



WORK INSTRUCTION	QP-137	Revision: AM Page 1 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

RELEASE DATE: _____

(signature / date; to be filled in only after all approvals received)

Approvals:

Operations:	Print	Michael MacLaren	Signature	Approved in QT9	Date	2/27/2024
Engineering:	Print	Jim Fett	Signature	Approved in QT9	Date	2/26/2024
Quality:	Print	Alan Moss	Signature	Approved in QT9	Date	2/27/2024
Process Owner:	Print	Lars Novak	Signature	Approved in QT9	Date	2/21/2024
Finance:	Print	N/A	Signature	N/A	Date:	N/A
Sales & Marketing:	Print	N/A	Signature	N/A	Date:	N/A
Legal:	Print	N/A	Signature	N/A	Date:	N/A
President:	Print	N/A	Signature	N/A	Date:	N/A
Other:	Print	Gary Embley	Signature	Approved in QT9	Date	2/21/2024
Other:	Print	Mike Brandel	Signature	Approved in QT9	Date	2/22/2024
Other:	Print	Lisa Ardino	Signature	Approved in QT9	Date	2/21/2024
FAA:	Print	N/A	Signature	N/A	Date:	N/A
Author:	Print	L. Novak	Signature	<i>Lars Novak</i>	Date:	2/21/2024

WORK INSTRUCTION	QP-137	Revision: AM Page 2 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES Notes:		

1.0 PURPOSE & SCOPE:

1.1 Purpose:

- 1.1.1 Quality Codes define the quality requirements to be met by the suppliers / external providers. These codes shall be included on all purchase orders as Quality Clauses for materials directly related to product manufacture and relevant services.

1.2 Scope:

- 1.2.1 This Work Instruction applies to all purchase orders generated by B-E Purchasing to support direct material requirements, including Engineering.
- 1.2.2 Appendix A within this document contains a partial listing of special processes and finishes.


2.0 REFERENCES & REGULATIONS:

2.1 Procedures

- | | | |
|--------|---------|--|
| 2.1.1 | OP 06.2 | Supplier Processing of Non-Conforming Material – Processes |
| 2.1.2 | OP 07.2 | Control of Government Property |
| 2.1.3 | OP 10.3 | First Article Inspections |
| 2.1.4 | OP 16.1 | Documented Information Retention |
| 2.1.5 | QP-166 | Supplier Certification Program |
| 2.1.6 | QP-136 | Procedure for Supplier Source Inspection |
| 2.1.7 | QP-189 | Process Conformity Audits |
| 2.1.8 | BE-014 | B-E PO Terms & Conditions |
| 2.1.9 | M06.007 | Maintaining PO Quality Codes in IFS |
| 2.1.10 | E04.007 | Interpretation and Control of Critical Parts Characteristics |


2.2 Forms

- | | | |
|-------|---------|-------------------------------|
| 2.2.1 | BE-003 | Age Controlled Item Label |
| 2.2.2 | QC-1351 | Part Number Accountability |
| 2.2.3 | QC-1352 | Product Accountability |
| 2.2.4 | QC-1353 | Characteristic Accountability |

WORK INSTRUCTION	QP-137	Revision: AM Page 3 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

