



**Procurement Notes** (applicable to all QC-claused items. Exception: Procurement Notes do not apply to orders when QC01 is the only clause imposed on the order):

1. **Record retention:** Seller shall retain objective evidence of the quality of any items supplied (manufacturing, assembly, inspection, physical/chemical test reports, test and special process records and material certification records) until directed otherwise by Buyer. Under no circumstances should these records be destroyed without the prior written approval of Buyer. Records shall be made available to Buyer upon request.

2. **Nonconformance system:** Seller shall establish and maintain a documented nonconformance system to ensure that product that does not conform to specified requirements is prevented from unintended use or delivery. This system shall provide for identification, documentation, evaluation, segregation to the extent practical, disposition and for notification of nonconforming product to Buyer. The responsibility for review and authority for disposition of nonconforming product shall be defined by Buyer. Seller shall ship hardware with an open nonconformance only with prior written approval from Buyer.

3. **Sub-tier flow down:** Seller shall ensure that all applicable technical and quality requirements, including any key characteristics, are flowed down to sub-tier suppliers, vendors, and manufacturers through Seller procurement documents. Seller is responsible to evaluate and approve sub-tier suppliers to ensure their capability to produce quality product and maintain process control, unless directed by Buyer to use a specific supplier source. Flow down to a sub-tier supplier shall include applicable quality system provisions, relevant drawings, specifications, documentation and certification requirements. Sub-tier supplier compliance and conformance to Buyer's contractual requirements is the responsibility of Seller.

4. **Proposed changes:** Seller shall provide in writing advance notification to Buyer of any change(s) to tooling, facilities, materials or processes at Seller's or Seller's sub-tier's facility that could affect Buyer's contracted product. This includes, but is not limited to, fabrication, assembly, handling, testing, facility relocation or introduction of a new sub-tier supplier.

### **QC00 Reserved**

### **QC01 Material Identification:**

Each article delivered under this Order will require positive identification with the part number ordered. Seller shall notify Buyer and obtain approval prior to shipment of any part number that differs from the part number being ordered.

### **QC02 Manufacturer's Certificate of Compliance:**

A Certificate of Compliance from the manufacturer is required with this Order. Seller shall provide a copy of the manufacturer's certification that material/articles delivered under this Order conform to the applicable drawing and/or specifications.

Buyer's Order number must be included on the documentation provided by the procurement source.

Manufacturer Certificate of Compliance must contain the following:

- Drawings/engineering orders and specifications, with revisions, as specified on Buyer's Order
- Part number, as specified on Buyer's Order
- Manufacturer's lot, heat or melt number, batch, date code and/or serial number, as required
- Manufacturer's name and date

### **QC03 Physical and/or Chemical Test Reports:**

For each lot in each shipment, Seller shall submit one reproducible record with results of the chemical and/or physical material analysis which provide quantitative evidence that the material shipped complies with the applicable specifications as stated in Buyer's Order.

Reports must provide manufacturer's name, specification number(s) and, if specified on Buyer's Order, the revision date or change letter, and must be identified to or correlated with specific lots.

### **QC04 Reserved**

### **QC05 Buyer Source Inspection:**

Buyer source inspection is required prior to shipment of articles from Seller's facility. Upon receipt of this Order and prior to commencing work, promptly notify the Procurement Quality Assurance Representative (PQAR) assigned to Seller's facility so the appropriate inspection plan can be coordinated.

In the event that a PQAR does not normally service Seller's facility, immediately request source inspection via the USA Supplier portal at URL: [http://www.usa-supplienet.com/pqa\\_contact.htm](http://www.usa-supplienet.com/pqa_contact.htm).

Source inspection shall be conducted by Buyer at Seller's facility or where designated in the Order. Seller shall notify PQA office a minimum of five (5) working days in advance of the time the articles or materials are ready for inspection or test.

