. Products shall contain no metallic mercury and must be free from contamination by mercury. The Supplier shall not use mercury, mercury components or mercury bearing instruments or equipment that cause contamination during the manufacture, service, assembly, or test of materials.

17. The supplier shall use industry standard, commercially reasonable efforts to prevent and/or remove **Foreign Objects** that might be considered a potential source of **Foreign Object Damage** (FOD) from all parts prior to shipment.

18. For ESDS (Electrostatic Discharge Sensitive) items, the Supplier shall establish and maintain a written electrostatic discharge control program for the control of Electro-Static Discharge (ESD) during fabrication, handling, and packaging of electrical and electronic parts, assemblies, and equipment. The program must comply with the requirements of the most current version of Mil-Std-1686 or ANSI/ESD S20.20.

19. All aircraft items and materials declared as scrap/unsalvageable*:

- a. Shall be physically identified.
- b. Shall be handled and stored in secured/ quarantine areas.
- c. Shall be mutilated (when feasible) prior transfer for destruction/ recycling. The mutilation shall be done in such way that the items or materials are beyond economic salvage or repair, including their potential subassemblies.
- d. When mutilation is not feasible prior to the transfer for destruction/recycling (e.g;hazardous or small items), the transfer and destruction/recycling processes shall be secured with capability to demonstrate the destruction or the recycling.

***Scrap/Unsalvageable item:** Item determined as no longer suitable for its intended aerospace use.

20. Periodic calibration of measuring and test equipment is required and shall be performed prior to use for acceptance of hardware. Measuring and test equipment records and labels shall indicate the date of last calibration and when the next calibration is due.

21. Products provided shall not contain Asbestos, 1,1,1-Trichloroethane, lead, chromium, CFC-12, radioactive material, polychlorinated biphenyls or Penta/Octa PBDE.

Hamilton Sundstrand Process Certification

The supplier must provide the below information for each KPC identified on the Hamilton Sundstrand print per the requirements of UTCQR-09.1 and HSC16199:

1. Gage Information for the gage used to measure that KPC:

- Gage ID and description
- Calibration Data
- Gage R&R to include: Gage resolution, Std Deviation, minimum tolerance gage is capable of measuring

2. Process Data:

- Initial process capability data
- Name of machine producing the KPC
- List of critical process variables that control the variation
- List of critical process variables setting that minimize variation
- List of Critical process variables control methods that define Key Process Input and key Process Input Setting

3. Inspection Data:

- Mfg. lot #
- Inspection qty
- mean average - the average of the measurements in the manufacturing lot
- Standard deviation - the calculated standard deviation of all measurements in the manufacturing lot

A.4

4. Action Plan (when required as outlined below):

- The Gage study does not meet all requirements
- The SPC data has a Cpk less than 1.33
- A Pop Up message in HS portal will indicate that an Action Plan is required - KLX Aerospace Solutions will advise
- A date will appear in the Action Plan Required Date window on the Milestone Status screen indicating when the Action Plan must be submitted - KLX Aerospace Solutions will advise
- Workflow messages will be sent to the producer and assignee when an Action Plan is required and when an Action becomes overdue - KLX Aerospace Solutions will advise



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A.5	Reserved
*A.6	<p><u>Counterfeit Parts Compliance</u></p> <p>The holder of the KLX Aerospace Solutions Purchase Order must be the Original Component Manufacturer (OCM) of the product or the OCM's Authorized Distributor with traceability to the OCM. KLX Aerospace Solutions will only accept hardware with an unbroken chain of custody from these authorized manufacturers or distributors.</p> <p>Authorized distributors shall provide certification to OCM approved distribution. Or provide evidence of certification, or approval from the appropriate OCM of the product supplied to KLX Aerospace Solutions.</p>
*A.7	<p><u>KAPCO Self Release on Behalf of KLX Aerospace Solutions</u></p> <p>KAPCO to perform Honeywell Self Release requirements on behalf of KLX Aerospace Solutions and per KAPCO PQQ-400 (W/I-400-4)</p>
A.8	<p><u>HSM17 Quality Requirements (UTAS End Use)</u></p> <p>HSM17, Latest Revision, Applies.</p> <p>The supplier must ensure that all requirements within HSM17, Latest Revision, are met.</p>
B	<p><u>Inspection Plans and Sampling Methodology</u></p> <p>Supplier's acceptance plan must meet the Quality System Inspection and Sampling methodology of the design holder, identify the inspection requirements, and provide for recording of the results.</p> <p>KLX Aerospace Solutions sampling plan is based on C=0 results and all manufactured lots found to have defective hardware will be returned to the supplier.</p>
C	<p><u>Protection of Materials</u></p> <p>The supplier must ensure that all items are packaged adequately to ensure that hardware is delivered to KLX Aerospace Solutions undamaged. The supplier will be responsible for repackaging at their expense if required. If there is damage due to inadequate packaging, the items shall be subject to rejection. Individual boxes/cartons <u>shall not exceed 40 lbs. in weight.</u></p> <ul style="list-style-type: none"> Product must also be protected against corrosion, rust or any elements which may cause a visual rejection or product failure Silver plated parts or parts/assemblies containing silver components shall be protected from sulfur-laden fumes, or other sources that cause tarnish <p>Electrostatic Discharge (ESD) product must be protected in ESD packaging.</p>
C.1	<p><u>Thread Protection</u></p> <p>When print or specification requirements do not already mandate explicit thread or packaging protection, threads must then be sleeved or individually packaged in a manner to prevent damage.</p>
*C.2	<p><u>Electro Static Discharge (ESD) Protection</u></p> <p>Electro Static Discharge (ESD) Packaging and identification required as per specifications. All documentation must be packaged separately from the parts – not sealed in bags with the parts.</p>