2.3 Other Documents

- 2.3.1 14 CFR Part 45.15 Identification and Registration Marking.
- 2.3.2 ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes.
- 2.3.3 ASTM E1417 Standard Practice for Liquid Penetrant Testing.
- 2.3.4 ASTM E1444 Standard Practice for Magnetic Particle Inspection.
- 2.3.5 ASTM E1205 Standard Practice for use of a Ceric-Cerous Sulfate Dosimetry System.
- 2.3.6 ASTM E1742 Radiographic Examination
- 2.3.7 EIA RS-471 Symbol & Label for Electrostatic Sensitive Devices.
- 2.3.8 SAE AS5553 Counterfeit Electronic Parts, Avoidance, Detection, Mitigation, and Disposition.
- 2.3.9 SAE AS6081 Counterfeit Electronic Parts: Avoidance, Detection, Mitigation, and Disposition
- 2.3.10 SAE AS6174 Counterfeit Materiel; Assuring Acquisition of Authentic and Conforming Materiel
- 2.3.11 SAE AS9102 Aerospace First Article Inspection Requirements.
- 2.3.12 Mil-Std-105 Sampling Procedures & Tables for Inspection by Attributes.
- 2.3.13 Mil-HDBK-263 Electrostatic Discharge Control Handbook for Protection of Electrical and Electronic Parts, Assemblies and Equipment (excluding Electrically Initiated Explosive Devices) (Metric).
- 2.3.14 Mil-PRF-21260 Grade 10, Internal Combustion Engine Oil.
- 2.3.15 Mil-Std-453 Inspection, Radiographic.
- 2.3.16 Mil-Std-1285 Marking of Electrical Parts.
- 2.3.17 Mil-Std-6866 Inspection, Liquid Penetrant.
- 2.3.18 Mil-Std-1949 Inspection, Magnetic Particle.
- 2.3.19 ISO14001:2015 Environmental Management Systems – Requirements with Guidance for Use
- 2.3.20 AS9100D - Quality Management Systems
Requirements for Aviation, Space and Defense Organizations

WORK INSTRUCTION	QP-137	Revision: AM Page 4 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

2.4 Regulatory Requirements

2.4.1 N/A

3.0 ABBREVIATIONS & DEFINITIONS:

3.1 Abbreviations

3.1.1	B-E	Breeze-Eastern
3.1.2	FAIR	First Article Inspection Report
3.1.3	OCM	Original Component Manufacturer
3.1.4	OEM	Original Equipment Manufacturer
3.1.5	AAM	Authorized Aftermarket Manufacturer
3.1.6	PO	Purchase Order
3.1.7	FAA	Federal Aviation Authority
3.1.8	PMA	Parts Manufacturer Approval
3.1.9	QPD	Qualified Products Data

3.2 Definitions

- 3.2.1 External Providers – organization external to B-E that provides product(s) and / or service(s). Examples include supplier, producer, distributor, retailer, vendor, or contractor.
- 3.2.2 Documented information – information required to be controlled and maintained by an organization and the medium on which it is contained. It can be in any format / media and from any source. It may refer to information created in order for an organization to operate (documentation) or evidence of results achieved (records).


3.3 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.

WORK INSTRUCTION	QP-137	Revision: AM Page 5 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

- 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.
- 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 in accordance with the drawing requirements and the requirements of work instruction E04.007.
- 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 is to 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 E1742 / 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 references 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 external provider's / supplier's facility

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021

Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 6 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

(including sub-tier suppliers) to inspect any or all of the work included in this order, to review any and all documented information (e.g. records) associated with the production of parts/products destined for B-E 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 contacts B-E'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, could 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 Program (QP-166):


Supplier Certification program requirements as per QP-166.

29. Acceptance Tests Results:

- a. 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.
- b. 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.
- c. When external provider test reports are utilized to verify externally provided product(s) or service(s), supplier shall have a process to evaluate the test report data to confirm the product meets applicable requirements.

46. Qualified Products List:

This material must be purchased from a supplier listed on the Federal Qualified Products List.

WORK INSTRUCTION	QP-137	Revision: AM Page 7 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

52. Age Controlled Item:

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

WORK INSTRUCTION	QP-137	Revision: AM Page 8 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

The FAI requires 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 per AS9102C and its associated forms or on Breeze-Eastern forms QC-1351 Part Number Accountability, QC-1352 Product Accountability, and QC-1353 Characteristic Accountability (available from the website).
- 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 B-E 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.
- 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.

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021

Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 9 of 22
	QUALITY Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

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.

At 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;
- 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: B-E 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

WORK INSTRUCTION	QP-137	Revision: AM Page 10 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
<h2 style="text-align: center;">PURCHASE ORDER QUALITY CODES</h2>		
Notes:		

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.


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 should 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 B-E purchase order requirements. This system is to 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 purchased material process, including supplier controls.
- d. Flow-down of specification/contractual requirements, including sub-tier contractors/suppliers.
- e. Controls for nonconforming/discrepant materials (products, services, or processes) per B-E OP 06.2, Supplier Processing of Non-Conforming Material – Processes.

