



# QUALITY CLAUSES - ENFIELD, CT

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## **PCX QUALITY CLAUSE SUPPLEMENT FORM NUMBER 1 - RECORDS MAINTAINED BY SUPPLIER**

The following Quality Control Requirements apply to all vendors and purchase orders. See Procedure Number PROC 08 for Guidance

### **PCX AEROSYSTEMS ENFIELD LLC**

#### **GENERAL QUALITY CLAUSE**

- G1** Certification required. Please include our Job Number or, PO Number, Part Number, and Quantity, on Certificates with Serial Numbers if applicable.
  
- G2** Vendor to meet quality inspection system requirements of ISO 9001 and calibration system requirements of ISO 10012-1, or MIL-I-45208 and MIL-STD-45662, as approved by PCX.
  
- G3** PCX has identified the Purchase Order as ITAR/EAR controlled. An ITAR/EAR statement and watermark is depicted at the bottom of each page.  
Vendor must take necessary actions to be compliance with the ITAR/EAR law, referenced at [www.pmdtdc.state.gov](http://www.pmdtdc.state.gov)  
Vendor must flow down all quality and ITAR/EAR requirements to any sub-tier supplier including key characteristics.
  
- G4** To grant right of access by the organization, their customer and regulatory authorities to the applicable areas of all facilities, at any level of the supply chain, involved in the order and to all applicable records.
  
- G5** Records must be maintained covering all phases of manufacturing, processing, and inspection, for a period of 10 years for Non-Flight Safety and 40 years for Flight Safety, as required by ASQR-01 / SSQR-01 including unique requirements. Vendor must inquire with PCX for disposition requirements of records.  
Vendor to perform all Quality and B/P requirements as detailed on the Purchase Order and notify the

organization of changes in product and/or process, changes of suppliers, changes of manufacturing facility location and, where required, obtain organization approval. Vendor shall flow down to the supply chain the applicable requirements including customer requirements. Records must be maintained for life of program. Vendor must inquire with PCX for disposition requirements of records.

- G6** If applicable, an approved process source is required for this process. Contact PCX if approval is not valid on date of the Purchase Order.
- G7** No changes in product design, documentation, material, tooling, or processing shall be made. Contact PCX Engineering for approval.
- G8** Vendor agree that submission of an invoice under the Purchase Order to PCX for payment acts as certification that supplies, deliveries and/or services performed conform in all respects to the requirements of the Purchase Order. Nonconforming product shall not be shipped to PCX. Any departure from drawings, specifications, nonconformance or failure to meet other Purchase Order requirements must be recorded on PCX QC(F)2, form supplied upon request. Disposition of these departures must be approved by PCX prior to shipment.  
(Note: If any nonconformance is found after shipment of the product, the supplier shall notify PCX within 24 hours).
- G9** If applicable, approval number required on Certificates.  
For end-customer Sikorsky Aircraft, Procedure Approval Number required.  
For end-customer Rolls-Royce, FPA Number or Data-card required.
- G10** Government Flowdown. This is a rated order certified for national defense use, and you are required to follow all the provisions of the Defense Priorities and Allocations System regulation (15 CFR part 700). See body of PO for Government Contract No. and Rating No. if applicable.
- G11** Vendor to notify PCX Quality of any Non-Conforming product within 24 hours.  
PCX must approve any non-conforming product disposition.
- G12** Counterfeit Parts Prevention Program. PCX work instruction for Counterfeit Parts Prevention Program applies to this order.  
As applicable a cert of compliance is required per AS 6174 for any controlled material.  
PCX urges Suppliers to enroll in "GIDEP" Government Industry Data Exchange Program.

**G13** This process requires current Nadcap Accreditation. A certificate of conformance shall accompany parts with the following information:  
compliance to: PO requirements, processing specification(s) with revision, Nadcap Accredited process.  
Test data as applicable and/or required.

