

**QC Document 42261**

**Has been superceded by**

**QC Document 40025**

**Incorporation date 11/4/11**

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**NOTE: YELLOW HI-LITED AREAS IDENTIFY LATEST REVISION CHANGES.**

**QC-1 OBSOLETE**

**QC-1A OBSOLETE**

**QC-1B Quality Management Systems** - The supplier will as a minimum maintain and implement a documented quality management system, available in the English language, that is certified to AS9100 and/or ISO9001 (AS9120 is acceptable for distributors, ISO 17025 is acceptable for material test and calibration laboratories). This system is subject to review by AMT Quality Assurance. The supplier shall promptly notify AMT of any changes in the management representative with assigned responsibility and authority for the quality system.

**QC-1C Quality Management Systems - Less than AS9100 Suppliers** – Suppliers who do not maintain a quality system certified to AS9100 and/or ISO9001 must maintain documented procedures, available in the English language, that address the following:

1. Identification and Traceability
2. Control of Nonconforming Material
3. Control of Customer Property
4. Process Control
5. Measurement and Monitoring of Product
6. Training
7. Preservation of Product
8. Control of Quality Records
9. Internal Audit
10. Contract / Purchase Order Review

Additionally, the supplier shall promptly notify AMT of any changes in the management representative with assigned responsibility and authority for the quality system.

**QC-2 Certifications** – A certificate of conformance shall accompany each shipment and include a statement that the product provided meets the controlling engineering and purchase order requirements. Distributors of hardware or raw material are required to include copies of the original manufacturer certifications.

**QC-2A Raw Material Certifications** – A certificate of conformance shall accompany each shipment and include chemical and physical analysis. The certificate must state that the material supplied

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meets the applicable specifications and must specify the revision level of the material specification. AMT supplied material will be maintained by AMT and is not subject to this clause. Distributors of raw material are required to include copies of the original manufacturer certifications.

**QC-2B Certifications - Non AS9100 Suppliers** – Suppliers who do not maintain a quality system certified to AS9100 and/or ISO9001, (or at AMT discretion), and provide “purchased complete” product to AMT must provide a certificate of conformance including a statement that the product provided meets the controlling engineering and purchase order requirements with each shipment. Also include all material and processing (including special processing) certifications with each shipment. Distributors of hardware or raw material are required to include copies of the original manufacturer certifications.

**QC-3 Shelf Life** – The manufacturing and applicable expiration dates must be noted on each individual container and / or certification.

**QC-4 First Article** – Supplier shall perform First Article Inspection in accordance with AS9102 on all supplied product. AS9102 forms are available from AMT upon request. First Article Inspection reports are to be supplied with the production shipment for all first article parts.

**QC-5 Source inspection** – Source inspection is required by AMT Quality. Supplier must contact the AMT Buyer prior to all shipments to AMT.

### QC-6 OBSOLETE

**QC-7 Statistical Process Control** – Statistical process control is required and shall be implemented on this order as defined on the purchase order.

**QC-8 In-Process Inspection** – In process inspection is required by AMT. The specific inspection point in the process will be specified on the purchase order. The supplier will contact the AMT Buyer and hold the product for in-process inspection by AMT Quality.

**QC-9 Frozen Planning** – Upon acceptance of the first article, the supplier shall make no changes to the method of manufacture, equipment used, materials, or processes which may affect interchangeability, function, dimensions, performance, or finishes. All changes must be approved in writing by AMT Quality or Engineering.

**QC-10 Pre-production First Part Approval** – The supplier shall submit the first part to AMT for inspection verification.

**QC-11 Manufacturing Facility Location** – Supplier is required to notify AMT of changes in manufacturing facility location. Upon review of the proposed changes, AMT may require additional information and/or approval prior to implementation.

**QC-12 Parts identification** – Parts identification – In addition to drawing requirements, all parts ‘purchased complete’ must be, at a minimum, identified with the part number, manufacture date, supplier lot number, and AMT assigned vendor number. The manner and location of this

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identification shall be agreed upon with AMT Engineering and/or AMT Quality. QC-12A is an acceptable substitution for QC-12.

**QC-12A Parts identification** – In addition to drawing requirements, all parts ‘purchased complete’ must be identified with the part number, manufacture date, purchase order number, line item number, and release per the following: PXXXXXXXXXXXXX (14 numerical digits following “P”), consisting of the letter “P” followed by a 9 digit PO #, 3 digit PO line #, 2 digit PO release #. The manner and location of this identification shall be agreed upon with AMT Engineering and/or AMT Quality.

The lettering should read in the following format: Color is shown only in this example and is not required on part mark.  
*Example:* Purchase order P294699 Line item 3, Release 2 would be marked as

P00029469900302  
 (10) digit PO number “P” followed by 9 digits (add 0’s to utilize all 10 digits)  
 (3) digit P.O. line number. (add 0’s to utilize all 3 digits)  
 (2) digit P.O. release number (00 if no releases)

**QC-13 Protection of Product against Contamination or Damage** – Product must be boxed, banded, or shipped in a manner that will ensure that no damage will occur. External threads must have special protection against damage.

**QC-14 Right of Entry** – AMT and/or AMT's customer or government representatives will have the right to survey facilities and review all processes, subcontractors, contracted parts, procedures and records.