WORK INSTRUCTION	QP-137	Revision: AM Page 11 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

- f. Notification to Breeze-Eastern in writing or email of suspected problems/non-conformances with previously delivered products and / or services.
- g. The inspection/testing of products/materials to be shipped to B-E meet any and all contractual agreements/requirements; including documented evidence of such.
- h. Review and acceptance of Purchase order(s) and the requirements therein; including any revisions to previously accepted purchase orders; including documented evidence of such.
- i. 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. Notification of Breeze-Eastern of any significant facility or organizational changes such as company name, ownership, senior quality management, certification status, etc.
- l. Notification of Breeze-Eastern of any changes to processes, products, or services, including changes to external providers or location of manufacture, and obtain B-E's acknowledgement.
- m. Maintenance of a program to ensure the proper operation of manufacturing software and equipment used for product/part/article inspection or test.
- n. Sampling Plans 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. Contact B-E Quality for other use of statistical techniques where applicable.
- o. Personnel involved in the provision of products and services to B-E are to be competent in their relevant roles and have necessary qualifications when specified. Personnel should be aware of their contributions to product or service conformity, product safety, and ethical behaviors.

WORK INSTRUCTION	QP-137	Revision: AM Page 12 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

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 or finishes performed as well as the applicable specifications. If the special processes/finishes are performed for the supplier, then the source must be one of the following:

1. NADCAP Certified (Preferred)
2. B-E Approved Supplier
3. If none of the above, you can use other special process suppliers provided you have approved the supplier through your quality system via quality system audit of their facility and special process audit of each process to be performed. Records of these shall be available upon request by B-E.

The sub tier suppliers certification must be maintained on file in accordance with record retention procedures and be available upon request by B-E.

Appendix A contains a partial listing of special processes and finishes.


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 the process control system. The PCA requires:

- a. The supplier to provide an in-process part, left in a partially completed state for review.
- b. The review and approval to be completed using B-E's QP-189 Process Conformity Audit procedure.

74. Quality Records & Revisions:

Control of Quality records, including retention is required. All applicable documented information (e.g. 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

WORK INSTRUCTION	QP-137	Revision: AM Page 13 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		


than ten (10) years, unless otherwise specified. These records include, but are not limited to:

- a. Certificates of Conformance.
- b. Special Process certifications (see Special Process section).
- c. Inspection records.
Note: 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.
- 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.

Note: Reference B-E OP 16.1.

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

WORK INSTRUCTION	QP-137	Revision: AM Page 14 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
<h2 style="text-align: center;">PURCHASE ORDER QUALITY CODES</h2> <p>Notes:</p>		

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 should be complied with for a part identified on the Purchase Order as an FAA-PMA Part:


- a. A part identified by this quality clause is a Breeze-Eastern FAA-PMA controlled part.
- b. 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 FAA will not accept any sampling plan which will accepts a lot with known rejections included which might occur with an ASI/ASQC Z1.4 or MIL-STD-105 type plan.
- c. 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.
- d. 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.
- e. 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.
- f. 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.
- g. 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.

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021

Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 15 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

- h. 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.
- i. 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 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.

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021


Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 16 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
<h2 style="text-align: center;">PURCHASE ORDER QUALITY CODES</h2> <p>Notes:</p>		

- b. Program should also met intent of AS6081 and AS6174.
- c. 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).
- d. 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.
- e. In the event a part is not directly available from the OCM/ OEM/ 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.
- f. 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.
- g. The certifications shall be provided upon request or as part of a FAIR (Quality Clause 59) or Critical Safety Item (Quality Clause 1).
- h. 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.
- i. Parts shall not be used, reclaimed, or misrepresented as new.

WORK INSTRUCTION	QP-137	Revision: AM Page 17 of 22
	QUALITY Controlling Department	2 / 27 / 2024 Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

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 B-E 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.

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 (OEM) 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.

84. Packaging of O-Rings and Preformed, Hydraulic Packings:


- a. O-Rings and preformed hydraulic packings with an OD of .750 inch or larger, are to be individually packaged. When individually packaged, O-rings shall not be coiled or packaged in a way that will induce twist or a preset shape that will affect the performance of the O-ring.