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C.3	<p><u>Frozen Goods</u> <u>Material requiring storage at -18°C / 0°F need qualified packaging (within sealed bag), condition (including cooling agent) and identification (outside labeling)</u></p>
D	<p><u>O-Rings/Packings/Rubber Products/Age Sensitive Products</u> A test report in accordance with the material or product specification is required with each shipment. Certifications must include the batch number and cure date if age controlled. (format may be standard mm/dd/year or 4Q01 format).</p> <ul style="list-style-type: none"> • Test reports must show actual values as required by the specification. • Not more than Fifteen (15) percent of the shelf life or Twelve (12) quarters, whichever is less, may have expired prior to shipment to KLX Aerospace Solutions. • All lots must be segregated and identified to maintain batch and cure date traceability. • All Distributers must also include a Certificate of Conformance (DCC) • Distributers shall include all documents that include full traceability to the original manufacturer for each lot in a shipment. <p>For rubber products other than O-Rings and Packings (seals, gaskets, etc.), a Material Certification with batch number and cure date is required if a Test Report is not available</p> <p>This clause applies to all age sensitive products.</p>



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Material, Physical/Chemical Certifications

Supplier shall provide material, physical and chemical certifications with actual physical and/or chemical results with each shipment as required by the specification.

Original mill cert not required, if all specification conditions for actual results are met and certified in a test report.

The certifications must meet the following requirements:

- Be on a company letterhead.
- Contain signature and title of an authorized quality representative.
- Include specification(s) and revision *level(s)* used to produce the order.
- Certify in accordance with applicable purchase order, contract, drawing and specifications requirements, including **type, grade, class, heat/lot, results of testing as applicable.**

In addition to the above:

***E**

- If the shipment contains multiple processed lots within each manufactured lot, each processed lot must be segregated and identified to maintain complete traceability in each shipment. For instance, a shipment containing two heat-treated lots, each heat-treated lot shall be segregated and identified to maintain traceability in the shipment.

This does not include vendor proprietary or catalog items.

- Certifications may be on same page as Manufacturer's C of C if appropriate for the Manufacturer's procedures.

Note 1: Material (Chemical & Physical properties), and process certifications are not required with the shipment on Ball Bearing, Roller Bearing, and Pin Bearing commodities.

Exception: When a FAIR is required, the full certification package is required to allow validation and acceptance. Contact your buyer to determine if FAIR validation is to occur at manufacturer's facilities or at KLX Aerospace Solutions.

Note 2: Certifications shall be made available within 48 hours of specific request.

Note 3: Material certifications may be substituted in lieu of a test report if the product is non-metallic. Material certifications submitted in lieu of test reports shall contain the batch number and cure date.

