



QUALITY FORM

Form QC – 1299
Rev. D
02-NOVEMBER-2011

DOCUMENT CHANGE NOTICE (DCN) FORM

This DCN form is to be completed for any minor proposed change to a QMS or EMS procedure. Please see OP 02.1 for instructions for use.

Document Title: Purchase Order Quality Codes		Rev: AB	Doc. No: QP-137
DCN No: 15-17QA	New Rev: AC	Release Date: 10/28/15	Next Review: N/A
Originator: Norman Harris			Date: 10/28/15
Description Of Change: Add to Code 74: 1. Inspection records for Standard Hardware (AN, MS, NAS, M, etc.), Off-the Shelf items (COTS) that is not modified or altered, or is not a Critical Part, are to be retained for a period of five (5) years.			
Justification/Reason for Change: Customer and First Article Inspection requirements do not require retention of this category of part for more than 5 years by the B-E supplier. B-E records are internally retained for 10 years and include the supplier certifications.			

Initiator Review / Approval

Norman Harris

10/28/15

Print Name

Signature

Date

Process Owner Review / Approval:

Lisa Ardino

10/28/15

Print Name

Signature

Date

Director of Quality Improvement & Completeness Review / Approval

Lars Novak

10/28/15

Print Name

Signature

Date

Other Review / Approval (FAA, DCMA, Customer, etc.)

Print Name

Signature

Date

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Approvals:

Operations	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Purchasing:	Print	<u>Lisa Ardino</u>	Signature	<u><i>Lisa Ardino</i></u>	Date:	<u>5/20/15</u>
Quality	Print	<u>Lars Novak</u>	Signature	<u><i>ML</i></u>	Date:	<u>5-20-15</u>
Process Owner	Print	<u>Lars Novak</u>	Signature	<u><i>ML</i></u>	Date:	<u>5-20-15</u>
Finance	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Program Management	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Contracts	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Human Resources:	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Legal	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Inspection:	Print	<u>Peter Kelley</u>	Signature	<u><i>Pete Kelley</i></u>	Date:	<u>05/20/2015</u>
Other	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
FAA:	Print	<u>N/A</u>	Signature	<u>N/A</u>	Date:	<u>N/A</u>
Author:	Print	<u>Norman Harris</u>	Signature	<u><i>Norman Harris</i></u>	Date:	<u>5/19/15</u>
Release Date (initial/date):					<u><i>ML</i></u>	<u>5/21/15</u>

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1.0 PURPOSE:

Quality Codes define the quality requirements to be met by the suppliers. These codes shall be included on all purchase orders as Quality Clauses for materials directly related to product manufacture.

2.0 SCOPE:

This Work Instruction applies to all purchase orders generated to support engineering and direct material requirements from purchasing.

3.0 REFERENCES & DEFINITIONS:

3.1 Procedures

- 3.1.1 OP 6.2 – Supplier Processing of Non-Conforming Material – Processes
- 3.1.2 OP 7.2 – Control of Government Property
- 3.1.3 OP 10.3 – First Article Inspections
- 3.1.4 OP 16.1 Control of Records
- 3.1.5 QP-189 – Conformity Audit Procedure

3.2 Forms

- 3.2.1 BE-003 – Age Controlled Item Label
- 3.2.2 QC 1351 – Part Number Accountability
- 3.2.3 QC 1352 – Product Accountability
- 3.2.4 QC 1353 – Characteristic Accountability

3.3 Other Documents

- 3.3.1 10 CFR Part 45.15 – Identification and Registration Marking.
- 3.3.2 ASI/ASQC Z1.4 - Sampling Procedures and Tables for Inspection by Attributes.
- 3.3.3 ASTM E1417 – Standard Practice for Liquid Penetrant Testing.
- 3.3.4 ASTM E1205 – Standard Practice for use of a Ceric-Cerous Sulfate Dosimetry System