Seller shall make available to the PQAR all applicable drawings, specifications, procedures, statements of work, Buyer's Order, test software and changes thereto, related inspection and/or test equipment, and such other information as may be required to satisfactorily perform the inspections and tests required under this Order.

### **QC06 Government Source Inspection:**

Government inspection is required prior to shipment of articles from Seller's facility. Upon receipt of this Order, promptly notify the Government representative who normally services Seller's plant for Government contracts so that appropriate inspection planning by the Government representative can be accomplished. In the event that Seller's facility is not normally serviced by a Government inspection representative and the area Government inspection representative or agency cannot be located, immediately notify Buyer to obtain a point of contact for the appropriate Government source inspection planning.

All work on this Order is subject to inspection and test at any time and any place. The level of Government inspection performed will be as determined by the cognizant Government inspection representative and may be conducted during processing, fabrication, or as a final inspection.

## Procurement Quality Requirements

Resident Government Representatives shall be notified 48 hours in advance of the time articles or materials are ready for inspection or test. When articles, processes or services are ready for required Government inspections and/or test and there is no Government representative in residence at Seller's facility, the Government representative or agency shall be notified at least five (5) working days prior to the Seller's requested date for Government source inspection.

Seller shall make available to the Government representative all applicable drawings, specifications, and changes thereto, related inspection and/or test equipment, and such other information as may be required to satisfactorily perform the inspections and tests required under this Order.

### QC07 Evidence of Test:

Seller shall provide results of inspections and tests (e.g., nominal operating load or pressure, maximum proof load or pressure the hardware was subjected to, electrical resistance, continuity & nondestructive testing/reports) performed by the Seller in accordance with the Order and specification requirements.

### QC08 Calibration Certification with Data:

Seller shall submit for each item calibrated one reproducible record of actual calibration results, including graphic and tabular data if applicable. Calibration Record or Certificate shall indicate traceability of measurements to the National Institute of Standards and Technology or methodology whereby values were derived from a controlled process utilizing a fundamental constant of nature or calibration to the Manufacturer's specification.

Seller calibration record shall include a unique calibration tracking number, tolerance range, and environmental conditions if applicable.

If out of tolerance condition is found, Seller shall include a statement setting forth the degree of operating error per specification, degree of correction of out of tolerance condition and remaining uncorrected out of tolerance condition.

### QC09 Process Certification:

Seller shall submit with each shipment a certification of processes performed that are specified on this Order. Certification must contain the following:

- Part number
- Serial and/or lot numbers of the hardware processed (as applicable)
- Material process specification
- Processor's name and date.

### QC10 Reserved

### QC11 Threaded Fastener Requirements:

For each item on this Order, Seller shall submit a copy of the manufacturer's certification for hardware supplied. The certification must contain:

- Statement that the hardware supplied was manufactured and acceptance tested in accordance with the applicable specifications.

- Listing of both the ordering and procurement specifications, including revision levels as specified on Buyer's Order.
- Annotation of the fastener's lot number on the shipper, certification, or packing list; any one of the three will be acceptable.
- Seller name and date.

Seller shall submit with each shipment one reproducible record of actual chemical analysis and actual physical test results for hardware shipped. The record must have identification by heat, lot, or melt number.

Seller shall submit data with each shipment, providing objective evidence that all processing, treatment, testing, and inspection as required by the applicable ordering specification and related procurement specifications have been satisfactorily completed. Data shall include, but is not limited to, ultimate tensile, ultimate shear, hardness, dye penetrant, and magnetic particle results when required by applicable specification.

Seller's Quality Control organization shall be responsible for ensuring that items of this Order are packaged in such a manner that the dimensional integrity is preserved, contamination and corrosion are prevented, and no physical damage occurs to the threads during shipment. For externally threaded fasteners, the preferred method, when size permits, will be to individually sleeve the threaded portion of the fastener. Any method used shall insure that threads remain undamaged during shipment. Bulk packaging of unprotected threads is prohibited. Exception: Fasteners smaller than ¼ inch diameter may be bulk packaged up to 100 count per container.