<p>E.1</p>	<p><u>Material Certification</u></p> <p>Supplier shall provide material certification with each shipment as required by the specification. The certification must meet the following requirements:</p> <ul style="list-style-type: none"> • Be on a company letterhead. • Contain Signature and title of an authorized quality representative. • Include specification(s) and revision level(s) used to produce the order. <p>Certify in accordance with applicable purchase order, contract, drawing and specifications requirements, including type, grade, class, heat/lot, results of testing as applicable.</p> <ul style="list-style-type: none"> • Per QAP 33.0 Clause A, if multiple manufactured lots are supplied, they shall be segregated and identified on the Manufacturer Certificate of Conformance. If the same material specifications were used for all lots provided, then only one material certification statement or document is required. <p>If different material specifications were used for each manufactured lot provided, then the material certification statement or document must identify which manufactured lot received is associated with each material specification(s).</p> <p>Material certification may be on the same certification as the Manufacturer’s Certificate of Conformance.</p> <p>If specifications do not identify a specification for the material, then material certification shall identify what specification was used.</p> <p>If QAP33.0 Clause E is also present on purchase order for the specific line / part number, then the requirements of clause E.1 take precedence and clause E is disregarded.</p>
<p>*E.2</p>	<p><u>Third Party Tests Required by Design Holder</u></p> <p>It is the responsibility of the supplier to comply with any third party testing requirements that are mandated by the design holder. All test reports for products ordered on face of the Purchase Order shall be retained on file at supplier’s facility and made available within 24 hours of any request for copies.</p>
<p>E.3</p>	<p>Supplier must provide copy of original mill certification.</p>
<p>E.4</p>	<p>Hazmat Material Hazardous materials need Material Safety Data Sheet (M.S.D.S.) and label:</p> <ul style="list-style-type: none"> - European Suppliers (MSDS and label in DE, EN and FR) - American Suppliers (MSDS and label in EN)



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Special Processes

Certification for special processes, such as heat-treating, chemical processing, plating, etc., shall be submitted with each shipment. Certifications may be transcribed to the MFR Test Report or MFR C of C for parts processed internally, or a Processor's certification may be included.

Specification(s) and revision *level*(s) used to produce the order are required.

If product is a customer proprietary item, processes shall be performed by an approved supplier(s) when required by the OEM design activity/Cage Code holder and the processor's certification must be included.

A list of approved process suppliers for other OEM's is available from the KLX Aerospace Solutions Buyer or Supplier Quality representative. Approved sources and specifications shall be evaluated during contract review and prior to release for production.

All process certification(s) shall be completely legible, and reproducible. * KLX Aerospace Solutions will review documentation for compliance to requirements, legibility, and reproducibility by electronic scanning and/or copying.

The APSL requirement does not apply to standard or commercial standard items, however, the process certification/transcription shall be required.

If the shipment contains multiple special processed lots within each manufactured lot, each processed lot must be segregated and identified to maintain complete traceability in each shipment. (Example: when a manufacturing work order is split into two separate heat-treated lots, each heat-treated lot shall be segregated and identified to maintain traceability in the shipment).

F.1

NADCAP CERTIFIED APPROVED SPECIAL PROCESSORS REQUIRED

All special processes, such as heat treating, chemical processing, plating, etc, shall only be performed by NADCAP certified processors.

Test report or certification to process must be provided.

This requirement may be invoked for special processes on industry standard parts.

<p>*F.2</p>	<p><u>Oxygen Cleaning Process Certification</u> Oxygen Cleaning process certification is required. Suffix of part number specifies process to be certified to.</p> <p>.OCP – requires Boeing process 27M100. Certify P/N with “.OCP” suffix. .OCPS - requires MIL-STD-1359 and/or SAE ARP1176 Standard Certification. Certify P/N with “.OCPS” suffix. .OXY – requires Boeing process DPS 4.901... Certify P/N with “.OXY” suffix. .OCPM – requires Northrop Grumman MEPS-7000-70 process. Certify P/N with “.OCPM” Suffix.</p>
<p>F.3</p>	<p><u>Hamilton High Strength Fasteners (HSM17)</u></p> <p>Fastener Manufacturers producing externally threaded fasteners with a minimum ultimate tensile strength of 150,000 pounds per square inch or greater shall be AS9100 registered and Hamilton Sundstrand approved. This includes high strength fasteners produced to Hamilton Sundstrand drawings, military, federal and industrial specifications. Approved suppliers are listed in Hamilton Sundstrand’s Report #80 under “<i>Fastener Manufacturers, High Strength</i>”.</p> <p>All special processes and non-destructive testing of Hamilton Sundstrand, military, federal and industrial specifications (externally threaded fasteners) with a minimum ultimate tensile strength of 150,000 pounds per square inch or greater shall be performed by a Hamilton Sundstrand approved supplier (HS Report 80/85).</p> <p>These requirements apply to all direct and indirect Hamilton Sundstrand suppliers.</p>
<p>F.4</p>	<p><u>Boeing D1-4426 Requirements Apply</u></p> <p>The Boeing D1-4426 web site specifies how The Boeing Company assures that special processes, production of raw material and the procurement of selected parts standards are performed in accordance with contractually established engineering specifications, drawings and quality requirements.</p>



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***F.5**

Chromate Verification

Chromate verification testing and documentation required on manufacturer's Certificate of Conformance or Test Report. Verification testing shall be performed on one piece minimum, to ensure coating is Hi-Kote 1 with chromates.