**G14** Vendor must maintain a quality management system  
Vendor must use customer-designated or approved external providers, including process sources (special processes)  
Vendor must ensure that persons are aware of: their contribution to product or service conformity, their contribution to product safety, and the importance of ethical behavior.  
Vendor must use statistical techniques for product acceptance and related instructions for acceptance by the organization.  
Vendor must flow down to external providers applicable requirements including customer requirements.

**G15** All individuals performing inspection activities require annual eye exams as detailed below.  
Unless otherwise specified, procedures shall be implemented to ensure that eye examinations, including visual acuity and color vision, as applicable, are administered by a medically qualified/trained person to all individuals performing visual inspection, other product acceptance activities and/or M&TE calibration that require visual acuity.  
Intervals shall not exceed one year.  
Individuals shall be tested in at least one eye, either corrected or uncorrected.  
Color Perception testing is required one time only. Individuals shall be capable of adequately distinguishing and differentiating colors used in the method for which certification is required, the process being performed or inspection activity.  
Records shall be retained for each individual.

**G16** Comply with PCX Code of Conduct

**G17** Comply with as applicable PCX Responsible Sourcing

#### **ADDITIONAL QUALITY CLAUSE NUMBER**

**4A** Packaging: Standard commercial MIL-STD-2073-1 Level C or equivalent.

**4B** Packaging: Clean. Wrap. No Oil.

**4C** Packaging: Magnesium, corrosive material preservation per SS8412 including oil, barrier paper or equivalent.

- 4D** Special requirements called out on the Purchase Order.
- 5** 1st Piece Inspection required. Contact PCX Quality Department.
- 6** Test pieces required.
- 7** Spline Charts required.
- 8** SA 1101 Form required.
- 10** "Flight Safety Parts" must be on certificates.
- 11** Flight Safety Parts – contains critical characteristics. See body of the Purchase Order for Category of Inspector. Please fill out SA Form 5193 if applicable.  
Inspectors Stamp on Certification is required. The latest revision of SS9211 applies to the Purchase Order.
- 12** Critical component parts per Kaman Aerospace KSD 0408. Requirements of QPS-2 apply. Must be on certificates.

- 14** Vendor shall submit, with each shipment of items covered by the Purchase Order, a Certificate of Conformance ("Certificate")
- This certificate must list all of the drawings and/or specifications that formed the Purchase Order, as well as the amendment revision level of each document named. This certificate must be dated, signed by a responsible representative, include the following statement (or an equivalent statement) (Note: Vendor's pre-printed certificate may be acceptable if it includes all of the requirements of this clause)
- (Note: Vendor must keep all quality records applicable to the Purchase Order. Retention time is 40 years. Vendor must call PCX prior to the destruction of quality records)
- (For Vendor of materials, only)
- Materials supplied conform in all respects to the requirements of the Purchase Order.
- (For Vendor performing a process, only)
- Processes performed and the results, for the Purchase Order, conform in all respects to the requirements of the Purchase Order.
- Vendor shall include a written statement on the certificate as follows:
- "Only materials furnished by PCX were used in the fabrication of items supplied on the Purchase Order."
- (For Vendor of materials which include processing thereto)
- Materials supplied, and processes performed, conform in all respects to the requirements of the Purchase Order.
- Certificates must identify manufacturing source and the date of manufacture.
- Certificates must report the current approved Method of Manufacture number used and its revision level and date. Certificates must report part classifications.
- Materials supplied shall be guaranteed to meet NDT requirements as defined by the end use customer drawing. If applicable per COL-ASQR-PRO-0003 Table 3, NDT audit program must include 25 random Collins Aerospace parts from each NDT method annually.
- 14B** For Rolls-Royce Parts, Certificates must report the current Rolls-Royce First Article Inspection Report (FAIR) approval date and the current Fixed Process Approval (FPA) number and approval date.
- 16** Government Source Inspection is required prior to shipment from your plant unless during performance on this order, your quality control or inspection system and manufacturing processes are subject to review, verification and analysis by authorized Government Representatives. Government inspection or release of product prior to shipment is not required if you are otherwise notified by the Government Source Inspector. Verify as applicable that process reviews required by DCMA are current. FAR Clause 52.246-2 applies.

