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Contact Weber Metals' the Supplier Quality Group for any questions or clarification.
Contact email: supplierqualitygroup@webermetals.com

The supplier is required to review relevant clauses. It is preferred that the supplier submit the review form to the email above.
The form is QP 8.4 F006. See attachment at the end of this document.

A Quality Alert form will be used to flow down "Advisory information" see attachments section.

Forms and Quality Clauses Code Matrix:

QP 8.4 F001 (long and short forms) Supplier Evaluation Forms

QP 8.4-F006 **Supplier review form -for QA documents, QA Clauses, WMPS, WMMS, WMQS specs**

QWI 8.7-3 F001 **Supplier Deviation Submittal Form**

QWI 8.7-3 F002 **Supplier Deviation Submitted Form : Raw Material/Tooling Services**

Quality Alert Form- Shall be reviewed and act accordingly to the topics listed.

Supplier Corrective Action Request Form – Supplier agrees to provide a formal response to any corrective action request within the time frame indicated on the SCAR.

Quality Clauses Matrix **Quick Reference of QA Clauses by Supplier Type**

Supplier Aids for training: Contact the QA manager for the information below

FOD Awareness

Fight Safety Awareness/Product Safety

Ethics Program

Quality Cardinal Rules program

Code of Conduct Exam

FTA Secure Portal for communication of DPD and ITAR documents

8-D Problem Solving tool

Counterfeit Material

Definitions:

WMPS **Weber Metals Process Specification**

WMMS **Weber Metals Material Specification**

WMQS **Weber Metals Quality Specification**

Index:

1. Standard (STAN)
2. Die Sinking (DS)
3. Engineering (ENG)
4. Heat Treat (HT)
5. Machining (MACH)
6. Quality (Q)
7. Shipping and Material Handling (SMH)
8. Testing (TEST)
9. Raw Material (RM)
10. Miscellaneous (MISC)

Note: Suppliers shall be aware and abide by the **REACH substances** from European Economic Area. Substances banned within the EEA can only be used with proper authorization from ECHA (European Chemical Agency).

www.webermetals.com can be use to download supplier documents. Ref. Supplier portal.

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1. STANDARD**New 1/19/15**

STAN6: (Prohibited Materials – Ozone Depleting Substance) Class 1 Ozone Depleting Substances (ODS) shall not be used in the design, test, manufacture, integration and assembly, handling, transportation, operations, maintenance or disposal of the hardware / components delivered to this order.

2. DIE SINKING**New 10/5/2005****Revised 1/30/17**

DS1: (Die Impression) The supplier is to provide an inspection report of the finish die impression to Weber Metals Engineering for review and approval (Electronic scan of the die using a type of CMS or GOM type equipment) prior to each finish die shipment. Use AS9102 Format as applicable. Supplier could also be requested to provide a partial plaster cast to verify raised character when a die needs to be re-engraved.

New 1/19/15

DS2: (Part Identification) Unless otherwise specified, when part markings are included in the die design the supplier is responsible to include all numbers, symbols, and figures in the part marking.

3. ENGINEERING**New 10/5/2005****Revised 3/6/19**

ENG1: (Receipt of Electronic Data) Electronic data supplied by Weber Metals to the supplier is proprietary and cannot be transferred to other parties without the written consent of Weber Metals, Inc.

Weber Metals uses a website for file transfers. It is secure, encrypted, and ITAR compliant. Supplier is required to use FTA for file transfer activities. This is required in order to protect ITAR controlled information. Contact the Supplier Quality Group for a training presentation.

Revised 1/23/17

ENG2: (Digital Data Quality Plan) If digital data is supplied for an order (DPD models, etc.) to be used in the tool design, manufacture or inspection of tooling and or product, the supplier shall develop and maintain procedures for managing digital datasets. It is the supplier's responsibility to assure compliance with the requirements of WMQS-001 "Supplier Digital Data Requirements." Contact Weber Metals Supplier Quality Group and or the Purchasing Manager for current revision. The WMQS-001 meets Weber Metals customer requirements. (e.g. D6-51991, MAA1-10009-1, etc.).

New 1/23/17**Revised 3/6/2019**

ENG3: (Software Control) The supplier shall develop and maintain software control procedures used in the design, analysis, manufacture, inspection, test, or calibration which directly affects or verifies the configuration, conformity, or quality of a service or product. Business systems software is excluded from this requirement.