### QC12 Shelf Life Certification:

Items on this Order require submittal of date of manufacture when shelf life is based on date of manufacture, or date of shipment from the manufacturer when shelf life is based on date of shipment, as appropriate, based on specified method of shelf life determination.

Upon shipment, shelf life remaining shall meet the minimum shelf life specified on the order or 75 percent of the shelf life shall be remaining on items on this Order.

Items on the Order shall be traceable by batch, serial or lot. Seller shall notify Buyer prior to shipment if the shelf life and temperature requirements are different from those identified on the Order.

Buyer's Order number must be included on the documentation provided by the procurement source.

Certification must contain the following:

- Order part number
- Drawings/engineering orders and specifications, with revisions, as specified on Buyer's order
- Manufacturer's name, lot, heat, batch, date code, and/or serial number (as applicable)
- Date of manufacture (as specified on Order).
- Date of shipment from manufacturer (as specified on Order).
- Seller name and date

**QC13 First Article Inspection**

Seller's system shall provide a process, as appropriate, for the inspection, verification, and documentation of the first production article. This First Article Inspection (FAI) is a deliverable report with the initial shipment of the product.

FAI documentation shall be retained and shall include a list of the characteristics required by the design data and any required tolerances, the actual results, and when testing is required, the results of the test.

The FAI shall be updated to include changes to production processes or product configuration.

NOTE: Guidance for the performance of FAI is provided in AS9102, First Article Inspection.

Seller shall notify Buyer's Quality Assurance Representative within 48 hours of receipt of this Order to coordinate and plan for the FAI to be conducted, as appropriate, by Buyer's Quality Assurance Representative. The FAI Report must show evidence of Buyer's Quality Assurance Representative acceptance.

When documenting the FAI, Seller may use the forms contained within AS9102 or their equivalent format, and will include all the information required in the AS9102 as applicable to the article's configuration.

Seller's FAI records will provide objective evidence of 100% dimensional inspection, tolerances and inspection results. Standard catalog hardware is exempt from this FAI requirement.

In the advent that this FAI requirement has been imposed by Buyer on subsequent procurements of the same article within a two (2) year period, Seller shall be required to provide evidence of that FAI to Buyer's Quality Assurance Representative in lieu of re-performing another FAI.

**QC14 Reserved****QC15 General Inspection Plan:**

One hundred percent (100%) inspection is required unless a sampling or a Statistical Process Control (SPC) Plan/Procedure(s) has been approved by Buyer's Procurement Quality Assurance. Any submitted plan shall preclude the acceptance of lots whose samples have known nonconformities. If a defective item is identified during sampling inspection and the sampling plan does not require rejection of the lot, every item will be inspected for the identified nonconforming characteristic.

Seller and Seller's subcontractors shall generate and maintain records and data of inspections and tests performed. Records shall disclose the status of articles and materials, the actual characteristics inspected, the allowable tolerance limits and tests performed, including dates, and must show objective evidence that each characteristic has been inspected and accepted by Seller's quality function. Recording of actual dimensions inspected is optional. This option does not apply to Interface Control Dimension (ICD) dimensions. When ICD dimensions are applicable, all ICD dimensions shall be inspected and actual dimension(s) shall be recorded. Upon Buyer's request, actual inspection records will be sent with shipment.

**QC16 Objective Evidence of Dimensional Inspection:**

Seller shall provide objective evidence with each shipment that a representative sample of the articles on this Order were dimensionally inspected for conformance with drawing and Order requirements. Objective evidence shall consist of records of actual dimensional readings taken during inspections with the dimension and its tolerance noted. All out of tolerance measurements shall be clearly identified on the records, and Seller shall indicate the authority for acceptance of any out of tolerance condition.

When using a "Sampling Inspection" as a means of product acceptance, the plan shall be statistically valid and appropriate for use (e.g., Military, ANSI/ASQ sampling plans).

