

Summary of Changes

095871 Contracts Deliverable Requirements

This is to notify you of changes to the BAE Systems Contracts Deliverable Requirements Manual. Please see the following changes/additions:

Legend:

This is to notify you of changes to the BAE Systems Supplier Quality Assurance Manual. Please see the following changes/additions:

Legend:

- Addition
- Change
- Deletion

012 Flammability

A flammability certification to the specification noted on the drawing from the original material manufacturer or a flammability test report from a BAE Systems approved facility, is required. Certification shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) for this item.

Changed 019 to 019A and added 019B

019A Test Samples – Tensile Testing

The Supplier shall provide a set of two samples (un-machined test bars/sheet stock) suitable for the mechanical testing as required by Purchasing Agreement or referenced specification. Both shall be made from the same melt and heat treated in the same lot as the supplied parts. Identify by paint marking.

019B Material/Process Samples:

A representative material test sample (the same as the material lot) is required. The test sample shall be processed simultaneously with the material it represents, through all special processing. The sample shall be of sufficient size and configuration to permit BAE Systems to determine heat treatment, plating, painting, etc., results in lieu of destroying a completed part. The supplier shall submit the processed test sample with completed material / parts to BAE Systems.

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029 Serialization:

The supplier shall identify items using marking methods as required by drawings, specifications, and/or the PO. Serialization logs shall be maintained to prevent duplication of serial numbers. The supplier's quality system shall ensure traceability of all serialized items and materials to the original materials. When two or more serialized parts are joined in an assembly, the supplier shall include a list for each assembly serial number with the part numbers, change letters, and component serial numbers making up the assembly serial number. This information shall be supplied with each shipment.

030A Approved Special Processors (BAE):

The supplier is to use BAE Systems approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current Approved Processor Listing may be obtained from the cognizant BAE Systems Buyer.

030B Approved Special Processors (Customer):

The supplier is to use BAE Systems' customer approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current approved processor listing may be obtained from the cognizant BAE Systems Buyer.

042 SPC Program:

Statistical methods and procedures used by the supplier to implement and maintain a documented continuous improvement program may be subject to review by BAE Systems' Quality Assurance. Using statistical process-control methods, tools, and documentation, the supplier must monitor key characteristics noted directly on the PO or engineering documents. Copies of the control charts, (including notes and corrective action for assignable causes) must be delivered with each shipment. Processes that are out of control or yielding a Cpk of less than 1.33 require 100% inspection for key characteristics prior to certification and delivery of the production lot. Documented inspection reports shall accompany each shipment. The supplier is responsible for the flowdown of this CDR to their subcontractors.

053 Dock-To-Stock Eligibility:

This part number is not eligible for the dock-to-stock program. All CDRs specified apply including the requirement to provide associated certifications, inspection and test reports.

Changed CDR 055 to 054

054 AQL 1.0

This item requires inspection at AQL 1.0 to the C=0 Sampling Plan for all major drawing characteristics. Major drawing characteristics are dimensions with a total tolerance of ≤ 0.010 or where the characteristic is identified as a "major" by a drawing note or SQAP/QAP/QAR.

Changed CDR 056 to 055

055 100% Inspection

This item requires 100% inspection of all critical drawing characteristics. Critical characteristics are any dimensions with a total tolerance of ≤ 0.001 or where the characteristic is identified as a "critical" by a drawing note or SQAP/QAP/QAR.

Changed 056 to PPAP Level 1

056 PPAP-Level 1:

The Supplier shall complete a PPAP in accordance with Level 1 of the Production Part Approval Process manual and shall submit a Warrant and an Appearance Approval Report as required to BAE Systems for approval.

086 Counterfeit Material Program:

Prior to first product delivery the supplier is required to submit and gain approval, by BAE Systems Procurement, documentation confirming the traceability of parts to be delivered were produced by the Original Equipment/Component Manufacturer or sourced directly from an Authorized Distributor. Parts from sources other than the OEM/OCM or Authorized Distributor will require submission and approval, by BAE Systems Procurement, of Certificates of Conformance, Certificates of Origin and/or Performance Test Reports. With every delivery the supplier is required to provide a Certificate of Authenticity stating compliance with sourcing from OEM/OCM, Authorized Distributor or BAE Systems pre-approved supplier.

034 Ballistic Requirements- Metal and Composite Materials

Removed requirement for micro hardness.

020 Heat Treating

The below processes shall be completed as stated per specific drawing requirements. When a conflict is noted between this document and specific drawing requirements, the drawing requirements take precedence.

C. Quench and Temper (Surface Hardness Specified, Core Hardness Not Specified)

The report shall include a statement of the surface hardness findings for each heat treat lot. Testing shall be done in areas identified on the drawing or in such a manner as to not damage the critical surface finish as defined by the drawing.

A test specimen (or additional part) of the same alloy and same size, within 20% of the largest

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cross section thickness, shall be heat treated with each heat treat lot. The test sample shall have a length at least one inch longer than the section thickness or two times the diameter. The specimen or sample part shall be cross sectioned at mid-length of the largest cross section thickness plus or minus 3/8 inch. The Supplier shall submit a report including the actual surface hardness and core hardness at . radius (core hardness measured on cut surface).