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- 3.3.5 EIA RS-471 – Symbol and Label for Electrostatic Sensitive Devices.
- 3.3.6 SAE AS5553 – Counterfeit Electronic Parts, Avoidance, Detection, Mitigation, and Disposition
- 3.3.7 SAE AS9102 – Aerospace First Article Inspection Requirements
- 3.3.8 Mil-Std-105 – Sampling Procedures and Tables for Inspection by Attributes.
- 3.3.9 Mil-HDBK-263 – Electrostatic Discharge Control Handbook for Protection of Electrical and Electronic Parts, Assemblies and Equipment (excluding Electrically Initiated Explosive Devices) (Metric).
- 3.3.10 Mil-PRF-21260 – Grade 10, Internal Combustion Engine Oil.
- 3.3.11 Mil-Std-453 – Inspection, Radiographic.
- 3.3.12 Mil-Std-1285 – Marking of Electrical Parts.
- 3.3.13 Mil-Std-6866 – Inspection, Liquid Penetrant.

3.4 QUALITY CODE DEFINITIONS:

1. Critical Safety Item:
The supplier shall furnish all material certifications, process certifications (heat treat, surface finish, plating, NDT, etc.) applicable to the Critical Safety Item's manufacture.
2. Critical Part:
Parts which have been identified by the Engineering drawing as "Critical" require special consideration and process control both by Breeze-Eastern and by the supplier.
 - a. Critical parts suppliers may not change any internal or subcontracted processes (or processor) or materials without B-E prior written approval.
 - b. Approved supplier process changes shall require a detailed delta first article to be completed.

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- c. B-E imposed process changes for critical parts shall require a delta first article to be completed.
- d. Supplier initiated changes shall require a first article to be completed and the change approved by B-E.
- e. The supplier shall mark the part with a serial number (or equivalent) unique to that part.
- f. For FAA-PMA parts, the requirements of Quality Code 76 FAA/PMA Part: apply as well.

20. Rough Castings:

For an initial lot of castings, each rough casting shall be given an overall visual inspection. Each rough heat-treated casting shall be subjected to penetrant inspection in accordance with MIL-STD-6866 / ASTM E1417 or magnetic particle inspection in accordance with MIL-STD-1949 / ASTM E1444. Each casting shall be radiographically inspected and the radiographs sent to Breeze-Eastern with each lot of castings. If the castings are being procured by a supplier who will subsequently be machining the castings, then the radiographic reports and film as well as the penetrant inspection reports shall be maintained on file at the supplier. Radiographic inspection must be in accordance with MIL-STD-453 / ASTM E1205. Each X-ray lot shall be serialized. Each casting subjected to X-ray inspection shall be identified by putting a dash number after the X-ray lot number. The X-ray report shall reference the inspection for each casting. For all lots, in addition to the applicable chemical and physical test results, an affidavit must show the thermal treatment (times and temperatures) performed on the casting and the alloy and temper designation.

22. Inspection/Audits at Supplier's Facility:

Breeze-Eastern, its customers, Government and/or Regulatory agencies reserve the right of access to the supplier's facility (including sub-tier suppliers) to inspect any or all of the work included in this order, to review any and all records associated with the production of

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parts/products destined for Breeze Eastern and to audit the supplier's Quality System

23. Breeze-Eastern Source Inspection (QP-136): All parts on the purchase order are to be source inspected per QP-136 by Breeze-Eastern at the supplier's facility. Supplier shall contact Breeze-Eastern's Supplier Quality Representative to schedule source inspection. To waive source inspection, the supplier must request, in writing to the buyer for source inspection to be waived. The approval for the waiver request, if approved, shall be in the form of an amendment to the purchase order or in writing from the buyer to the supplier. This communication may be via email.
24. Breeze-Eastern Certified Supplier (QP-166): Breeze-Eastern Certified Supplier: Supplier Certification required as per QP-166. Materials/parts/articles/assemblies identified as FAA-PMA are not eligible to be processed per this Quality Code and must be processed per Quality Code 76.
29. Acceptance Tests Results:
The supplier shall conduct (as applicable) all acceptance testing required by the applicable drawing(s), unless otherwise stated in writing by B-E. The records of these tests shall be maintained on file, as per the requirements of clause 74. For higher level units such as controllers, where interim acceptance testing is conducted at the supplier and the final acceptance testing is conducted by B-E, the unit and the test data sheets shall be identified with a temporary serial number to maintain traceability. These test data sheets shall be supplied with each unit shipped to B-E.
46. Qualified Products List:
This material must be purchased from a supplier listed on the Federal Qualified Products List.
52. Age Controlled Item:

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This order contains items which are subject to age control. The supplier shall:

- a. Furnish items that have at least 85% of the shelf life present upon receipt at Breeze-Eastern.
- b. Indicate the manufacturing / cure date and the expiration date on the item where physically capable, the container and the certificates.
- c. Comply with age limitations as expressed in applicable specifications for the material or components supplied.
- d. Supply a copy of form BE-003, Age Controlled Item Label with each part number shipped. The information on this form shall agree with the marking requirements in item b.
- e. Part marking shall be per the drawing requirements.
- f. The recommended format for the manufacturing/cure date and expiration date is MM/DD/YYYY. An acceptable alternate format is the QX-YYYY format. The marking of the part, any labeling and the Certificate of Conformance shall be consistent.

53. ESD Precautions Required:

The supplier shall package, handle, and protect all electrical or electronic components or higher level sub-assemblies susceptible to ESD in accordance with MIL-HDBK-263. This shall include ESD labeling with MIL-STD-1285 of EIA RS-471 sensitive electronic device symbol. The outside shipping container shall be labeled as well.

59. First Article Inspection:

First Article Inspection (FAI), reference OP 10.3 First Article Inspection applies to all suppliers, regardless of the supplier approval status. It is only required under the following conditions:

- a. when a supplier processes a part for the first time
- b. a revision occurs

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- c. a process changes
- d. a material changes
- e. a manufacturing location changes
- f. a lapse in production of 2 years.

The FAI shall require the following:

- a. A part from the first production lot, normally identified on the PO as a separate line item, is to be given a 100% inspection of all characteristics and documented with actual values on Breeze-Eastern forms QC 1351 Part Number Accountability, 1352 Product Accountability and 1353 Characteristic Accountability or per AS 9102 and its associated forms.
- b. Each item, including those in tables, on the FAIR must be related to the drawing by numbered balloons on the drawing.
- c. All characteristics, notes, or special requirements must be accepted, without exception.
- d. The FAI to be supplied is to be completed for the item identified on the PO. It is not required that all lower level FAIs be provided unless specifically requested.
- e. For higher level assemblies, a FAI shall exist for all lower levels and on file at the supplier. These lower level FAIs are to be referenced on the QC-1351, Part Number Accountability form. They shall be available upon request by B-E.
- f. Copies of all supplier purchased components/part, materials and process certifications shall form a part of the FAIR package. Materials or parts supplied by Breeze-Eastern must be identified, but do not require a copy of the certifications.
- g. A copy of the FAIR forms and the associated certifications are to be included with the shipment of the FAI part to Breeze-Eastern and a copy is to be kept in the supplier's records (see clause 74 below). The FAI part is to be tagged for identification purposes.

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- h. Upon successful completion of the FAI and at the time of shipment, a supplier is required to email the FAI and all associated documentation to the following:
FAI_Submittal@breeze-eastern.com. The FAI should be a PDF file and named in the following format: PO Part Number _ Rev (Rev. of P/N) _Supplier Code.pdf, i.e., BL-9149-1_Rev N_CB00469.pdf
- i. The production lot and the FAI part are authorized to ship to B-E prior to B-E approval, upon completion, the supplier review and approval of the FAI, unless otherwise specified on the PO.

60. Certificates of Quality Conformance Required:

The supplier shall provide a Certificate of Conformance (COC) with each shipment against a purchase order, signed by a member of the supplier's management.