Manufacturing and Test Software:

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- Software used in the design, analysis, manufacture, inspection, acceptance, test or calibration that has a direct effect on the configuration, conformity or quality of deliverable product.
- Examples of software: Machine system software. Non-part specific software used to run automated equipment, usually provided by the machine vendor. Examples: CMM, Romer or Faro Arm, 3D-Capture, Tensile machines, CNC machine. CMM Inspection programs for the inspection of forgings.

The procedure shall cover the following:

1. Requirements phase-Defines the purpose or function of the software:
See example below.

Area	Procedure/ Requirements	Initiated/ Approval	Purpose or Fuction	Risk
Digital Models	DDQP-001 Digital Data Quality Plan	Engineering Dept. and IT Manager	Model created to created tooling/ dies to make forgings and instruction/prints	High
Heat Treat	QWI 8.5-29 Heat Treat compliance to AMS 2772 and AMS 2750	Metallurgy	Heat Treat, Furnace control using Trendlink or Ignition or similar software	Hight

2. The next requirements deal with full configuration control: Version control, change control, access control, archiving, backup and recovery, identification, storage, handling, release and Export compliance (ITAR) "Software Control" applies to:
 - Part specific program (e.g. Computer Numerical Control (CNC), Coordinate Measuring Systems (CMS)
 - Coordinate Measuring Machine (CMM)
 - Gage Calibration –when software is used to conduct calibration requirements.
 - Computer Aided Design Models (CAD)
 - Programmable Logic Control (PLC)
 - Executive software, (e.g., robot dipping, CMM, CNC, etc.)
 - Special Process Software (e.g., heat treat/pyrometry, automatic saw cuts, etc.)
 - Hardware/ Software Qualification
3. **Supplier is require to implement when required to performed AS9102 Final Inspection per PO:**
 - **Part Specific CMS Inspection Programs- Independent Method of Inspection :** Method of inspection using calibrated and traceable measuring & test equipment using inputs different from those of the software under test such that programming errors, specification interpretation errors, and decisions made by the programmer that affect the accuracy of the inspection are not duplicated. Independent methods of inspection may include hand gauging, bench layout, previously approved automated inspection programs, manual-mode machine inspection involving a different programmer/inspector or automated inspection programs involving a different programmer/inspector. Applies to CMM inspection programs.
 - ✓ Software for automated inspection (e.g. CMM, CMS, etc.) shall be verified by correlation of the test results with the results from an independent method of inspection.
 - ✓ Inspection of Pratt&Whitney products requires the following: Acceptable correlation requires the difference to be within 10% of the tolerance for each characteristic. Differences greater than 10% but not exceeding 25% may be acceptable with documented justification. Records of review must be retained.

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- The independent method also requires a different person other than the person who created the inspection program to perform the verification.

4. HEAT TREAT**New 10/5/2005****Obsolete 1/19/15****HT1:** (Load Thermocouple)**New 10/5/2005****Revised 1/19/15**

HT3: (Chemical Milling) Unless otherwise specified, 6-4 titanium has a required chemical milling removal amount of 0.016 - 0.018 inches per face. 10-2-3 and 6-6-2 titanium have a required chemical milling removal amount of 0.014 - 0.016 inches per face. A witness pad to verify the removal amount is required on 10% of each Weber Metals Chem Load to ensure compliance. The tolerance for the measurement of a witness pad is (- 0.0, + 0.003") for the removal amounts specified. This tolerance does not broaden the chemical mill range specified and is only to cover variation in measurement from one forging to another.

New 5/30/14**Revised 3/5/19**

HT4: (Heat Treatment Guidelines) The heat treatment shall be performed in accordance with the instructions noted on the purchase order/Delivery Note. If the supplier believes that the instructions are incorrect, discontinue work and contact Weber Metals Product Metallurgy department or Supplier Quality Group to resolve the issue. Note: Fixed Operations work is to be conducted per fixed practices such as frozen HT plans.

New 5/30/14

HT5: (Beta Transus) The beta transus as provided by Weber Metals shall appear on supplier certifications.

New 2/28/17

HT6: (Weber Metals HT process spec) Weber Metals' process (heat treat) spec or WMPS. Contact the Supplier Quality Group for the latest revision at supplierqualitygroup@webermetals.com

5. MACHINING**New 10/5/2005****Revised 9/06/16**

MACH2: (Manufacturing Plan) For new products or programs the supplier must submit a manufacturing plan, prior to the machining of forgings, for approval by Weber Metals Engineering. The plan must include forging identification controls.