Seller shall identify each inspection data sheet to the related Order, part number and when applicable, serial number.

Inspection equipment (i.e. tools & gages) used during dimensional measurement shall be calibrated to measurement standards traceable to National Institute of Standards & Technology or methodology whereby values were derived from a controlled process utilizing a fundamental constant of nature.

**QC17 Reserved****QC18 Reserved****QC19 Reserved****QC20 Computer Software Control at Seller:**

- Seller shall plan, develop, and implement a software quality assurance (QA) program, which includes practices and procedures to assure compliance with all software requirements of this Order.
- Seller shall develop a software QA plan. The plan shall identify organizational responsibilities and shall provide for detection, reporting, analysis, and correction of software problems and deficiencies.
- The plan shall document the procedures for design logic, fulfillment of requirements, traceability and compliance with specified standards.
- Seller shall document controls for the handling of source code and object code and related data in the initial approval until the codes have been incorporated into the final media. The objective of these controls is to ensure that program versions are accurately identified. Modifications shall be properly incorporated.
- Tests shall be conducted with approved test plans/procedures ensuring that test results are actual and test repeatability is maintained.
- Seller shall ensure that documentation, software, and hardware under this Order are acceptable to Buyer.

**QC21 Seller's Material Certification Retention Requirements:**

Seller shall retain on file one reproducible record of actual chemical and/or physical material analysis of all metallic raw materials, including certification. Material identification shall be traceable to heat, lot or melt number, and shall be made available upon request to Buyer. Material shall be traceable to Seller's and Seller's sub-tier's procurement document.

**QC22 Pyrotechnic Device Manufacturing Controls:**

For each production lot of each pyrotechnic device described by this Order, Seller shall make provision for the following reviews by Buyer, as described below:

- Baseline Review (Phase I)
- Production Review (Phase II)
- Lot Certification Review (Phase III)

1. Baseline Review (Phase I)

Seller shall begin fabrication of detail parts for a pyrotechnic device only after Buyer has established a hardware baseline for such device. The hardware baseline will be established through Buyer's review, at Buyer's plant, of Seller's drawings, specifications and related procurement, fabrication, processing, test and quality control procedures, as required by this Order. For a previously qualified device, Buyer will accomplish this review 5 weeks after placement of this Order. For an unqualified device, Buyer will accomplish this review 3 weeks after Critical Design Review.

2. Production Review (Phase II)

Seller shall secure specific authorization from Buyer prior to the explosive loading of any device. Seller shall give Buyer at least two weeks prior notification, in writing, of the date on which explosive loading is scheduled to begin. Buyer will schedule a review team visit to Seller's manufacturing facility for an on-site verification of Seller's implementation of quality system and hardware baseline requirements, and for a detailed correlation review of associated drawings, specifications, tooling, equipment, facilities, procedures, manufacturing environments, and personnel qualifications.

3. Lot Certification Review (Phase III)

Seller shall receive specific authorization from Buyer before shipping pyrotechnic devices under this Order. When Buyer, at Buyer's plant, determines that Seller's X-ray and N-ray films and associated data indicate an acceptable lot of pyrotechnic devices, Buyer will schedule a lot certification review team visit to Seller's manufacturing facility. Buyer's review team will perform an in-depth verification of Seller's supporting documentation and data required by Buyer's Order.

**QC23 Reserved**

**QC24 Scrap Control at Seller:**

Control scrap hardware and scrap raw materials as specified:

- Seller shall permanently identify scrap hardware or raw materials by complete destruction or impression stamping or etching the word "scrap", or painting with red paint, signifying scrap hardware or raw materials.