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021

Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 18 of 22
	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

- b. All O-rings and hydraulic packings are to be in UV resistant packaging.
- c. All O-rings and preformed, hydraulic packings shall be identified with, at the minimum, the following information:
 - Material specification
 - Manufacturer's name
 - Manufacturer's compound identification
 - Manufacturer's batch number
 - Cure date
 - B-E Part number
 - B-E Cage Code
 - FAA PMA (when applicable, per the PO)

85. Raw Material Traceability

Raw material certifications shall show clear traceability to the manufacturer(s) of the raw material including ingot source, all thermo-mechanical processing (i.e., forging, rolling, drawing, etc.), heat treatment, chemical processing, and inspection as required by applicable raw material specification requirements.

- a. Supplier shall not disguise the pedigree of the material or chain of ownership by removal of a supplier's name, nomenclature or identification.
- b. The substance of this clause should be flowed down to sub-tier suppliers as applicable.

86. Non-conforming Item From a Distributor

If a non-conforming item is provided by a distributor, at a minimum, the distributor must notify the original manufacturer and take appropriate steps to ensure the non-conforming items do not end back into the supply chain. Corrective Actions responses may be required from both the distributor (back to B-E) and the original manufacturer. Contact the B-E buyer as necessary for further information. (Reference LHD QRS-107).

87. Qualified Products Data (QPD) for Paint / Coatings


- a. PAINT (Primer & Top Coat) – The paint/paints required for this item is a Qualified Products Data (QPD) item. Procurement shall be from approved manufacturers listed on the QPD only. Reference <https://qpldocs.dla.mil/default.aspx>.

Breeze-Eastern Form QC-1298, Rev R, July 15, 2021

Uncontrolled Document when printed – Revision must be confirmed per OP 02.1

©2021 Breeze-Eastern LLC. All Rights Reserved.

Contents Proprietary Information of Breeze-Eastern LLC

WORK INSTRUCTION	QP-137	Revision: AM Page 19 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		


b. (Code for Top Coat) – For Chemical Agent Resistant Coating (CARC) used on this item the following applies: Each lot of paint manufactured shall be approved by Army Research Laboratory, Aberdeen Proving Ground, MD 21005. Ref (MIL-DTL-53072 - Chemical Agent Resistant Coating (CARC) System Application Procedures and Quality Control Inspection); (MIL-STD-186 Department of Defense Standard – Manufacturing Process - Protective Finishing for Army Missile Weapon Systems). Contact your B-E Buyer if any questions.

88. Subject to US Import transaction

- a. For items produced outside of USA, Please notify CUSTOM'S AGENT/ BROKER upon arrival at airport.
- b. COMPASS AIRFREIGHT 159-15 Rockaway Blvd., Jamaica, NY 11434 / Phone 718-528-3589 ext. 208 (Import Department).
- c. Contact your B-E Buyer if any questions.

89. EU & UK Imports of Russian Iron & Steel Products Restrictions

- a. The European Union & United Kingdom have expanded its restrictions on imports of iron and steel products listed in *Annex XVII* (EU Regulation No. 833/2014) when processed in a third country incorporating iron and steel products originating in Russia.
- b. This requires action by both EU businesses importing products identified on Annex XVII, and businesses in other countries (e.g. USA) exporting those products to the EU.
- c. Businesses exporting Annex XVII products to the EU should integrate into its procedures reliable measures to ensure it is not providing goods that are produced wholly, or in part, with Russian steel or iron.
- d. For those items listed on Annex XVII (HS codes 72xx & 73xx), collect information about the targeted items, including Mill Test Certificates (MTCs).
 - o Provide to B-E MTCs establishing the name of the facility where the production is taking place, the name of the country corresponding to the heat number (country of the ladle of melting) together with the classification at subheading level (six-digit code) of the product.
- e. Contact your B-E Buyer if any questions.

WORK INSTRUCTION	QP-137	Revision: AM Page 20 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES Notes:		

90. Mercury free requirement

- a. Mercury free certification is required.
- b. Mercury or mercury containing compounds shall not be intentionally added to, or come in direct contact with, any hardware or supplies furnished under this order.
- c. C of C must state that parts are mercury free.