New 5/30/14**Revised 1/19/15**

MACH3: (Source Inspection) After submittal and approval of a manufacturing plan, Weber Metals will include source inspection points into the plan. Those points will be determined after submittal and approval of supplier's manufacturing plan.

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New 10/5/2005**Revised 1/19/15****MACH7:** (Traceability) See Q20 for traceability requirements.**New 8/21/14****Revised 3/6/19****MACH8:** (Expectations of Machine Shop Inspections)

- A.** (New Production) All machine shops are required to perform a First Article Inspection (FAI), in accordance with AS9102, for all machined features on the first piece of the production lot (for each machine center). The balance of the order must be 100% inspected for all machined features. Records of the inspections must be retained, and must be delivered with the shipping documents to Weber Metals. This applies to the following:
- First run of a particular forging or try-out forging number by a machine supplier.
 - Change in process or fixturing by a machine supplier (new process, new fixturing, computer program, or new set-up of a fixture, die or jig on the machine).
- B.** (Subsequent orders) 100% inspection of all machined features is required. Records of the inspections must be delivered to Weber Metals with the returned forgings. Reports may include the overall range of values, or individual piece values at the supplier's discretion. Parts falling out of tolerance range must be segregated and identified as nonconforming. These parts shall be submitted to Weber Metals as described in Q21.
- C.** Critical or Key Characteristics (CC/KC) requires 100% inspection when CC/KC for machine features is specified on a drawing, machine plan, or purchase order. Inspected CC/KC values for each piece must be recorded on an AS9102 form 3 and records of the inspection must be returned to Weber Metals with the returned forgings. No sampling is allowed
- D.** Flight Safety and critical/major rotating/prime reliable parts (Example: Engine components: disk, rotors, hubs) parts require 100% inspection. Each piece must be recorded on the AS9102 form 3 and records of the inspection must be return to Weber Metals with the returned forgings. No sampling is allowed
- E.** (Inspection Reduction) The supplier may utilize a sampling plan and or statistical methods (SPC) on regular features as an alternative to 100% inspection.
- F.** All Sharp Edges created as a result of machining forged surfaces are to be broken with a chamfer or radius .3mm (.012") Max

Data in support of 100% inspection, sampling plan and or SPC are to be made available to Weber Metals and its customers upon request. Application of sampling plans and or SPC methods does not invalidate the need to comply with AS9102 requirements.

1. Sampling Plan method: Contains a sample size to be used and the associated acceptance and rejection criteria.
2. Sampling requirements shall not be construed as permitting defective parts to be sold/delivered to Weber Metals Inc. and or our customers.

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3. The lot shall be rejected if a nonconformance is discovered in the sample and inspection of all pieces in the lot is required for dimensions out-of-tolerance.
4. All lot inspection plans must have first piece and last piece inspection.
5. **The lot must be homogeneous and produced under essentially the same conditions and at the same time. If not, the items shall be segregated and treated as a separate lot.**
6. An acceptable First Article Inspection (FAI) is required before sampling inspection may be applied.
7. Sampling plan shall be suspended and replaced by 100% inspection when a previously produced product is found to be nonconforming.
8. The sampling plan can be initiated after an effective corrective action is demonstrated and approved by Weber Metals Inc., and the next FAI is acceptable. Contact supplierqualitygroup@webermetals.com
9. Sampling Plan of machine characteristics and acceptable quality level: Ref. item 3 above.
 - If the first piece inspection fails, (Verify programming, set-up, fixturing, dimensions, contact Weber Metals for proper resolution).
 - If the mid piece fails, conduct inspection, after the first piece in the sequence that passed the inspection.
 - If the last piece inspection fails, conduct inspection, after the mid piece in the sequence that passed the inspection.
 - submit any non conformance using the deviation form to Weber Metals to VendorNCR@webermetals.com
 - Supplier can inspect more not less of what is stated in the table below:

Regular Machining	A	B	C
Lot Size	First Piece	Mid Piece	Last Piece
1-10	yes	none	yes
1-20	yes	number 10	yes
1-40	yes	number 10, 20	yes
1-60	yes	number 10, 20, 40	yes
1-100	yes	number 10, 40, 60, 80	yes

- G. Stock Machining: The supplier is required to inspect first and last piece. This applies to locating, scalping and radius of stock.
- H. **Weber Metals requires 100% inspection of all close tolerance machined features of +/- .005" or less, regardless of reduced inspection approvals for other features. Inspected values for each piece must be recorded on an AS9102 form 3 and returned to Weber Metals with the returned forgings.**
- I. Visual inspection is required after all manufacturing operations have been completed and added to the dimensional report.
- J. Non-conforming parts shall be segregated, identified as non-conforming, and submitted to Weber Metals as described in Q21.