Coating analysis shall be performed using scanning electron microscopy, energy dispersive X-ray spectroscopy or X-ray fluorescence techniques per drawing notes.

F.6

UTAS PART MARKING REQUIREMENTS

Part marking shall be in accordance with UTAS part marking specifications noted below as called out on the HS Drawing.

- If the supplier does not have a Hamilton Sundstrand designated supplier code, the supplier will assume KLX Aerospace Solutions ' primary supplier code, "16209" and apply the code as specified within the applicable part marking specification.
- If applicable, the Supplier is to validate NDT requirements (100% / Sample testing). Also, confirm that the NDT stamp letter matches the actual test requirement.

HS333

Supplier shall utilize the latest revision using the Method as identified on the print. HSM17, Part Stamping/Special Marking requirements applies. Cage Codes 73030: if no part marking specification is indicated - default to HS333.

PN17.50

Supplier shall utilize latest revision marking requirement using the Method as identified on the print. Unless otherwise specified, PN17.50, para 3.14.2 applies.

MIL-STD-130 (Source Control Item)

The Method for part marking will be identified on the Hamilton Sundstrand print. HSM17, Part Stamping/Special Marking requirements apply

ESR1386

Supplier shall utilize the latest revision using the Method as identified on the print.

Additional details and a UTAS (Hamilton Sundstrand) Non-Destructive test stamp quick reference guide can be found at:

**<https://www.KLX.com/sitemap.cfm>
Click on "Supplier Communications" link**



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F.7 Goodrich Aerostructures Controlled Processes and Materials per QA-111

The Goodrich Aerostructures Qualified Supplier Document (QSD) lists processes that require Goodrich Aerostructures approval per RPS 1.000-2 Controlled Processes and Materials. Nadcap accreditation is required for all controlled processes where applicable. Suppliers or subcontractors may only perform those controlled processes for which the supplier is listed in the QSD. Use of QSD listed sources does not relieve the supplier's responsibility for the quality of purchased materials and services.

This includes Goodrich S700 part numbers but not industry standards (NAS / AS / AN for example).



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First Article Inspection Report (FAIR) for Customer Proprietary Parts

A FAIR shall be submitted to KLX Aerospace Solutions with the **initial** shipment and as per rules for each OEM quality requirement (ref. Table I) and using AS9102 format. The FAIR shall be on file at the supplier's facility and available upon request.

Critical NOTES:

- 1. Honeywell Proprietary parts DO require a copy of the FAIR to be sent with the initial shipment and then whenever required, as per SPOC 124 Events Table.**
- 2. Reference QAP 33 Clause "R" (SPOC 124) for Honeywell Proprietary part's requirements and timing.**

A FAIR is also required if there has been:

- tooling change,
- drawing change (FAIR documenting attribute and/or notes changed),
- drawing changes which have no effect on product must be documented on a new FAIR stating "no effect"
- change in the manufacture/production location.

***G**

The following information is required on the FAIR:

- Supplier Name
- Supplier Code
- Part Number
- Latest Revision
- Purchase Order Number
- Inspector Name / Stamp
- FAIR Date
- Blueprint Zones
- All Blueprint characteristics
- All Blueprint Notes (If a note does not apply, identify the note on the FAIR as N/A)

If a FAIR is not available, it may be substituted with an inspection report containing the same information contained in a FAIR (**does not apply if in violation of design holder's requirements**). **Exceptions will require prior quality assurance approval.**

Note 1:

Customer Proprietary Part Numbers require compliance to that Customer's Quality System Standard Requirements for FAIR (e.g. documentation, format and frequency). Customer Proprietary CAGE Codes may require First Articles (refer to TABLE I).

Table I provides examples of Customer Proprietary Cage Codes which require compliance to that Customer's Quality System's Standards for First Article. Additional Customer Proprietary CAGE Codes may exist, requiring First Articles, and KLX Aerospace Solutions Aerospace Inc. should be contacted as necessary, to ensure compliance to that Customer's System Standard Requirements.



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G.1 Documents Required on File

The manufacturer of the product supplied must have a valid first article inspection report **compliant to AS9102** on file **and available upon request**.