4.0 RESPONSIBILITIES:

4.1 Departmental Responsibilities

- 4.1.1 Quality is responsible to define and maintain the Purchase Order Quality codes. These codes are identified in the Purchasing/Purchase Part/Purchase Part/QPR/Clauses screen in IFS for individual parts.
- 4.1.2 Purchasing is responsible to ensure suppliers / external providers have all the necessary information to provide the applicable product(s), service(s), and/ or process(es) per the specified requirements. The buyer is the primary point of contact for the supplier / external provider.
- 4.1.3 Suppliers / External Providers are responsible for complying with the requirements of the applicable documented information, including B-E's PO Terms & Conditions (BE-014).

5.0 PROCEDURE:


- 5.1 Quality defines the quality clauses applicable to purchased items and materials.
- 5.2 Quality maintains the IFS system quality clauses in the Purchasing module.
 - 5.2.1 Instructions for the maintenance of the quality clauses in IFS are contained in B-E work instruction M06.007.
- 5.3 Purchasing coordinates purchase order requirements with the supplier / external provider.

WORK INSTRUCTION	QP-137	Revision: AM Page 21 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	QUALITY Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

6.0 REVISION HISTORY:

<i>REV</i>	<i>Release Date</i>	<i>AUTHOR</i>	<i>DESCRIPTION OF CHANGE(S)</i>
AA	5/29/2014	Norman Harris	Add statement to Code 52 to identify manufacturing /cure date formats.
AB	5/21/2015	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.
AC	10/28/2015	Norman Harris	Added to 74c "Note: 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."
AD	10/10/2017	L. Novak	Added section 3.4 abbreviations and definitions. Added reference to OP 16.1 to code 74. Added AS9100D and ISO14001:2015. Updated section 4.2. Removed how to update IFS from section 5 and put into internal work instruction M06.007. Updated code 69 with additional AS9100D 8.4.3 requirements. Updated/Revised code 71 and Appendix A with additional information.
AE	11/3/2017	Fred Willms	DCN 17-22 QA to add Purchase Order Quality Code 84 for individual packaging and UV protection of o'rings, & packing preformed, hydraulic as specified in MIL-P-25732.
AF	2/21/2018	L. Novak	DCN 18-03QA added second sentence to 4.2.2; changed contents of Purchase Order Quality Code 29 to comply with AS9100D 8.4.3d and 8.4.2d.
AG	3/26/2019	Fred Willms	DCN 19-02QA to add Purchase Order Quality Code 85 for the contractual flow down of Boeing Requirement H900 26, D thru G.
AH	6/14/2019	T. Covino	Updated to Rev. AH with the incorporation of all changes effected by the approval of DCN 17-22QA, DCN 18-03QA, and DCN 29-02. Corrected minor grammatical and formatting errors; modified wording including substitution of the word "shall"; where appropriate.
AJ	8/28/2019	L. Novak	Added code 86 per DCN 19-12QA
AK	3/13/2020	L. Novak	Updated clause 24 & 76, reinstating FAA-PMA parts to the certified supplier program. Add definition of FAA & PMA.
AL	4/13/2023	L. Novak	Incorporated onto latest template (QC-1298, Rev R). Added 3.1.9. Updated clause 84. Added clause 87 & 88.
AM	2/27/2024	L. Novak	Added ASTM E1742 in 2.3 & code 20; referenced AS9102C in code 59; added AS6081 & AS6174 in 2.3 & code 79; added code 89 for EU/UK Russian Iron & Steel; and added code 90 for Mercury free product(s).

* A revision's release date is to be filled in the above revision history table and document header once approved; to be the same as from top of page 1/ just under header.