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New 12/17/19**Revised 10/26/2020****MACH9: PWA370 Quartely Self-Audits**

Suppliers machining and inspecting Pratt & Whitney forgings are required to conduct quarterly witness self-audits of the processes involved from PO review, receiving, traceability information, traveler operations, machine programs and control of changes, inspection operations and review of certification records per PWA 370 specification. These quarterly audits shall be available for Weber Metals or Pratt & Whitney review.

New 10/5/2005**Revised 1/19/15**

Q2: (Mandatory Inspection Points - MIPS) Government inspection is required, prior to shipment, at Seller's facility. Prior to initiating any work on this order, contact Weber Metals' Quality Assurance Department to coordinate the schedule for in-process verification. Evidence of government inspection (DCMA representative signature) shall be shown on the shipping document. Government inspection of goods or services provided hereunder shall be performed at Seller's address shown on this contract or contract change unless a different address is specified.

New 10/5/2005**Revised 3/5/19**

Q4: (Source Inspection) Source inspection is required in process and / or prior to shipment from your facility as deemed necessary by Weber Metals. Upon receipt of a Purchase Order / Delivery Note, which contains this clause, contact Weber Metals' Quality Assurance Department to schedule source inspection activity. A minimum of 24 hours' notice is required for any local source inspection activity. Any non-local or out-of-state source inspections require a one week notice. (Local implies Los Angeles county, Orange county, and the Inland Empire.)

New 10/5/2005**Revised 11/11/16**

Q5: (Raw material test reports and or certifications)

- A.** For each lot or heat of material supplied on this order, the seller shall furnish a certified material test report showing the material description, the material type or designation, alloy, type, grade or condition, the producer's name, the lot number, heat number, and the material specification(s) including revision number.
- B.** When the material specification requires quantitative limits for chemical, mechanical or physical properties, the test report will contain the actual test and inspection values obtained.
- C.** For titanium, the charge make-up (scrap or sponge – for example, 100% scrap, or 80% sponge / 20% scrap) and source of sponge shall be identified.
- D.** The providers of extruded Aluminum material, the source of the ingot/billet material, shall be identified on the test report. Weber shall approve the ingot/billet suppliers prior to the extruded Aluminum supplier acquiring the ingot/billet material.

New 10/5/2005**Revised 1/19/15**

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Q6: (Heat Treat Certification) With each shipment of forgings the seller shall furnish one copy of the actual time/temperature certifications for each heat-treated lot. Certifications must be clear and legible. Minimum heat treat data to be provided, but not limited to:

- 1) Time Forgings were Loaded
- 2) Soak Start Time
- 3) Soak End Time
- 4) Total Quench Time
- 5) Quench Medium
- 6) Weight of Load
- 7) Heating Medium
- 8) Load Thermocouple Charts (When Requested)
- 9) Quench Bath Temperature Before and After
- 10) Quench Delay
- 11) Racking Photo**
- 12) Forging Serial numbers
- 13) Forging Number
- 14) Temper Received
- 15) Temper Returned
- 16) Packaging (Shipped on Ice or Fresh Quench)
- 17) Signed
- 18) Program
- 19) Program Approval

New 10/30/14**Revised 1/19/15**

Q7: (First Article) The supplier is required to comply with AS9102 (current revision) requirements.

New 10/5/2005**Revised 3/5/19**

Q8: (Certificate of Conformance) Seller shall provide complete certification attesting to accurate completion of the procured materials or service in accordance with the description shown on the purchase order and Delivery Note. The Certificate of Conformance shall include, but is not limited to, the Forging number, Job number, Forging name, Customer specific info (if available): Forging note, Drawing number, Program, Program customer, Alloy/Temper, Additional Documents, Applicable Specifications, and Flight Safety or Critical Program Planning, FSP/CC/Fixed/Frozen statements (If applicable), serialized Identification (if applicable), and the specific information pertaining to the applicable subcontract operation. Seller shall record the end item part number, drawing level and engineering changes to which the delivered item has been manufactured to on the packing slip. Certifications must be clear and legible.