G.2 Detailed Inspection Plan Required

The supplier of the product must submit a detailed inspection plan (DIP) applicable to the manufactured lot provided. Format is supplier option, but It shall be **compliant to AS9102, FORM 3 Characteristic and Accountability**. As a quality document, it shall remain available upon request.

Notification, Containment, and Corrective Action of Discrepant Orders

H

1. The supplier shall provide prompt written notification to KLX Aerospace Solutions when suspect nonconforming products or processes are discovered to have shipped. Notification shall include:
 - Part Numbers
 - Traceability (lot, serial, and manufacturer-numbers),
 - Ship dates
 - Quantities
 - Purchase Order number
 - Description of the nonconformance.
 2. Upon notification of non-conformity by KLX Aerospace Solutions the supplier shall complete containment activity within 48 hours.
 3. When formal corrective action is requested by KLX Aerospace Solutions:
 - Enter containment in the CAR within 48 hours
 - Submit a formal corrective action response by the specified due date
 - Extensions shall be requested on or before the due date
 4. KLX Aerospace Solutions uses an internal corrective action tracking system known as 'HQMS'. Email notifications will be sent to suppliers when a corrective action has been assigned.
 5. When a shipment is received without the required documentation:
 - Corrected documents shall be submitted within 48 hours of specific request
 - Failure to submit required documentation within 48 hours may result in a formal rejection and/or corrective action
 - Shipment is subject to return within 30 days if documents are not corrected
 6. When processes or tooling are discovered which will not produce conforming hardware, discontinue production until failure modes are resolved and corrected or authorized MRB actions are complete.
- In the event that the supplier has determined that KLX Aerospace Solutions has rejected material in error, the supplier shall contact the assigned KLX Aerospace Solutions Supplier Quality Engineer or the KLX Aerospace Solutions Buyer.



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I	<p><u>Lab Certified Source (LCS) Requirements</u> Supplier to certify hardware as tested to current Pratt & Whitney (P&W) LCS Materials Control Laboratory Manual requirements, including Section F-45 as applicable. All documents shall be stamped "Parts have been controlled to P&W requirements for LCS per P&W-MCL Manual Section F-17" or a similar statement.</p>
J	<p><u>Supplier Acceptance Test Procedure (SATP)</u> Requires acceptance testing by the supplier in accordance with an acceptance test procedure prepared by the supplier and submitted for approval. A copy of the SATP data sheet must be submitted with each shipment.</p>
K	<p><u>Fixed Process Control (Honeywell Aerospace SPOC 110, when Clause R is imposed on the order)</u> The supplier's manufacturing processing procedure must be submitted to the KLX Aerospace Solutions Buyer and approved by the design authority prior to production of a part with a fixed process control. Once a fixed process approval has been obtained, any change requires re-submittal to the KLX Aerospace Solutions Buyer and approval by the design authority prior to implementation. Fixed process control is specified by engineering documents, such as a note on the drawing, material specification or other document stating "fixed process is required".</p>
L	<p><u>Customer/Government Source Inspection</u> Customer source inspection is required prior to shipment from your facility. 1. If this is a government order, promptly notify the government representative who services your area so that appropriate planning for GSI can be accomplished. On receipt of this order, promptly furnish a copy to the government representative that services your area. If no government agency can be located, notify your Buyer immediately. 2. If this is a commercial order, contact your Buyer to arrange for customer source inspection.</p>
M	<p><u>MRB Authority</u> The supplier is <u>not</u> authorized MRB activity without receiving prior approval in writing by the cage code holder. For OEM designed product ONLY, the supplier may request material review consideration for nonconforming material that cannot be reworked to fully conforming drawing/spec requirements. The request must be submitted in writing to the KLX Aerospace Solutions Buyer and Supplier Quality Engineer (SQE) contact point for coordination with the design authority. Nonconforming product, including shipments that do not meet documentation, certification, and traceability requirements shall not be shipped to KLX Aerospace Solutions until prior approval in writing has been received. If MRB authority has been granted, the supplier must comply with the MRB instructions for marking the parts, please note that general C of C's do not need to be identified showing "MRB Approved" unless requested to do so by the MRB authority.</p>