As a minimum, the COC shall provide the following information:

- a. The B-E purchase order number
- b. The part number ordered, including the revision letter
- c. The quantity certified
- d. Statements indicating that the material, product and/or service furnished has been inspected and conforms to purchase order requirements.
- e. Any additional statements required by the purchase order.
- f. A listing of applicable material and special process certifications on file and available to Breeze-Eastern upon request.
- g. X-Rays, if required, are to be provided per Quality Clause 20.
- h. Printed name, signature and title of the person certifying the COC, and the date of the certification.

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- i. Electronic Signatures are acceptable provided records are on file to substantiate the signature at the supplier.
- j. Manufacturing / cure date and expiration dates per Quality Clause 52.

63. Government Property (Material):

Government property identified on this purchase order must be controlled in accordance with government property administrator's procedures. Reference: OP 07.2, Government Property Control Procedure.

64. Government Property (Tooling):

Records of all costs (material and labor) utilized in the procurement and fabrication of government provided or funded tooling shall be maintained by the subcontractor and made available to Breeze-Eastern upon request. The subcontractor shall provide an annual inventory of all government tooling or gages. The subcontractor shall maintain the calibration status of all tooling and gages used for acceptance of product. Tooling or gage non-conformances shall be reported to Breeze-Eastern immediately. In addition to the records of costs, a record of all designated special tooling used in the production of Breeze-Eastern products on this order shall be maintained by the subcontractors and made available to Breeze-Eastern upon request. These records shall include for each tool:

- a. Tool number or part number of the item to fabricated with the tool.
- b. Name and description of the tool.
- c. Purchase order number.
- d. Unit Price.
- e. The words "Government Property."
- f. Location of Tool.
- g. First Article Inspection Report validating the tooling or gage.

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65. Government Source Inspection:

Government Inspection is required prior to shipment from your plant. Upon receipt of this order, promptly furnish a copy to the Government Representative who normally services your plant, or, if none, to the nearest Army, Navy, Air Force, Marine, or Defense Supply Agency Inspection Office. In the event that the representative or office cannot be contacted, notify the Breeze-Eastern Purchasing agent immediately. Indication of government inspection must be present on the shipping documents.

69. Quality System Requirements:

The supplier shall have a documented quality system for ensuring that all product produced for Breeze Eastern conform, in all respects, to the requirements of the applicable drawing(s) and corresponding Breeze Eastern purchase order requirements. This system shall include, but not be limited to controls for:

- a. The calibration of inspection/test devices, with traceability to national standards (i.e. N.I.S.T.); with documented evidence of such.
- b. Records maintenance and storage
- c. Control of purchase material process, including supplier controls.
- d. Flow-down of specification/contractual requirements, including sub-tier contractors/suppliers.
- e. Controls for nonconforming/discrepant materials per OP 6.2, Supplier Processing of Non-Conforming Material – Processes.
- f. The inspection/testing of products/materials to be shipped to Breeze Eastern meet any and all contractual agreements/requirements; including documented evidence of such.
- g. Review and acceptance of Purchase order(s) and the requirements therein; including any revisions to previously

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accepted purchase orders; including documented evidence of such.

- h. Stock control which satisfies age and environmental controls as necessary to assure the stability and quality of inventory, as applicable.
- j. A Foreign Object Damage (FOD) program which assures the prevention of FOD material or corrosion from being included in any assembled or manufactured product.
- k. The notification of Breeze-Eastern of any significant facility or organizational changes such as company name, location, senior quality management.
- l. The notification of Breeze-Eastern in writing or email of suspected problems/non-conformances with previously delivered products.
- m. Maintenance of a program to ensure the proper operation of manufacturing software and equipment used for product/part/article inspection or test.

71. Special Process and Finishes:

The item listed in the purchase order requires one or more special processes and/or finishes. The supplier's COC shall indicate the special processes of finishes performed as well as the applicable specifications. If the special processes/finishes are performed for the supplier, then the source must be included on the COC or a copy of the source's COC must be included with the shipment. Special processes are listed under Appendix A, Special Processes.

73. Product Conformity Audit (PCA) Required:

Product Conformity Audit (PCA) required. Supplier shall perform an audit with the participation of a Breeze-Eastern representative. The purpose of the PCA is to review process control system. The PCA requires:

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- a. Provide an in process part, left in a partially completed state for review.
- b. Review and approval shall be completed using the QP-189 Conformity Audit Procedure.