- Seller shall establish documentation to control all aspects of identification, traceability, segregation, control and disposal of scrap hardware or raw materials.
- Seller shall establish physical segregation and control of scrap hardware or raw materials in an enclosed locked area with limited access.
- Seller shall dispose of scrap hardware or raw materials ensuring complete destruction, which prevents reintroduction of use.
- Scrap hardware or raw materials may be used for nonproduction purposes (shop aids, engineering evaluation units, etc.). This scrap shall be subject to identification, documentation, segregation and control requirements.

**QC25 O-Ring Requirements:**

With each shipment of O-rings, Seller shall:

- Individually package all O-rings in opaque packaging.
- Part mark all O-ring packages in accordance with the specification (i.e., nomenclature, part number, material specification, manufacturer's name or cage code, compound number, batch number, cure date.) as applicable.
- Ship all O-rings to Buyer within two years (8 quarters) of their noted cure date. NOTE: This requirement (shipment within two years of cure date) does not apply to O-rings with unlimited shelf life per ARP5316.
- Provide a Material test report for each lot or batch number shipped.

Buyer's Order number must be included on the documentation provided by the procurement source.

Certification must contain the following:

- Seller name and date.
- Manufacturer Name
- Part Number
- Material Specification
- Batch/Lot number
- Cure Date

**QC26 Pressure Vessel:**

With each shipment, Seller shall provide a copy of American Society of Mechanical Engineering Code Reports showing conformance of the units to the requirements of the Pressure Vessel Code. When required, the hardware markings must be in accordance with the applicable drawing/specification.

**QC27 Reserved**

**QC28 Reserved**

**QC29 Reserved**

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**QC32 Reserved**

**QC33 Reserved**

**QC34 Reserved**

**QC35 Inspection Plan:**

Seller shall prepare and submit an inspection system plan for the manufacture, test and inspection of articles under this specific Order. The plan shall be submitted for Buyer approval prior to contract award. The inspection system plan shall cover activities for the Order period and be tailored to the Order requirements. The plan shall also describe Seller's detailed implementation of the quality requirements, statement of work, and associated drawings and specifications. Specific elements/provisions imposed by Buyer will require Seller to provide a detailed method of ensuring the applicable quality inspection system provisions and technical criteria are satisfactorily met.

**QC36 USA Supplier Quality Assurance Requirements Level 1:**

**Quality System Requirements for Sellers that design and build flight & ground support equipment to procurement specification.** Seller will establish and maintain a quality assurance system to the requirements of SM647, Attachment 1, QSL 1 – Supplier Quality Management System Level 1.

Buyer reserves the right to perform periodic audits at Seller's facility.

**QC37 USA Supplier Quality Assurance Requirements Level 2:**

**Quality System Requirements for Sellers that build to print/modify flight & ground support equipment to procurement specification.** Seller will establish and maintain a quality assurance system to the requirements of SM647, Attachment 2, QSL 2 – Supplier Quality Management System Level 2.

Buyer reserves the right to perform periodic audits at Seller's facility.

**QC38 USA Supplier Quality Assurance Requirements Level 3:**

**Quality System Requirements for Sellers that provide commercial products/industry standards, ground support hardware built/modified to Buyer drawing/specification or modified commercially-available products.** Seller will establish and maintain a quality assurance system to the requirements of SM647, Attachment 3, QSL 3 – Supplier Quality Management System Level 3.

Buyer reserves the right to perform periodic audits at Seller's facility.

**QC39 EEE Hardware Manufacturer's Certificate of Compliance and Chain of Traceability Requirements:**

Hardware provided on this Order shall only be procured from the Original Component Manufacturer (OCM) or through the OCM Authorized Distributor(s). A Certificate of Compliance from the manufacturer is required with this Order. Seller shall provide documentation to record acquisition supply chain of traceability back to the manufacturer of all Electrical, Electronic, and Electromechanical (EEE) parts provided on this Order.

The full quantity of date code controlled Electrical, Electronic, and Electromechanical (EEE) parts provided under this Order is preferred to have a single lot/date code. If mixed lot/date codes are provided, the shipping documentation shall list individual lot/date codes and quantity. Multiple lot/date codes shall not be commingled and separate packages shall be marked with the quantity and lot/date code.