New 10/5/2005**Revised 1/19/15**

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Q9: (Nonconforming Material Control System) The supplier must have a system to identify and control nonconforming material in accordance with AS9100. The supplier is not allowed to use a disposition of "Use-As-Is". The supplier's disposition authority of nonconformances is limited to 'rework to specification' without affecting fit, form or function. See Q21 for notification process.

New 10/5/2005**Revised 3/6/19****Q10:** (Quality Records)

- A.** Work performed for Weber Metals, Inc., as well as associated records shall be subjected to inspection, surveillance, test or audit by Weber Metals, Inc., its customers, and/or regulatory agencies at reasonable times.
- B.** Upon request by Weber Metals or its customers, records shall be made available within 2 business days.
- C.** Suppliers are required to retain records for a period of 10 years (commercial program) for non FSP/Critical Rotating and 50 years for FSP/Critical Rotating, or per prime customer/program requirements whichever is later, from the date product was shipped or services were performed.
 - a. Boeing FSP 50 years or the life of the program.
 - b. Sikorsky FSP 40 years or the life of the program
 - c. Pratt FSP/Critical Rotating 40 years or the life of the program.
- D.** Electronic imaging/microfilming of records in lieu of storing actual inspection records is permissible. All electronic records must be controlled, retained, and retrievable per the same requirements identified for hard copy records. For electronic records that are transferred from computer files, the storage media must be capable of maintaining the data integrity for the full retention period.
- E.** Examples of Quality Records to be retained are, but not limited to:
 - First article inspection reports
 - In process / final inspection & test records
 - Training records
 - Manufacturing / fabrication records (e.g., planning sheets, routers, etc.)
 - Nonconforming material disposition
 - Procurement documents (supplier placed orders)
 - Process control records (used as acceptance criteria)
 - Technique sheets and related acceptance reports
 - Receiving inspection Records (e.g., test reports and material certifications, etc.)

New 10/5/2005**Revised 3/5/19**

Q11: (Right of Entry) Seller shall allow Weber Metals Inc., its customers, and/or regulatory agencies the right of entry to review or verify work performed on Weber metals purchase orders / Delivery Note.

New 10/5/2005**Revised 1/25/17**

Q13: (Special Processors/Nadcap) Approval is required for all special processes (heat treaters, NDT, Chem, Pre-Etch PT and destructive testing labs). Any subcontracting or work off-loading by special processors must both be approved by Weber Metals and be a Nadcap certified source.

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Nadcap M&I (Measurement and Inspection) It is recommended that suppliers recognize the Nadcap M&I and comply to the Nadcap M&I audit checklist criteria. This applies to suppliers providing final dimensional inspection using CMM and or portable inspection equipment. Ref. Nadcap PRI portal.

New 10/5/2005

Revised 1/27/17

Q14: (Quality System) Supplier shall have a Quality System that is certified to AS9100 or ISO 9001 unless alternate approvals are granted by Weber Metals. Refer to Weber Metals ‘Supplier Evaluation Form’ QP-8.4 F001 as a guide for quality requirements. Contact supplierqualitygroup@webermetals.com for the form. The evaluation is done for new suppliers and then again after for re-certification of suppliers at specified time intervals.

Metal distributors shall be certified to AS9100 or AS9120. Special Process and calibration suppliers shall meet the required certifications for their process.

New 10/5/2005

Revised 3/5/19

Q15: (Revisions) For any listed specification, supplier is to use the revision noted on the purchase order/delivery note. If there is any conflict, contact the Supplier Quality Group and the Purchasing team.

New 10/5/2005

Revised 9/06/16

Q16: (Approval Status) Prior to performing any work, the supplier shall verify if approvals are required from the prime contractor. The Supplier shall notify Weber Metals immediately if supplier does not hold the required approvals and do not perform any work. The supplier shall verify the Prime portals for proper approvals including specific references to processing specifications. (e.g., Boeing D1-4426, Sikorsky SS7777, Lockheed Martin QCS-001, etc.).