74. Quality Records & Revisions:

Control of Quality records, including retention is required. All records associated with the production of the material, product and/or service provided to B-E shall be controlled in such a manner as to prevent loss and deterioration, and to allow for ease of access. These records shall be maintained on file, and provided to B-E, its customers or regulatory agencies upon request, for a period of not less than ten (10) years, unless otherwise specified. These records shall include, but are not limited to:

- a. Certificates of Conformance.
- b. Special Process certifications (see Special Process section).
- c. Inspection records.
- d. Testing records.
- e. Job cards/travelers, etc. documents used to record the production process, including operator and inspection approval of all steps/operations, etc. shown on the traveler.
- f. Receiving Inspection reports.
- g. Material certifications for all materials used for the production of the product.
- h. Corrective and Preventive Action reports including supporting data.
- i. First Article Inspection Reports shall be retained indefinitely.
- j. Product Records for Critical Parts must be retained indefinitely.
- k. Records retained for an indefinite period may be returned to Breeze-Eastern for long term storage at the end of the normal required record retention period.

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75. Breeze-Eastern Customer or Breeze-Eastern Property (Tooling and Gages):

Records of all costs (material and labor) utilized in the procurement and fabrication of Breeze-Eastern or Breeze-Eastern's customer provided or funded tooling shall be maintained by the subcontractor and made available to Breeze-Eastern upon request. The subcontractor shall provide an annual inventory of all Breeze-Eastern or Breeze-Eastern's customer tooling or gages. The subcontractor shall maintain the calibration status of all tooling and gages used for acceptance of product. Tooling or gage non-conformances shall be reported to Breeze-Eastern immediately. In addition to the records of costs, a record of all designated special tooling used in the production of Breeze-Eastern products on this order shall be maintained by the subcontractors and made available to Breeze-Eastern upon request. These records shall include for each tool:

- a. Tool number or part number and revision of the item to fabricated with the tool.
- b. Name and description of the tool.
- c. Purchase order number.
- d. Unit Price.
- e. The words "Customer Property."
- f. Location of Tool.
- g. First Article Inspection Report validating the tooling or gage.

76. FAA/PMA Part:

The following requirements for a part identified on the Purchase Order as FAA-PMA Part shall comply with the following requirements:

- a. A part identified by this quality clause is a Breeze-Eastern FAA/PMA controlled part.
- b. **This part is not subject to the Certified Supplier Program and shall be source inspected or inspected at Breeze-Eastern.**
- c. Sampling Plans utilized for this part must be a C-0 acceptance plan where any rejection results in rejection of the lot. The lot may then be inspected 100% for the failed characteristic. The

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FAA will not accept any sampling plan which will accept a lot with known rejections included which might occur with an ASI/ASQC Z1.4 or MIL-STD-105 type plan.

- d. Parts which have this clause shall be identified with the part number, the Breeze-Eastern cage code and the letters "FAA-PMA" per the requirements of 14 CFR Part 45.15.
- e. If the part marking is called out on the drawing, the location of the additional marking shall be located adjacent to, or in the area of the part number.
- f. If the part number is not called out on the drawing, mark the part with the part number, the Breeze-Eastern cage code and the letters "FAA-PMA" on a non-critical surface.
- g. If the marking cannot be affixed due to size limitations or if the drawing restriction the marking to bag or tag, a tag or label with the same information must be attached to the part or its container.
- h. If the marking is impractical (critical surfaces, part application), a tag or label with the same information must be attached to the part or its container.
- i. If the part is a catalog part procured by our source control drawing, a tag or label with the same information must be attached to the part or its container.
- j. If the location, as defined in the above, is not readily determinable, contact Breeze-Eastern for assistance in determining the appropriate location or marking requirements.