Seller's certification shall contain the following data and accompany each shipment:

- Buyer's Purchase Order Number
- Part number
- Quantity
- Manufacturer's name
- Batch identification for the item(s) such as date codes, lot codes, serializations, or other batch identifications.
- Certification of Compliance from the part manufacturer (OCM) or OCM authorized distributor, as applicable, stating compliance to the applicable specification requirements identified on the purchase order.
- Statement that the shipment contains only new parts (e.g., not reworked or returned from another user)
- Seller name and date

Seller's Supply Chain Traceability records must contain the following data and accompany each shipment:

- Evidence of procurement from OCM or OCM Authorized Distributor
- Data that identifies the name and location of all the supply chain intermediaries from the manufacturer to the direct source of the product for the Seller, and shall include the manufacturer's batch identification for the item(s) such as date codes, lot codes, serializations or other batch identifications.

#### **QC40 Electrostatic Discharge (ESD) Protection Program and Packaging:**

Seller shall document and implement an ESD Control Program in accordance with MIL-STD-1686, Electrostatic Discharge Control Program for Protection of Electrical and Electronic Parts, Assemblies and Equipment (Excluding Electrically Initiated Explosive Devices). Parts must be properly packaged and identified as required in MIL-STD-1686. All goods will be placed in conductive or static-dissipative packages, tubes, carriers, conductive bags, etc., for shipment. The packaging must be clearly labeled to indicate that it contains electrostatic sensitive goods. Electrical parts that may be used or shipped in conjunction with ESD sensitive parts shall be treated as ESD sensitive.

#### **QC41 Test Usage:**

The articles on this Order are for engineering test or analysis, development, prototyping, bread/brass board non-production usage. Seller shall uniquely identify and mark articles to prevent incorporation of their use into production, flight or GSE articles.

#### **QC42 Certificate of Compliance with Applicable Requirements:**

Seller shall provide certification that Seller has complied with material and inspection requirements of this Order.

Seller shall certify that all articles were produced either from materials furnished by Buyer or from materials for which Seller has available for examination the chemical and physical test reports or other evidence of conformance to material specifications.

Buyer's Order number must be included on the documentation provided by the procurement source.

Certificate of Compliance must contain the following:

- Part number
- Drawings/engineering orders and specifications, with revisions, as specified on Buyer's Order
- Seller name and date

#### **QC43 Orbiter Element Approved Controlled Processor:**

Controlled processes performed on this Order must be performed by a processor on Buyer's "Orbiter Element Approved Controlled Processor List" via the USA Supplier portal at URL:

[http://www.usa-suppliernet.com/pqa\\_asl.htm](http://www.usa-suppliernet.com/pqa_asl.htm)

Seller's responsibility for acceptable processing is not diminished by Seller's use of Buyer's approved processors. Seller shall provide certification for controlled processes performed. Hardware processed shall be processed in accordance with the process and material specifications on this Order.

Use of superceding specifications is not permitted without authorization from Buyer.

Certification must contain the following:

- Part number
- Serial number and lot numbers of the hardware processed (as applicable)

- Material process specification & revision as specified on Buyer's Order
- Supplier Material Processing Procedures (SMPP) number and revision as specified on buyer's order.
- Processor's name, address and date

#### **QC44 Acceptance Data Package:**

Seller shall submit with each shipment of a part or assembly an acceptance data package with Seller name, Buyer Order, part nomenclature, part number and serial number with the applicable data items in accordance with USA form SM648, Acceptance Data Package Requirements.

#### **QC45 NSTS 5300.4(1D-2) Quality Program:**

Seller will provide and maintain a quality program that complies with NASA Quality Publication, NSTS 5300.4(1D-2), Safety, Reliability, Maintainability and Quality Provisions for the Space Shuttle Program. Buyer reserves the right to perform periodic audits at Seller's facility

#### **QC46 Certification of Repair:**

Seller shall provide documentation to indicate the status of any material or article shipped against this Order (e.g., item repaired, refurbished, or returned in as-is condition.)