- 18** Vendor shall provide certifications to the country of origin for the materials provided. The Vendor shall submit with each shipment certification that any bearing, bearing assembly, or any component part thereof, except the raw material (such as bar or rod stock and lubricants) or bearing contained in any item of the Purchase Order, has been manufactured in the United States or Canada or by an "other authorized manufacturer" as defined in DOD FAR Supplement 52.208-7006 and DFARS 252.225-7014 as applicable. In addition the requirements of DFAR 252.225-7009 apply in regards to specialty metals.
- 23** Please complete Inspection Report and return with parts.
- 25** If the Purchase Order is for "Make Complete", a completed inspection report submitted with parts is required.
- 26** All Material furnished or processing performed under the Purchase Order must be by a source who meets Rolls-Royce SABRe source approval requirements.  
This also applies to all sub-tier suppliers. The articles included in this order are for Roll-Royce end use. Rolls-Royce SABRe and or RRES 90000 quality requirements apply to this order.  
Review SABRe process documents. <https://suppliers.rollsroyce.com/GSPWeb/appmanager/gsp/guest>  
NDT site and processes must be Nadcap approved.
- 26B** FAIR package required per SABRe requirements and AS9102.
- 27B** PO's for Hardware and/or Parts to be used for Heroux Devtek the following applies: Additional Requirements detailed in Heroux Devtek Specifications HPS-10 applies to this order.
- 29** GE S1000 Quality System Requirements apply to this order  
GE C64 – Standard Terms and Conditions apply to this order
- 30** UTC / UTAS order: Supplier to meet requirements of ASQR-01, HSM19, and First Article requirements of HSM236  
Form 2 required with this order. As applicable supplier to meet requirements HSM-17 on reports 80 and 85 UTAS Form 34 required for any applicable or modified hardware  
All distributors for Metals, Electronics, and Hardware shall be on the UTC QDL
- 32** Material shall be procured from Laboratory Controlled Source (LCS).

- 33** For Parker End Use – Mechanical Properties – Q410 Foundry Control Clause Applies –  
The laboratory test report or certified statement of the test bar mechanical properties from the foundry control 1st Article Castings.  
The test bars used for the mechanical testing shall be from the same melt and heat treat lot as the foundry control 1st article castings.  
The testing must be performed by a test facility with Parker Aerospace (ASPL) and Nadcap approval for Materials Testing.  
The test results submitted from a foundry with Nadcap Materials Testing approval are also acceptable.
- 34** Performance on this order is subject to BOEING D6-82479 requirements if either the Engineering Drawing of the supplied Operation sheet requires a key or critical characteristic.
- 35** If a designated part (Ref: D6-1276/D36002). A forging manufacturing plan must be written per applicable specification(s) and submitted for Boeing approval prior to fabrication of production forgings. Certifications for first and subsequent lots of production forgings shall indicate the Boeing approval memo number for the particular forging part/dash number produced.
- 36** Items on this Purchase Order are for Boeing Chinook CH-47 Aircraft and must comply with all Boeing Philadelphia engineering and quality requirements, including D-590 and D1-4426 specifications for this particular item(s) ordered. Processer must be, and/or use D1-4426 sources and flow down the requirements of D1-4426 to any sub-tiers.
- 37** BOEING MESA Standard Q-Note – Production: Items on this purchase order are for the Boeing AH-64 Apache program. Quality records must be maintained, and be accessible within a reasonable time, for 40 years after completion of this Purchase Order. Boeing document EPB17-119 applies. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's that are applicable. Certification must contain Material Control (MC) number (for raw material only). Export Control Classification Numbers (ECCN's), if applicable, are contained in the text of this PO. If a Government Contract Number is stipulated in your PCX purchase order, Boeing's FAR/DFAR and Customer Contract Requirements (CCR) are incorporated herein by reference to these terms and conditions and are posted on Boeing's public Supplier Website. The following link can be used to locate Boeing's FAR/DFAR and CCR flow-down requirements:  
<http://www.boeingsuppliers.com/idscommon/ccr/contracts.htm>