77. Protection of Supplied Materials

- a. Finished parts shall be adequately protected to prevent damage during handling and shipment.
- b. Parts shall be wrapped, bagged, or otherwise protected to prevent damage when packaged within a larger pack.
- c. Plated parts must be packaged to prevent tarnish and corrosion.
- d. Un-plated or un-finished parts shall be protected from tarnish and corrosion for a period not less than two years. Coating with

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MIL-PRF-21260 Lubricating Oil is an acceptable method for steel parts/ assemblies.

- e. Special care is to be utilized in selecting the packing and packaging system and shall support the weight of the material during the specified or selected transportation method.
- f. The seller shall be responsible for determining the method of packaging to assure protection during transit.
- g. Seller shall assume responsibility for inadequate packing that result in damage physically and/or functionally.

78. First Article Inspection – Special Requirement

The First Article Inspection requirements of Purchase Order Quality Code 59 apply with the additional requirement that a lapse in production of 1 year requires a new First Article Inspection to be performed.

79. Counterfeit Parts Prevention Program

- a. Suppliers are required to have and maintain a Counterfeit Parts Program that meets the intent of AS5553 paragraph 4.1, Counterfeit Electronic Parts, Avoidance, Detection, Mitigation, and Disposition, to ensure it does not receive counterfeit parts into inventory, use them in manufacturing, or inadvertently sell them to other parties.
- b. All electrical, electronic, electro-mechanical devices or parts used in the manufacture of products delivered to Breeze-Eastern shall be from the Original Component Manufacturer (OCM)/Original Equipment Manufacturer (OEM), their franchised distributor or authorized aftermarket manufacturer (AAM).
- c. Non-electrical standard parts, like fasteners, nuts, washers, springs, O-rings, inserts, and pins must have certification from the Original Component Manufacturer (OCM)/ Original Equipment Manufacturer (OEM) or Authorized Aftermarket Manufacturer (AAM) or authorized distributor.

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- d. In the event a part is not directly available from the OCM/ OWEM/ AAM or franchised distributors (electronics) or authorized distributor (non-electronics), purchase from independent distributors may be made but the evidence of supply chain traceability (chain of custody) back to the OCM/ OEM/ AAM shall be provided. The Certification shall clearly identify the name and location of all of the supply chain intermediaries from the original manufacturer to the final source of the product delivered to Breeze-Eastern.
- e. Suppliers that deliver next higher assemblies shall flow this requirement down to all sub-tier suppliers to prevent the inadvertent use of counterfeit parts and materials. Certifications from the OCM/ OEM/ AAM must be readily retrievable and made available upon request.
- f. The certifications shall be provided upon request or as part of a FAIR (Quality Clause 59) or Critical Safety Item (Quality Clause 1).
- g. If evidence of supply chain traceability to the OCM/ OEM/ AAM is not available, the supplier shall verify authenticity prior to shipment. The supplier may use an independent inspection/test service provided to verify authenticity. Contact the B-E buyer for the minimum verification requirements prior to shipment of any product/components.
- h. Parts shall not be used or reclaimed or misrepresented as new.

80. Customer Specified Special Process Suppliers:

The supplier is required to utilize only suppliers specified by Breeze-Eastern's customers. When this quality clause is on the PO, the supplier is responsible to contact the Breeze-Eastern supplier for directions as to the approved source for the specific process. Additional information regarding this requirement may be contained in text or note fields on the PO. Failure to utilize the specified supplier will result in rejection of the items.

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81. AIRBUS A400M LTA Document:

The Breeze-Eastern A400M LTA Document applies to this order. A copy of this agreement is located on the Breeze-Eastern webpage: breeze-eastern.com. The agreement is in the supplier Information Tab with the name "AIRBUS A400M Document LTA"

82. Environmental Protection Requirement:

The supplier shall establish and maintain compliance with all applicable federal, state and local environmental regulations and requirements for the components, parts and processes used in the manufacture of products for Breeze-Eastern.