Buyer's Order number must be included on the documentation provided by the procurement source.

Documentation must contain the following:

- Part number, as specified on Buyer's Order
- Serial number (if applicable)
- Seller name and date
- Drawings/engineering orders and specifications with revisions, as specified on Buyer's Order

#### **QC47 USA Approved Controlled Processor:**

Controlled processes performed on this Order must be performed by a processor on Buyer's "USA Approved Controlled Processor List" via the USA Supplier portal at URL:

[http://www.usa-suppliernet.com/pqa\\_asl.htm](http://www.usa-suppliernet.com/pqa_asl.htm)

Seller's responsibility for acceptable processing is not diminished by Seller's use of Buyer's approved processors. Seller shall provide certification for controlled processes performed. Hardware processed shall be processed in accordance with the process and material specifications on this Order.

Use of superceding specifications is not permitted without authorization from Buyer.

Certification must contain the following:

- Part number
- Serial number and lot numbers of the hardware processed (as applicable)
- Material process specification & revision as specified on Buyer's Order
- Supplier - Controlled Process Procedure (CPP) number and revision as specified on buyer's order.
- Processor's name, address and date

**QC48 USA Supplier Calibration Laboratories:**

Calibration System Requirements for Calibration Laboratories that perform calibration of all Test & Measurement equipment. Calibration Laboratories shall establish and maintain a calibration system compliant to Calibration Laboratory general requirements of ANSI/NCSL Z540 or ISO 17025 accreditation.

A USA Approved Calibration Laboratory compliant to the requirements of ANSI/NCSL Z540 or ISO 17025 or other accredited certifying body shall perform these calibration services.

Buyer reserves the right to perform periodic audits at Calibration Laboratory facilities.

**QC49 Seller Certification:**

Seller shall provide certification with each shipment to attest that the parts, assemblies, subassemblies, or detail parts conform to the Order requirements.

- Buyer's Order number must be included on the documentation provided by the procurement source.
- Seller's name
- Part number as specified on purchase order

Seller shall perform inspection, as necessary, to determine the acceptability of all articles under this order. All articles submitted by Seller under this order are subject to final inspection by Buyer.

**QC50 USA Supplier Quality Assurance Distributor Requirements:**

Quality System Requirements for Sellers that procure parts, materials and assemblies from a manufacturer then sells the products to USA.

Seller will establish and maintain a quality assurance system compliant to the requirements of SM649, Distributor Quality Assurance Requirements. Buyer reserves the right to perform periodic audits at Seller's facility.

**QC51 USA Non-Government Customer Source Inspection:**

Work under this contract is subject to inspection by USA's customer Quality Assurance Representative (QAR) prior to shipment of goods from Seller's facility. Evidence of USA's customer source inspection is required to accompany shipment of goods on this Order.

Source inspection shall be conducted by USA customer QAR at Seller's facility or where designated in the Order.

Upon receipt of this contract, the Seller shall promptly notify the USA Buyer to coordinate with USA customer QAR so the appropriate inspection plan can be coordinated for source inspection at Seller's facility. The level of customer inspection performed will be as determined by the customer's QAR and may be conducted during processing, fabrication, or as a final inspection.

Seller shall make available to the QAR all applicable drawings, specifications, and changes thereto, related inspection and/or test equipment, and applicable inspection, measurement and test equipment as may be required to satisfactorily perform the inspections and tests required under this Order.

Seller shall notify USA Buyer a minimum of five (5) working days in advance of the time the articles, processes or services are ready for inspection or test to allow for notification of USA's customer QAR for the planned activity. The Seller shall not proceed past Customer Mandatory Inspection Points without written authorization from the Buyer.