New 5/30/14

Revised 3/6/19

Q17: (Notification) All suppliers are required to inform Weber Metals, within the indicated timeframe, if there is:

A change in management and/or quality management process <ul style="list-style-type: none"> • Ownership/Senior Management/NDT L3/QA/Metallurgical mgr. • Major audit findings related to ISO9001/AS9100/Nadcap/other 3rd party registrations • Poor Quality and Delivery performance • QMS- processes or procedures that are known to affect or could potentially affect conformity to product. • Counterfeit material/parts • Bankruptcy, Fire, floods, Environmental restrictions. 	48 hours
A change in manufacturing location	48 hours
Suspected nonconforming product that has been shipped to Weber Metals	24 hours
A process change; The change must be submitted for approval before instituting the change (That could affect form, fit or function of the forgings).	-----

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Any change in their approval status from Aerospace prime contractors, NADCAP, or to their certification status for ISO-9001, AS-9100, A2LA, etc. <ul style="list-style-type: none"> Changes in registration/accreditation (suspensions, withdrawn, scope of accreditation) 	48 hours
The supplier will notify Weber Metals, Inc. within 48 hours or 2 business days of any changes affecting the integrity of the digital data system to the documented digital data plan, major changes to CAD/CAM/CAI/CNC software or measurement equipment.	48 hours

New 5/30/14

Revised 1/19/15

Q18: (Counterfeit Materials Prevention Program) In order to preclude the introduction of counterfeit materials, all suppliers are required to implement and maintain a Counterfeit Materials Prevention Program. Refer to AS 6174 for guidelines on counterfeit materials prevention.

- A. Unauthorized Material Substitution (General) - Unauthorized material substitutions are not permitted on Buyer's Goods. Unauthorized material substitution includes any deviation from the engineering definition of a raw material. Engineering definition includes Buyer design drawing and applicable specifications, product specification, form, size, shape, chemistry, melt method, origin, temper/condition, product testing or surface finish. Alternate materials specified in the engineering definition (and often described as approved material substitutions therein) do not constitute unauthorized material substitution.
- B. Temper or Condition Conversion - Unless specifically authorized by the engineering definition, conversion of a raw material (i.e. heat treat to change the temper or condition of the material) constitutes material substitution of the condition provided by the manufacturer.
- C. Specification Supersession - For government specifications and standards canceled after June 1994, Seller and subcontractors at all tiers shall use the last active revision of the canceled specification and standard until an acceptable replacement is included in the requirements of this Contract. Contact the Buyer's Authorized Procurement Representative in the event of any inconsistency in applicable specification or standard.
- D. Reports (Full Pedigree from melt to final product) - Raw material certifications shall show clear traceability to the manufacturer(s) of the raw material including ingot source, all thermo-mechanical processing (i.e. forging, rolling, drawing, etc.), heat treatment, chemical processing and inspections as required by applicable raw material specification requirements.
- E. Chain of Custody (Disguising intermediate ownership) – Suppliers shall not disguise the pedigree of material or chain of ownership by removal of a previous supplier's name, nomenclature or identification.
- F. The substance of this clause shall be flowed in all subcontracts at every tier.

New 5/30/14

Revised 3/5/19

Q19: (Eye Exams) All suppliers that perform calibration, in-process inspection, NDT, or inspection services must have on file evidence that personnel have received an acceptable annual eye exam by a qualified medical professional (Ref. Snellen 14/18, (20/25), Jaeger 2 at not less than 12 inches, NAS 410). A review of the results

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shall be conducted by the supplier as part of the procurement process. Per ISO and AS9100 section 8.4. Any restrictions shall be resolved with their employees.

New 5/30/14**Revised 3/5/19**

Q20: (Traceability) The supplier is required to maintain traceability of all products in their possession and through their production processes. Traceability is required between the Purchase order/Delivery Note, job number, serial numbers, part number, piece count, etc.

Machine shops must have a system in place to maintain and transfer all serial numbers and traceability markings.

Identification shall be performed using those same methods and materials identified within the applicable part mark specifications referenced on the associated Models/prints/drawings.

- ✓ Verify marking requirements.
- ✓ No-stress steel stamps shall be used to mark the forgings
- ✓ Vibro engrave shall meet PO and or drawing requirements
- ✓ Depth requirements shall be verified prior to marking

Contact supplierqualitygroup@webermetals.com if any discrepancy is found. All identifications are to be legible.

New 12/17/14**Revised 3/5/19**

Q21: (Nonconforming Material Submittals) When a supplier has not produced a product or service in conformance with contractual requirements, the supplier is required to submit the nonconformance for concession to Weber Metals. The submittal will be reviewed and dispositioned by Weber Metals' Material Review Board. The supplier is not allowed to ship to or alter the product until the supplier receives a disposition from the Weber Metals' Review Board. Supplier should use of supplier deviation form unless they have a their own form.