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N	<p><u>Aircraft Parts Documentation Requirements</u></p> <p>The item on the face of the purchase order must be an FAA or JAA/EASA approved item. The following conditions apply:</p> <ul style="list-style-type: none"> • If the supplier holds PMA on the item, the item must have appropriate markings per the applicable FAA requirements and the statement “FAA-PMA” must appear on the Certificate of Conformance (C of C) or test reports. The C of C must also include a direct shipment authorization statement if the supplier holds direct shipment authorization from the Production Approval Holder (PAH). • If the supplier holds TSOA on the item, the item must have appropriate markings per the applicable FAA requirements and the statement “FAA-TSOA” and the TSO number must appear on the certificate of conformance or test reports. The C of C must also include a direct shipment authorization statement if the supplier holds direct shipment authorization from the Production Approval Holder (PAH). • In addition to all documents requested in clauses A,D,E,F and G, the supplier may provide an 8130-3 or EASA “Form One”. <p>If the supplier is the PAH, a production certificate statement of conformity with the production certificate number is acceptable in lieu of the documents requested in clauses A,D,E,F and G and fulfill the requirements of clause N, product must still be marked in accordance with FAA/JAA/EASA requirements.</p> <p>If the supplier is not the PAH and does not hold PMA or TSOA for the item being ordered, and supplier cannot produce an 8130-3 tag, the supplier must take exception to this clause and request authorization to remove this clause from the purchase order. Failure to do so will result in the product being rejected.</p> <p>If the item is not currently FAA or JAA/EASA approved, clause N should be removed from the face of the purchase order prior to acceptance by the supplier.</p>
N.1	<p><u>FAA/PMA Marking Prohibited</u></p> <p>Parts provided on this Purchase Order are for OEM use only and not for the aftermarket. DO NOT mark with FAA/PMA.</p>
O	<p><u>Airworthiness Approval Tag Requirement</u></p> <p>FAA Form 8130-3, JAA Form One or EASA Form One required with each shipment.</p>



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KLX Aerospace Solutions Bar Coded Supplier Shipping Label

- A bar coded shipping label is required on the outside of each box in each multi-box shipment.
- Multiple orders within one box shall have a bar code label for each unique order contained in the box and affixed to the outside of the box.
- When shipping a skid containing one unique order only, only one label is required.

CRITICAL NOTES:

P

A unique order is one Purchase Order / Part Number / Manufactured Lot combination.

Multiple Purchase Orders for one part number and/or multiple lots to fulfill one Purchase Order and part number are not one unique order.

A representative sample of the required KLX Aerospace Solutions supplier bar code label is shown below. .

Vendors who have been incorporated into KLX Aerospace Solutions's Buyer Supplier Portal (BSP) will be able to create their labels and track shipment status from the Portal. Vendors can obtain information regarding the portal from their buyer.

BSP bar code training slides can be found at:

https://www.KLX.com/quality/supplier_communications.cfm

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Bar Code Label Exam

Requested: [REDACTED]		KI.X Inc. 9835 NW 14TH ST, MIAMI, FL 33172	
Printed: [REDACTED]		1 of 1 USA	
PO Number	[REDACTED]		
PO Type	[REDACTED]		
Line Item	[REDACTED]		
Part Number	[REDACTED]		Rev LATES
Pack Slip #	test		
Total Ship Qty	[REDACTED]		Carton Qty [REDACTED]
PSL			

P Cont.	<p>Documentation requirements for multiple box shipments:</p> <ol style="list-style-type: none">1. Each box in the shipment shall contain a copy of the required documentation or2. the box containing the required documentation shall be labeled or clearly marked <p>“DOCUMENTATION ENCLOSED.”</p>
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<p>Q</p>	<p><u>Lubrication Requirements (Bearings/Pulleys/etc.)</u> If lubrication is required, all lubrication dates must be current within six (6) months of the shipping date to KLX Aerospace Solutions.</p> <p><u>Honeywell designs</u> Unless otherwise required by specification: Bearings that are lubricated for use shall be shipped less than 6 months from the lube application date.</p> <p>Lube date must be included on manufacturing paperwork.</p> <p>Bearings lubricated with preservative compounds shall be inspected for corrosion prior to shipping if more than 5 years from the application date.</p>
<p>Q.1</p>	<p>If lubrication is required, all lubrication dates must be current within twelve (12) months of the shipping date to KLX Aerospace Solutions.</p> <p>Lube date must be included on manufacturing paperwork.</p> <p>Bearings lubricated with preservative compounds shall be inspected for corrosion prior to shipping if more than 5 years from the application date.</p>



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Honeywell Aerospace Quality Requirements

The latest version of the Honeywell Aerospace Supplemental Purchase Order Condition (SPOC) Manual, SPOCS 001, 002 or 003 are invoked on this order as per Note 1 below – minus SPOC 149. (Honeywell’s SPOC 149 is not a requirement on these orders).