WORK INSTRUCTION	QP-137	Revision: AM Page 22 of 22
 BREEZE • EASTERN <small>Be Ready. Be Sure.</small>	<u>QUALITY</u> Controlling Department	<u>2 / 27 / 2024</u> Release Date
PURCHASE ORDER QUALITY CODES		
Notes:		

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

Anodizing	Metallic Ceramic Coating
Aluminum, Ion Vapor Deposited Coating	Nedox Coating
Black Oxide Coating	Nickel Plating
Bonding	Nondestructive Testing (e.g. MPI, FPI, etc.)
Cadmium Plating	Painting
Chemical Film	Passivation
Chromium Plating	Phosphate Coating
Conformal Coating	Shot Peening
Copper Plating	Silver Plating
Electrical or Electronic Soldering	Solid Film Lube
Electroless Nickel Plating	Tin Plating
Heat Treating (i.e. Heat Treat, Nitride, Carburization, UHF Induction Hardening, etc.)	Zinc Plating
Hot Metal Joining (e.g. soldering, brazing, welding, welding repair, etc.)	

Request For Document Action

Doc. Name: PURCHASE ORDER QUALITY CODES

Doc. #: 8

Doc. Code: 02-Q-Level III-08

Publish Date: 2/27/2024

Document Info

Doc. #: 8

Doc. Code: 02-Q-Level III-08

Doc. Ref: QP-137

Document Name: PURCHASE ORDER QUALITY CODES

Doc Description: Quality Codes define the quality requirements to be met by the suppliers / external providers. These codes shall be included on all purchase orders as Quality Clauses for materials directly related to product manufacture and relevant services.

Document Type: Quality Procedure

Department: Quality

Document Owner: Alan Moss

Document Category:

Revision Info

Requestor: Lars Novak

Resp. Party: Lars Novak

Status: Active

Previous Revision: AL

Current Revision: AM

Document Location: QT9

Document Author:

Physical Location: B-E Intranet / Quality Dept. archives.

Description of change to document

☐ Training Required

Added ASTM E1742 in 2.3 & code 20; referenced AS9102C in code 59; added AS6081 & AS6174 in 2.3 & code 79; added code 89 for EU/UK Russian Iron & Steel; and added code 90 for Mercury free product(s).

Comments

Entry Date	Author	Entry
------------	--------	-------

Collaboration

Collab User	Status	Date Completed	Notes
-------------	--------	----------------	-------

Affected Departments

Dept Code	Department	Inactive
E	Engineering	<input type="checkbox"/>
M	Materials	<input type="checkbox"/>
O	Operations	<input type="checkbox"/>
P	Purchasing	<input type="checkbox"/>
Q	Quality	<input type="checkbox"/>

Approvals

Approvers

Request For Document Action

Doc. Name: PURCHASE ORDER QUALITY CODES

Doc. #: 8

Doc. Code: 02-Q-Level III-08

Publish Date: 2/27/2024

Approver	Approved	Date Approved
Alan Moss	<input checked="" type="checkbox"/>	2/27/2024
Jim Fett	<input checked="" type="checkbox"/>	2/26/2024
Michael MacLaren	<input checked="" type="checkbox"/>	2/27/2024
Gary Embley	<input checked="" type="checkbox"/>	2/21/2024
Mike Brandel	<input checked="" type="checkbox"/>	2/22/2024
Lisa Ardino	<input checked="" type="checkbox"/>	2/21/2024
Lars Novak	<input checked="" type="checkbox"/>	2/21/2024

Approval Notes

Entry Date	Author	Entry
February 27, 2024 02:57:42 PM -04:00	Lars Novak	Approved from new document queue
February 27, 2024 01:42:45 PM -04:00	Michael MacLaren	Document Approved With the following notes:
February 27, 2024 09:34:10 AM -04:00	Alan Moss	Document Approved With the following notes: Approved
February 26, 2024 08:53:55 AM -04:00	Jim Fett	Document Approved With the following notes:
February 22, 2024 06:12:05 AM -04:00	Mike Brandel	Document Approved With the following notes: Document Approved
February 21, 2024 04:11:54 PM -04:00	Gary Embley	Document Approved With the following notes: I approve.
February 21, 2024 04:08:56 PM -04:00	Lisa Ardino	Document Approved With the following notes:
February 21, 2024 12:43:43 PM -04:00	Lars Novak	Document Approved With the following notes:

User Defined Fields

Affected Products

Product Name	Part Number	Description	Inactive
--------------	-------------	-------------	----------