83. OEM and Serialized Product Revision Notification:

Original Equipment Manufacturers and suppliers who are the design authority shall notify and receive approval from Breeze-Eastern in writing of any changes to the product or processes which may affect form, fit, interchangeability, reliability, maintainability, safety, purchase specification or is a critical part per Quality Clause 2. This notification shall include any change documentation required to evaluate the impact of these changes. Suppliers who are not the design authority and are producing to Breeze-Eastern specifications or drawings, shall require written notification and approval for any change to the product or processes used to produce the product.

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4.0 REGULATIONS & RESPONSIBILITIES

Quality Improvement & Completeness is responsible to define and maintain the Purchase Order Quality codes. These codes shall be identified in the Purchase Part/Purchase Part/QPR/Clauses screen in IFS for individual parts.

5.0 PROCEDURE

- 5.1 Quality will define the quality clauses applicable to purchased items and materials.
- 5.2 Quality will maintain the IFS system quality clauses in the Purchasing module.
 - 5.2.1 The clauses will be added to/updated/modified by accessing the IFS system at the Purchase Part/Purchase Part/Basic Data for Purchasing screen.
 - 5.2.2 Open the Clause Tab.
 - 5.2.3 The implementation of a new quality clause will be accomplished by displaying the total list of quality clauses using the populate button.
 - 5.2.4 Place the cursor on a new line.
 - 5.2.5 Using the “new” button, open a new line in the field area.
 - 5.2.6 Add the code number in the Clause # field.
 - 5.2.7 Add the Description of the Clause in the description field.
 - 5.2.8 Using the Save button, save the changes.
- 5.3 Maintaining a Purchase Part’s Quality Clauses.
 - 5.3.1 These codes shall be identified in the Purchase Part/Purchase Part/QPR/Clauses screen in IFS for individual parts.
 - 5.3.2 Using the Query Dialog button, open the query page.
 - 5.3.3 Put the part number that the quality clause is to be added/updated/modified/removed from in this field and press the OK button. This will display the Purchase Part screen for that part.
 - 5.3.4 Open the QPR Tab.

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- 5.3.5 Open the Clauses Tab. The list of current quality clauses will be displayed.
- 5.3.6 To add a quality clause, place the cursor on the next blank line and press the “New” button at the top of the screen.
- 5.3.7 Type in the new clause number and press the “Save” button at the top of the screen.
- 5.3.8 The list will display the current list plus the new item.
- 5.3.9 To Delete a quality clause, place the cursor on the line and press the Delete button and press the Save button.
- 5.3.10 A modification is accomplished by deleting the current clause and adding the correct clause.
- 5.3.11 These changes in the quality clauses will remain each time this part is purchased until subsequently changed.

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APPENDIX A
LIST OF SPECIAL PROCESSES AND FINISHES (Partial Listing)

Anodizing	Nondestructive Testing (e.g. MPI, FPI, etc.)
Aluminum, Ion Vapor Deposited Coating	Painting
Black Oxide Coating	Passivation
Bonding	Phosphate Coating
Brazing	Plastic Coating
Cadmium Plating	Rubber Coating
Chemical Film	Shot Peening
Chromium Plating	Silver Plating
Conformal Coating	Solid Film Lube
Copper Plating	Special Cleaning
Electrochemical Milling	Tin Plating
Electrical or Electronic Soldering	Welding and Welding Repair
Electrical Discharge Machining	Zinc Plating
Electroless Nickel Plating	
Heat Treating	
Hot Metal Joining (e.g. soldering, brazing, etc.)	
Impregnation	
Metallic Ceramic Coating	
Nedox Coating	
Nickel Plating	