**38** BOEING Philadelphia Standard Q-Note – Production: Items on this purchase order are for the Boeing CH-47 program. Quality records must be maintained, and be accessible within a reasonable time, for 50 years after completion of this Purchase Order. If BAC specifications apply, refer to Boeing document D1-4426 for PSD's and Certify to PSD's that are applicable. Export Control Classification Numbers (ECCN's), if applicable, are contained in the text of this PO. If a Government Contract Number is stipulated in your PCX purchase order, Boeing's FAR/DFAR and Customer Contract Requirements (CCR) are incorporated herein by reference to these terms and conditions and are posted on Boeing's public Supplier Website. The following link can be used to locate Boeing's FAR/DFAR and CCR flow-down requirements: <http://www.boeingsuppliers.com/idscommon/ccr/contracts.htm>. Look up the Government contract number located in the PO and select the latest date. These requirements apply to all components on the PO.

**39** GENERAL QUALITY REQUIREMENTS : Compliance with AS9100 OR ISO 9001 (latest revisions) is required; Compliance ANS/ISO/IEC 17025:2005/2006 or ISO 10012, latest revision is required; All certifications must include Purchase Order Number, Part Number(s), Part Number Revision(s), Serial Number(s), Operation Number(s), Specification(s) and Revision Level(s), Amendments (and PSD's if applicable), an Authorized signature and typed name and title of signatory. Certifications must also include supplier's approved plan title, number and revision/date as applicable. For Raw Material (Boeing Mesa only) a Material Control (M/C) Number is also required; These PO requirements must be flowed down to all sub-tier suppliers as applicable. All suppliers / sub-tier suppliers performing "special processes" requiring OEM/Prime approval must be on the OEM/Prime's "Approved Source/Supplier List" for that process at the time the material is processed. Supplier shall notify PCX Aerosystems Purchasing IN WRITING for approval of changes in product and/or processes; Supplier must have written authorization from PCX Aerosystems Purchasing prior to making any changes to product and/or processes; Supplier shall notify PCX Aerosystems Purchasing IN WRITING when a delivered product and/or affecting process nonconformance is discovered or suspected (including suspect counterfeit parts); Nonconforming product cannot be shipped to PCX Aerosystems without written authorization from PCX Aerosystems Purchasing PCX Aerosystems, its customer's and regulatory authorities retain the right of access to all facilities involved in this order and all applicable records; Quality documentation records and certifications must be maintained for a period of 50 years after final payment of this PO. After this time period the supplier shall not destroy such records without giving PCX Aerosystems Purchasing and Quality ninety days written notice and receive approval for the destruction of records. IF BAC Specifications apply: refer to Boeing document D1-4426 for PSD's and certify to PSD's that are applicable. If Sikorsky part the certification must state "Parts and/or services are destined for Sikorsky Aircraft". If supplier uses Boeing/Government supplied tooling in the performance of this PO, Boeing document D950-11059, SEC. 9 APPLIES.

**40** Boeing document D950-11059, Section 9 – Boeing/Govt "Each Use Condition Check" applies when using PCX Aerostructures supplied BAC/Govt tooling or gages.


**41** Boeing Mesa Production – Boeing document DE-STD-1 applies in lieu of EPB17-119.

**42** This PO contains Boeing Digital Product Data – the requirements of D6-51991 Quality Assurance Standard for Digital Product Definition at Boeing Suppliers applies.

**43** This part number is process controlled per PPAP requirements. No changes to manufacturing process, speeds, feeds, tools, programs or machining center are allowed without prior written approval from PCX Aerosystems engineering.

**PCX AEROSYSTEMS  
COMPANY HEADQUARTERS**

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