If you do not currently have access to the Honeywell Aerospace SPOC manual and APSL access can be obtained by contacting your KLX Aerospace Solutions buyer or supplier quality engineer. You will be provided with a unique user name and password. Review of SPOC requirements is mandatory.

<https://www.supplier.honeywell.com/servlet/com.honeywell.supplier.MainServlet>

For purposes of interpreting SPOC Manual requirements by Honeywell Aerospace sites, the blueprint Cage Code will identify the Cage Code holder and Honeywell site. Review of HW SPOC Manual for requirements is mandatory.

SPOC Manual General Requirements Section 1.0, 1.1 and 1.2, in their entirety do not apply. All other SPOC Manual requirements as flowed are binding

The following also apply:

Suppliers with design authority are required to notify KLX Aerospace Solutions promptly, in writing, of any changes of fit, form or function, or safety of product and obtain approval prior to manufacture and delivery. Supplier shall submit proposed changes to the Buyer including but not limited to: process – material – design – software.

When the source of supply is specified on the Honeywell drawing / technical data in any way, only those sources listed shall be used. Use of any alternate sources must be approved by Honeywell and added to the drawing/technical data before use. Contact your buyer for exceptions.

***R**

Suppliers shall be third-party registered and/or may receive periodic system audits, or be subject to periodic compliance audits by Honeywell and/or KLX Aerospace Solutions. Suppliers assume the cost of systems audits.

Critical Notes:

1.) Adherence to the appropriate Group SPOC codes for the following, are based on your manufacturing authority, and are invoked on this order:

a.) SPOC 001 is for manufacturers with design authority

Certifications shall have the Honeywell part number.

Vendor part number must be referenced on either CofC or pack slip.

b.) SPOC 002 is for manufacturers without design authority. May include Specification Control or Standard part prints that call out specific dimensional or Honeywell controlled processing methods.

c.) SPOC 003 is for standard and/or catalog hardware providers and other Vendor Controlled Items (HW VICD’s).

2.) SPOC 124 rules for FAIR apply to all manufacturers of HW parts, to include all Purchase Orders issued by KLX Aerospace Solutions.

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<p>*R</p> <p>Cont.</p>	<p>3.) If a FAIR meeting all requirements of SPOC 124 has not been validated by a Honeywell FQE and uploaded to the Honeywell Fair Tracker or Net Inspect, and a hard copy has not been sent in with a KLX Aerospace Solutions order, then the pertinent hard copy FAIR SHALL be sent with the next shipment of any part number and then again as necessary, in order to meet the SPOC 124 Event Table requirements.</p> <p>A “bubbled” print establishing direct traceability to each print characteristic noted in the FAIR must be submitted with the FAIR.</p> <p>If a FAIR is required to fulfill SPOC 124, neither Honeywell FQE validation nor Fair Tracker/Net Inspect upload is required for KLX Aerospace Solutions Purchase Orders. KLX Aerospace Solutions will use the hard copy provided to validate and upload as needed.</p> <p>If a First Article is required per SPOC Event Table and the part number is an assembly:</p> <ul style="list-style-type: none"> • A copy of the AS9102 FAIR for each HW detail part in the assembly must also be included in the FAIR package for the assembly part number ordered. <p>EXCEPTION Bearings manufacturers: When a FAIR is required (partial or full), contact your buyer for instructions.</p> <p>When a FAIR is the result of a 2 year lapse in production, the supplier SHALL note such on the FAIR.</p> <p>4.) A completed Detailed Inspection Plan (DIP), meeting the requirements of SPOC 128, and pertaining to the lot shipped, SHALL be provided with each shipment. NOTE: Suppliers having:</p> <ul style="list-style-type: none"> • current HW Self Release Approval • KLX Aerospace Solutions DIP process audit approval per KLX Aerospace Solutions QWI-45 and QAF-89 or • another Alternate Plan approved by Honeywell <p>are exempt from this requirement. Proof of all alternate plans will be required when used in lieu of a DIP. Contact your buyer or supplier engineer for details regarding DIP process audit approval. A signed release from DIP requirements will be provided upon successful completion of an audit.</p> <p>5.) All Material Certifications and controlled process certifications (SPOC 001 & 002 requirements) to meet current SPOC revision (type, class, grade): Certifications shall include name of process source, specifications and revision used. The physical and chemical process and heat numbers shall be indicated. Certifications must clearly state conformance to all specifications in their entirety, including embedded specifications with specific acceptance criteria, additional processing requirements and any specific requirements that pertain to hardware approval or acceptance. (Drawn directly from SPOC 140.2, Table III C of C Requirements)</p>
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Mercury Free Certifications

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Supplier must certify the supplied item(s) is/are Mercury Free. The certification must be in the form of a certification sheet. The certification sheet must contain the following information: (a) contract/ PO Number, (b) National Stock Number (NSN) (c) manufacturer’s cage code and part number, (d) the date of shipment and quantity shipped and (e) the following statement:

“The undersigned hereby certifies that the material and/or parts shipped on the subject order/contract conform to the requirements of the supplier purchase order/contract. Also, the material furnished is free from mercury contamination. Mercury bearing instruments and equipment which might have caused mercury contamination was not used in manufacture, fabrication, and assembly or testing of any material furnished under this order/contract.”

