

1.0 PURPOSE

- 1.1 To define the minimum Quality Assurance requirements for suppliers who provide material and/or services to Composites Horizons (CHI). Quality Clauses 2.1 through 2.31 are applicable to all purchase orders for production parts and processes. Quality Clauses 3.0 through 6.0 are only "As Required", based on individual purchase order requirements.

2.0 REQUIREMENTS

- 2.1 The Supplier shall submit a CERTIFICATE OF CONFORMANCE with each lot/shipment.
- 2.2 The latest revision of specifications reflected or implied in this purchase order are applicable unless otherwise noted.
- 2.3 Supporting certification for Special Processes, Raw Materials, and/or Acceptance Testing shall accompany each lot/shipment, as applicable. The Supplier shall use only CHI/ CHI's Customer approved sources for special processes, as applicable.
- 2.4 CHI may refuse to accept item if Supplier fails to submit certifications, documentation, test data or reports specified by this procurement document.
- 2.5 Subcontracting with other than CHI approved suppliers is prohibited without written permission.
- 2.6 Raw materials for Government orders shall not be procured from foreign agencies or produced in non-domestic mills unless previously approved by CHI . Any "specialty metals" identified in DFARS Clause 252.225-7009 which have been melted outside of the United States, its possessions or Puerto Rico are prohibited. When approval is granted, an independent laboratory analysis by a CHI approved laboratory may be required.
- 2.7 If the contract specifies a "DO" or "DX" type DPAS rating, the Supplier is obligated to comply with all of the relevant provisions of section 15CFR350 of the Defense Priorities and Allocations System Regulation, including flowing such rating and requirements down to their own subtiers.
- 2.8 The Supplier shall determine, provide, and maintain the infrastructure needed to achieve conformity to product requirements. Requirements for maintenance activities shall be documented, and records retained. Suppliers shall maintain an acceptable level of cleanliness to assure the prevention of foreign object debris (FOD).
- 2.9 Machining techniques performed by the Supplier or their subcontractors

which impart significant localized heating (i.e. EDM, ECM, plasma applications, laser use, etc.) are prohibited unless authorized by CHI prior to performance.

- 2.10 When titanium material is machined per the purchase order, either deionized water or non-halogenated coolant must be utilized exclusively as the coolant medium.
- 2.11 A written Dimensional Inspection Report shall accompany each lot/ shipment submitted. A First Article shall be submitted per AS9102 on the first delivery. A Delta First Article shall be submitted for any part revision changes, as applicable.
- 2.12 Component parts and/or assemblies shall be inspected / tested in accordance with ANSI Z1.4 unless otherwise specified.
- 2.13 The Supplier shall be responsible for all sub-tier services and/or goods. CHI reserves the right to disapprove the use of any sub-tier.
- 2.14 The Supplier shall maintain a quality system meeting the requirements of AS 9100 or ISO 9000 unless otherwise agreed to by CHI.
- 2.15 Discrepant items must be submitted to CHI's Purchasing for proper disposition prior to shipment.
- 2.16 The Supplier is accountable for all CHI supplied materials. All materials must be returned to CHI, whether partial, complete, discrepant or scrap.
- 2.17 Certifications for products containing fasteners must be certified with one of the following statements to meet the FASTENER QUALITY ACT(FQA).
 - 2.17.1 All contained fasteners meet the requirements of the FQA and records of compliance are maintained on file.
 - 2.17.2 All contained fasteners were produced prior to the implementation of FQA and are therefore exempt.
 - 2.17.3 Materials and parts are not assembled with fasteners covered by FQA.
- 2.18 Right of access to Supplier facilities shall be granted to CHI, CHI's customers or any regulatory authorities, as required/ requested.
- 2.19 The Supplier shall ensure that their employees are aware of:
 - their contribution to product or service conformity,
 - their contribution to product safety,
 - the importance of ethical behavior.
- 2.20 The Supplier must ensure the competence of their employees, including any required qualifications of persons.
- 2.21 The Supplier will retain Quality Records for a minimum of fifteen (15) years from the date of shipment.

- 2.22 All drawings/electronic datasets furnished by CHI are the property of CHI

- and its customers. The information given shall not be shared or given to anyone without the written approval of CHI or it's customers and must be returned to CHI upon completion of the contract.
- 2.23 The Supplier shall not change any drawing, process, material (including Subtier supplier parts), manufacturing facility location, or procedure without prior CHI Buyer written approval, if such drawing, process, material, location or procedure was previously approved by CHI Buyer as provided for in the procurement document.
- 2.24 The Supplier shall not change any process, material or procedure from that used to qualify any item or which was used by Supplier to become a qualified source for CHI's specification/drawing, without CHI written approval.
- 2.25 The Supplier shall immediately notify CHI when it is suspected or known that nonconforming material has been delivered. The notification must include a clear description of the actual or suspected nonconformance.
- 2.26 When a quality problem exists with any received Supplier item, CHI will forward a "Supplier Corrective Action Request" (SCAR) to Supplier, requiring timely response that shall include the following information, as a minimum: analysis of the cause of the problem, statement of the action taken to prevent recurrence, and the effectivity of the action. Failure to respond within 30 days of receipt of a SCAR may result in an onsite audit by a 3rd party auditor, to be fully paid for by the supplier.
- 2.27 No work purchased, manufactured or otherwise acquired for use in the performance of or to be delivered under this order shall be transported on vessels, aircraft or other carriers leased to or from, owned, operated or controlled by any prohibited country identified in the International Traffic in Arms Regulations (ITAR), 22 CFR 126. No vessels, aircraft or other carrier, while carrying any such work shall make an enroute stop in any prohibited country identified in ITAR, 22 CFR 126.
- 2.28 The product and the associated technical data related to this purchase order is considered ITAR and/or EAR controlled pursuant to 22 CFR Part 120-130 and 15 CFR Parts 730-774 respectively. Transfer of this product or data by any means to a Non-US Person, whether in the United States or abroad, without proper U.S. Government authorization (e.g., License, exemption, NLR, etc.), is strictly prohibited.
- 2.29 The Supplier will insure that adequate packaging and preservation of hardware is performed to prevent damage or deterioration during manufacture and shipment to CHI.
- 2.30 Suppliers are responsible for notifying CHI in the event of any

significant change at the Suppliers or subtiers facility, including company name, Quality System, Management or Quality Management.