**QC-15 Subcontracting**– Supplier is authorized to subcontract special processes (as defined and controlled by AMT customer specifications) outside of supplier's capabilities. All other subcontracting requires written consent from AMT Purchasing and approval by AMT Quality Assurance. Supplier shall flow down to Subcontractors any/all applicable requirements in the purchasing documents, including key characteristics, where required.

**QC-16 Delegated Source Program** – Supplier has been selected to perform delegated source inspection for AMT Quality Assurance. The supplier must meet all the requirements agreed upon between the supplier and AMT. No deviation is allowed from these requirements unless written permission is granted from the AMT Quality Assurance Manager.

**QC-17 AMT Supplied Drawings / PCMs** – All engineering drawings / PCMs provided by AMT are AMT property and must be returned with this order.

**QC-18 OBSOLETE**

**QC-18A NADCAP Approval - HT** – Supplier must be NADCAP approved per AC 7102 Heat Treating.

**QC-18B NADCAP Approval - WLD** – Supplier must be NADCAP approved per AC 7110 Welding.

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**QC-18C NADCAP Approval - CP** – Supplier must be NADCAP approved per AC 7108 Chemical Processing.

**QC-18D NADCAP Approval - NDT** – Supplier must be NADCAP approved per AC 7114 Non-Destructive Testing.

**QC-18E NADCAP Approval - SE** – Supplier must be NADCAP approved per AC 7117 Surface Enhancement.

**QC-18F NADCAP Approval - COMP** – Supplier must be NADCAP approved per AC 7118 Composites.

**QC-18G NADCAP Approval - MTL** – Supplier must be NADCAP approved per AC 7101 Material Testing Laboratory.

### **QC-19 OBSOLETE**

**QC-20 Quality Records** – Suppliers shall maintain quality records, including traceability throughout all stages of manufacturing. No quality records shall be destroyed without the written consent of AMT Quality.

### **QC-20A OBSOLETE**

### **QC-21 OBSOLETE**

### **QC-22 OBSOLETE**

**QC-23 Revision Control** – Unless otherwise specified, latest revision applies on all specifications used in product manufacture.

**QC-24 ITAR Requirement** – IMPORTANT/CONFIDENTIAL: This PO (and any drawings and/or attachments accompanying it) may contain confidential information, including information protected by United States Government. The information is intended only for the use of the intended recipient(s). Delivery of this PO to anyone other than the intended recipient(s) is not intended to waive any privilege or otherwise detract from the confidentiality of the PO. If you are not the intended recipient, or if this PO has been addressed to you in error, do not read, disclose, reproduce, distribute, disseminate or otherwise use this information, rather, please promptly notify the sender by phone or e-mail, and then destroy all copies of the PO and its attachments, if any.

**QC-25A DPD Requirement (Boeing)** – Suppliers utilizing AMT supplied Digital Product Definition (DPD) for the purposes of manufacturing and/or inspection of Boeing product must hold written approval from AMT for compliance to Boeing D6-51991.

**QC-25B DPD Requirement (Spirit)** – Suppliers utilizing AMT supplied Digital Product Definition (DPD) for the purposes of manufacturing and/or inspection of Spirit product must hold written approval from AMT for compliance to Spirit MAA1-10009-1.

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**QC-25C DPD Requirement (Vought)** – Suppliers utilizing AMT supplied Digital Product Definition (DPD) for the purposes of manufacturing and/or inspection of Vought product must hold written approval from AMT for compliance to Vought SQR-004.

**QC-25D DPD Requirement (Goodrich)** – Suppliers utilizing AMT supplied Digital Product Definition (DPD) for the purposes of manufacturing and/or inspection of Goodrich product must hold written approval from AMT for compliance to Goodrich QA-111 Addendum J.

**QC-26 Tooling** – Suppliers utilizing Boeing owned tooling are required to comply with D33200, Boeing Suppliers' Tooling Document.

**QC-27 Sampling Inspection** – Suppliers performing acceptance sampling shall meet the requirements of document ARP9013, "Statistical Product Acceptance Requirements", with minimum protection levels meeting ARP9013 Figure B1. For Boeing product, Boeing approval of each revision of the Supplier's acceptance sampling plan is required prior to use. When statistical process control is used as an option for either in-process or final inspection, the Supplier shall satisfy the requirements of ARP9013/3 "Statistical Product Acceptance Requirements Using Process Control Methods" available at <http://sae.org/servlets/index>. In all cases, inspection requirements identified by engineering drawing or specification take precedence over the inspection requirements defined herein.

**QC-28 Material Review** – Supplier shall provide written notification to AMT within one (1) business day when a nonconformance is determined to exist, or is suspected to exist, on product already delivered to AMT under any order. When the following is known, written notification shall include:

- A - Affected process(es) or product number(s) and name(s)
- B - Description of the nonconforming condition and the affected engineering requirement (i.e., what it is and what it should be)
- C - AMT purchase order/line item/release, manufacturer lot number, quantities, and dates shipped to AMT.
- D - Outside Services nonconforming parts are to be tagged with a description of nonconforming Condition.

The Supplier shall not use dispositions of use-as-is or repair on nonconforming product.

**QC-29 Excess Inventory** – The Supplier shall strictly control all inventory of customer proprietary product that is in excess of contract quantity in order to prevent product from being sold or provided to any third party without prior written authorization from AMT.

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