The supplier is to contact Weber Metals by using the email address vendorNCR@Webermetals.com with the following information:

Information needed:

- 1) Forging #, job #, Purchase order/Delivery note information, Company name, forging #, job #, PO/Delivery Note #, brief description of nonconformance, direct contact information of person managing the NC (Phone # and email address).

Note:

The PO the job number is the "assignment"

The Delivery Note the job number is the "production order"

- 2) Attachments (photos, sketch of problem) to be included as necessary (highly recommended).

Raw Material & Tooling Suppliers

The supplier is to contact Weber Metals by using the email address vendorNCR@Webermetals.com and or with the following information:

- 1) Email subject line: Purchase Order #, Company Name,

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- 2) Body of email: Company name, Purchase Order number, Material Code / Identification, Vendor job/lot number, brief description of nonconformance, direct contact information of person managing the NC (Phone # and email address).
- 3) Attachments (photos, sketch of problem) to be included as necessary (highly recommended).

Weber can provide the supplier deviation form **QWI 8.7-3 F001 Supplier Deviation Submittal Form & QWI 8.7-3 F002 Supplier Deviation Submitted Form : Raw Material/Tooling Services**

for raw material (Aluminum & Titanium) suppliers or supplier can submit their own form. See the sample attachments at the end of the document.

Non-conforming product must be clearly tagged and identified when returned to Weber Metals. The supplier is not authorized to ship the product to Weber Metals unless explicit written direction has been provided by Weber Metals.

New 5/30/14**Revised 9/9/20**

Q23: (Subcontracting/Work transfer) All suppliers must have written approval from Weber Metals Metallurgy and Quality Department before subcontracting, transferring, or off-loading any work received from Weber Metals. Relevant quality clauses and documents shall be flowed down to any subcontractor.

New 5/30/14**Revised 3/5/19**

Q24: (FOD) Supplier shall maintain an FOD (Foreign Object Debris / Damage) prevention program. Refer to NAS 412 and AS9146 for guidance.

Specific attention should be given, where applicable, to items such as:

- Housekeeping and cleanliness
- Food and beverage control
- Tool and small part accountability
- Loose objects
- Material handling and parts protection
- External cleaning following evidence of external contamination

The supplier shall ensure that Foreign Objects and subsequent Foreign Object Damage (FOD) are eliminated from all parts prior to shipment. All suppliers must maintain a FOD free environment during machining, manufacturing, assembly, maintenance, inspection, storage, packaging and shipping.

- Potential FOD includes but is not limited to burrs, chips, dirt, corrosion and contamination resulting from manufacturing, assembly, maintenance, processing, cleaning, storage and subsequent packaging of parts
- Suppliers must ensure all passageways – are clear of chips, core material, dirt, breakout of cast walls, etc.
- Suppliers must ensure all parts are clear and FOD free prior to shipment.

Supplier is to verify cutting tools when broken that any material is not embedded in our forgings, this includes Titanium forgings. Forgings are to be returned free of chips and FOD.

Supplier shall ensure that the responsibility for the FOD prevention program is clearly defined and appropriate personnel have received FOD awareness training.

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Suppliers are responsible for flow down of these requirements to their sub-tier suppliers to ensure FOD free products. Weber Metals can provide a training power point presentation, contact the Supplier Quality Group.

New 5/30/14

Revised 1/26/17

Q25: (Conformance) The supplier is responsible to produce conforming parts, services, or raw materials. The material is to be manufactured and inspected in accordance with all applicable drawing revisions and/or specifications/standards, including functional testing requirements.

New 5/30/14

Q26: (Calibration) Calibrations must be performed, at a minimum, in accordance with ISO 10012, ISO 17025 or ANSI/NCSS Z540.3. All measurement and test standards must be NIST traceable. The seller shall provide qualified personnel and equipment to conduct calibration.

New 5/30/14

Revised 1/26/2017

Q27: (Commingling) The supplier is not allowed to commingle forging parts/tooling from different jobs when returning forgings/tooling to Weber Metals. Each job must be separated, labeled, & identified clearly.

New 8/21/14

Revised 1/26/2017

Q28: (On-Site First Article Review) The supplier could be required to successfully pass an on-site verification of its First Article part as well as an audit of applicable production part process/systems including processes and systems designed to ensure serialization and traceability for critical parts as applicable.