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1.0 REVISIONS

REV	DATE	OWNER	DESCRIPTION OF CHANGE(S)
J	7/30/10	Norm Harris	Reformat to current requirements. Deleted Quality Clauses 14, 15, 24, 25, 67, 70 & 72. Clause 29. Added higher level unit requirements. Clause 59. Updated to reflect compliance with AS9102. Clause 60. Added allowance for Electronic Signature on C of C. Clause 69. Expanded flow down to include sub-tier suppliers. Clause 71. Changed reference for Special Processes. Clause 74. Added retention requirements for Rec. Insp. Reports, Material Certifications, Corrective and Preventive Actions and First Article Inspection Reports. Added Quality Clause 76, 77. Added Quality Clause 78 is to close CAR 1915. Added the procedures for initiation and update of the quality clauses in the IFS system. Changed Appendix A into a Table.
K	3/22/11	Norm Harris	Quality clause 76 has been updated to identify the FAA-PMA part marking requirements per 14 CFR Part 45.15, effective 4/16/11. Quality Clause 2 is updated to require a unique serial number per 14 CFR Part 45.15 and included the requirement to meet Quality Clause 76 for FAA-PMA parts.
L	4/26/11	Norm Harris	Changed form QC-1354 to QC-1353 – typo error. DCN 11-04 QA incorporated.
M	8/9/11	Norm Harris	Added Quality Clause 79, Counterfeit Parts Program and Quality Clause 80, Customer Specified Special Process Suppliers. Added “This tagged part is to be shipped without the Certified Supplier Tag or the Source Inspection Tag.” to Clause 59. Added “per OP 6.2, Supplier Processing of Non-Conforming Material – Processes” to Quality Clause 69. Completely reorganized Quality Clause 59 to clarify requirements and make it easier to understand. Deleted Clauses 4,5,8,12,13,16,21,23 due to obsolescence.
N	2/2/12	Norman Harris	Add Quality Code 81 Airbus A400M ITA Document per DCN 12-04QA.
P	4/18/12	Norman Harris	Add FOD requirement to Quality Code 69 per DCN 12-12QA.
R	5/24/12	Norman Harris	Update Quality Code 79 to reflect current customer requirements for Counterfeit Parts Prevention Program. Added “production” in g. of Quality Code 59. Quality Code 76 updated to clarify part marking when ‘Bag or Tag’ is specified on the drawing.
S			Omitted.
T	6/11/12	Norman Harris	Add: 74 j... Product Records for Critical Parts must be retained indefinitely. Add 74. k. Records retained for an indefinite period may be returned to Breeze-Eastern for long term storage at the end of the normal required record retention period.
U	8/15/12	Norman Harris	Added Shipping Container marking to Clause 53, “supplier purchased components/part” to Clause 59, 1, restated Clause 76 to clarify marking requirements, added requirement for C=0 Sampling

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			Plan, added "Electrical or Electronic Soldering" to Appendix A, List of Special processes and Finishes.
V	10/15/12	Alan Moss	Quality Code 20 – Rough Castings: Revised the third sentence and add a new sentence immediately following new third sentence per DCN 12-20 OPS.
W	3/5/13	Norman Harris	Update Quality Code 52 to include identification locations for Date of Manufacture/ Cure Date and Shelf Life. Updated Quality Code 60 to include the requirement to identify the Manufacturing / Cure date on the COC. Updated Clause 59 b. to require balloons on the drawing and e. to require sub-level FAIs to be available upon request. Add Quality Code 82, Environmental Regulation Requirements. Update Quality Clause 77 to include Sulfur free cardboard boxes. Added Clause 83 OEM and Serialized Product Revision Notification
X	3/18/12	Norman Harris	Delete Quality Clause 77 c.
Y	5/2/13	Norman Harris	Changed 69 c. to read "purchase material process, including supplier controls. Added 69 k. notification of facility, organizational changes. Added 69 l. the notification of non-conforming product previously shipped. Added 69 m. maintenance of a program to ensure the proper operation of manufacturing software and equipment used for product /part/article inspection or test.
Z	9/24/13	Norman Harris	Added to Clause 76. k. In those cases where the part is identified with a supplier's part number and cage code, the Breeze-Eastern Part Number, Cage Code and "FAA-PMA" shall be added without additional changes to the supplier's data.
AA	5/29/14	Norman Harris	Add statement to Code 52 to identify manufacturing /cure date formats.
AB	5/19/15	Norman Harris	Update format to current revision. Update Code 83 to reflect requirements for Revision Notification based on Design Ownership. Added 3.1, 3.2, and 3.3. to meet the format requirements. Added Quality Codes 23 & 24. Updated Code 74 to 10 years.