- 2.31 The Supplier shall comply with all applicable requirements of AS6174, Counterfeit Materials.

3.0 End of Use Customer Specific Requirements

- 3.1 For fabrication or processing of component parts or assemblies for delivery to **General Electric**:
- 3.1.1 General Electric Quality Management System S-100, S1002 and S-450 applies as applicable with respect to the specific product supplied.
 - 3.1.2 All special processing, such as Chemical Surface Treatment, Heat Treating, Welding, NDT, etc, shall be performed only by suppliers listed in the current G.E. Approved Source List for Special Processes.
- 3.2 For fabrication or processing of component parts or assemblies for delivery to **Pratt and Whitney**:
- 3.2.1 Pratt and Whitney ASQR-01 and PW-QA-6088 applies as applicable with respect to the specific product supplied.
 - 3.2.2 LCS approved suppliers need only to supply a Certificate of Conformance, and include a statement that they are LCS approved by Pratt and Whitney.
 - 3.2.3 All special processing, such as Chemical Surface Treatment, Heat Treating, Welding, NDT, etc shall be performed only by suppliers listed in the current Pratt and Whitney Approved Source List for Special Processes. Specific certification statements may be required based on the program requirements.
- 3.3 For fabrication or processing of component parts or assemblies for delivery to **Honeywell**:
- 3.3.1 Honeywell Quality Management System SPOC-002 and SPOC 108 apply as applicable with respect to the specific product supplied.
 - 3.3.2 All special processing, such as Chemical Surface Treatment, Heat Treating, Welding, NDT, etc. shall be performed only by suppliers listed in the current Honeywell Approved Source List for Special Processes per SPOC 165.
 - 3.3.3 Original processing certifications are required.
 - 3.3.4 All documents/certifications must include the current revision letter of any specifications used.

- 3.3.5 Heat Treated parts must be 100% hardness tested and certified.
- 3.4 For fabrication or processing of component parts or assemblies for delivery to **Middle River Aircraft Services:**
- 3.4.1 Middle River Aircraft Quality Management System S-1007 applies as applicable with respect to the specific product supplied.
- 3.4.2 All special processing, such as Chemical Surface Treatment, Heat Treating, Welding, NDT, etc. shall be performed only by suppliers listed in the current Middle River Aircraft Source List for Special Processes.
- 3.4.3 Original processing certifications are required.
- 3.4.4 All documents/certifications must include the current revision letter of any specifications used.
- 3.4.5 Heat Treated parts must be 100% hardness tested and certified.
- 4.0 **Special processing requirements for Rubber, Plastic and Chemical Products:**
- 4.1 Supporting certification reflecting the suppliers lot/batch number, cure date and date of manufacture, including Technical Data Sheets, shall accompany each lot/shipment.
- 4.2 Unless otherwise specified, limited life products shall not be delivered with less than 75% of the product shelf/service life remaining.
- 5.0 **Special processing requirements for Plating, Painting, Anodizing, Cutting or Non-Destructive Testing of Component Parts and/or Assemblies:**
- 5.1 Certifications shall include, as a minimum:
- Processors name and address
 - Controlling specification(s) with revision(s)
 - Applicable process parameters, such as time, plating thickness, etc. (time in/time out for critical parts, as applicable)
 - Mechanical properties if/as required
 - Customers order number
 - Part numbers
 - Serial numbers or Lot numbers of processed hardware
 - Certification stating process performed per applicable drawing and purchase order requirements
 - Signature and date of company official attesting to acceptance of the process performed (Level III if NDT performed).
- 6.0 **Special processing requirements for Heat Treatment and Curing of Component Parts:**

- 6.1 Certifications shall include, as a minimum:
- Processes performed
 - Controlling specification(s) and revision(s)
 - Applicable process parameters. Such as time, temperature, etc. (time in/time out for critical hardware or as requested)
 - Mechanical properties after heat treat.

7.0 **Machine services shall include, as a minimum:**

- 7.1 CNC Machines, Autoclaves, Ovens, Presses.
- Calibration system must be accredited to AS9100, ISO9000, ISO17025, ISO10012-1 and satisfies the requirements of 10CFR part 21, 10CFR, Appx. B, Part 50, ANSI Z540-3.
 - In accordance with ISO/IEC Guide gg-3:200g (GUM)
 - Measurement standards used to calibrate the machine and named on the certificate must be compliant to ISO/IEC 170252:2017 and ANSI/NCSL Z540.1 - 1994 (R2002)
 - Traceability must be to the national standards administrated by the U. S. NIST.
 - When not specifically called out in measurement report, a minimum Test Uncertainty Ratio (TUR) of 4:1 can be assumed, generally 10:1 in most cases.
 - The results relate only to the items calibrated and the certification shall not be reproduced, except in full, without the written approval from the Metrology company performing the service.
 - CHI may request supporting documentation related to the traceability at any time.

8.0 Revision History

Revision	Changes	Changes By	Date
NC	Incorporated prior CHQAR's	P. Giffin	1/11/19
A	Added Servicing Updated Titles under approver	T. Hynes	12/09/2022

Approved: _____ Date: _____
VP Operations