Record Retention

U

Quality/Inspection records shall be retained on file by the supplier:

- Radiographic film - eleven (11) years unless an alternate term is approved.
- Non-traceable, non-serialized parts – eleven (11) years
- Traceable parts as identified on the drawing or purchase order - Indefinitely
- Serialized parts as identified on the drawing or purchase order - Indefinitely.
- Critical parts as identified on the drawing - Indefinitely
- Distributor standard off the shelf product - 7 years
- Certifications must be available to KLX Aerospace Solutions within 48 hours from request.

MINIMUM retention periods, beginning with the date the order was completed. In the case where a specification, contract or purchase order requires a greater retention period, the more stringent requirement will apply.



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*V	<p><u>Quality Systems</u> Manufacturing suppliers' quality systems shall be certified to ISO9001:2008, TS16949, AS9100/EN9100 or an approved alternate. Distributor's quality systems shall be compliant to AS9120/EN9120, AS7103/AS7104, ASA100, QS9000 or an approved alternate.</p> <p>Outsource vendors that are used to certify materials, test and calibration laboratory results, shall be certified to ISO/IEC 17025.</p> <p>Internal manufacturer labs shall be certified to ISO/IEC 17025, NADCAP certified or compliant with ISO/IEC 17025 and also maintaining certification to AS9100 Management Systems.</p> <p>All providers shall be willing to provide a copy of their certification(s) when requested.</p> <p>Supplier management shall notify KLX Aerospace Solutions (via the Buyer) of all significant changes to the supplier quality system. Significant changes include but are not limited to:</p> <ul style="list-style-type: none"> • Change in location of facility • Change in ownership • Change in senior company management • Change in quality system <p>KLX Aerospace Solutions will perform periodic evaluations of supplier's quality systems. Suppliers who are NOT third party registered:</p> <ul style="list-style-type: none"> • May receive periodic system compliance audits, but only as necessary to maintain their level of approval. • May be subject to a compliance audit by Honeywell, in order to maintain their approval to provide Honeywell design parts. <p>If not third party registered and a compliance audit becomes necessary to maintain required approval, supplier assumes the reasonable and agreed cost and schedule. . Failure to comply may result in disapproval as an active and approved supplier to KLX Aerospace Solutions.</p>
W	<p><u>Acceptance at Supplier's Facility</u> Source inspection is required prior to shipment by a KLX Aerospace Solutions appointed source inspector unless the supplier is Honeywell or KLX Aerospace Solutions Self Release, or waived by KLX Aerospace Solutions Quality Assurance. Evidence of Source Inspection or Self Release shall be annotated on the packing slip. (Self release status allows shipment without source inspection)</p> <p>The supplier shall make arrangements for source inspection at least 5 days prior to the required ship date. Call your buyer for direction.</p>



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X	<p><u>Suppliers with Design Authority</u></p> <p>Suppliers with design authority are required to notify KLX Aerospace Solutions promptly of any changes of fit, form or function or safety of product on this order in compliance with blueprint and obtain approval prior to manufacturing and delivery. Supplier shall submit proposed changes to the KLX Aerospace Solutions buyer.</p>
Y	<p><u>The Supplier Shall Provide a Packing Slip With Each Shipment</u></p> <p>The packing slip shall include the following and shall be completely legible and reproducible:</p> <ul style="list-style-type: none"> • Purchase Order Number • Part Number • Quantity
*Z	<p><u>Self Release Requirements</u></p> <p>Vendors accepted into the KLX Aerospace Solutions Self Release Program shall maintain their process as per the KLX Aerospace Solutions SR Audit and Agreement (QAF-108).</p> <p>All changes shall be approved by KLX Aerospace Solutions Quality prior to implementation.</p> <p>All escapes shall be investigated and corrected with a documented Corrective Action.</p> <p>When an escape has occurred, at a minimum, the next three manufactured lots shall be 100% inspected to ensure process has been corrected.</p>