New 8/21/14

Revised 3/5/19

Q29: (Flight Safety or Critical Parts (Product Safety)) is applicable when the purchase order/Delivery Note contains requirements for Flight Safety or critical parts. Prior to commencement of work, Seller will assure that its Flight Safety Program Plan (which it shall include re-occurring training of personnel involved with the FSP) and Production Planning Packages, as approved by the Prime Customer and or Weber Metals, are in accordance with the requirements of the purchase order. The Seller is not allowed to deviate from the approved Production Plan; including changes to sub-contractors who produce key characteristics. Approval of the Supplier's Flight Safety Program and Production Plan does not waive the Supplier's obligation to supply parts that meet drawing or specification requirements. Supplier must certify that all Flight Safety Parts conform to its approved Production Plan Packages. The Supplier shall provide and maintain a system of traceability from raw material to purchase order end item. Contact Weber Metals for a training presentation.

Note: Raw material (Casting, Billet, Ingot, outside conversion) suppliers:

the FSP is for awareness only (this applies when the raw material PO does not specify that it would be used for a specific FSP program). Traceability and changes to frozen plan requirements are applicable.

Note: Fixed Operations work is to be conducted per fixed practices such as frozen HT plans, Machine plans, or NDT inspection plans.

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New 1/19/15

Q31: (Key Characteristics) When Key Characteristics are specified on the drawing or purchase contract, the Seller shall utilize 100% inspection for these characteristics or employ control per SAE AS9103 (pre approval is required from Weber Metals) – Variation Management of Key Characteristics. Data in support of either 100% inspection or control per AS9103 are to be made available to Weber Metals and its customers upon request. Application of AS9103 does not invalidate the need to establish and document compliance with all requirements for First Article Inspection per AS9102.

New 1/19/15**Revised 9/06/16**

Q32: (Corrective Action) Supplier shall provide Weber Metals with documented Root Cause and Corrective Action (RCCA) for any/all supplier corrective action requests initiated by Weber Metals Supplier Quality Group and or procurement representatives. Supplier may be required to provide RCCA if the supplier delivers non-conforming material, does not meet On Time Delivery KPI ($\geq 85\%$), does not meet Quality KPI ($\geq 80\%$) or any other issue deemed suitable by Quality Management. Supplier shall respond using the appropriate Weber Metals Supplier Corrective Action Response Form (QP8.4 F008) (see attachment at the end of document) as supplied by Weber Metals and/or any applicable Weber Metals Customer response forms. Failure to provide timely and comprehensive corrective/preventive action responses in a timely manner may result in negative impact to the supplier's Weber Metals Supplier Performance Indicator rating.

New 5/30/14**Revised 3/5/19**

Q33: (Supplier Quality System Requirements) The Seller is responsible for implementing the Quality Assurance Requirements defined by each prime/customer in the performance of this purchase agreement. The QA clauses cover the topics listed in the QMS defined by our prime/customer manufactures (See a list of several prime/customer QMS specifications). By complying with our QA clauses, the supplier also complies with the QMS specs listed below.

The supplier shall be aware and is also responsible for implementing the requirements of AS9100 (latest revision).

Awareness- Suppliers are required to assure their entire workforce is aware of an individual's contribution to the product or service conformity. This extends to product safety and ethical behavior.

(Code of Ethics) Supplier shall comply with the highest standards of Ethics and Business conduct as stated in our Code of Ethics program. Supplier shall also comply and implement our Quality Cardinal Rules to everyone involved with the processing/manufacturing of our forgings. Contact Weber Metals for an Ethics and Quality Cardinal Rules training presentations.

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Prime Airframe Manufacturer	Supplier Quality Assurance Specification Examples: Supplier is to verify the current naming and rev level.
Boeing Commercial Airplanes	D6-82479
United Technologies Corporation (UTC) (includes Pratt & Whitney, and Hamilton Sundstrand)	ASQR-01 UTC Quality Cardinal Rules UTC Code of Ethics
Sikorsky	SSQR-01 Main text
Collins -Rockwell (UTAS Formerly Goodrich LG/WB)	ASQR-01
Embraer	Embraer Quality Requirements for Suppliers
GKN	GKN Supplier Quality Assurance Manual
Honeywell	Honeywell SPOC Manual
Gulfstream	SQAR-001
Lockheed	Appendix QX
Bell Helicopter	SQRM-001

New 7/14/16

Q34: (Flight Safety Program Awareness): Suppliers are advised that their product may be used in forgings with Flight Safety applications. The Supplier shall provide and maintain a system of product traceability to ensure FSP requirements can be met.

New 7/14/16

Revised 3/5/19

Q35: (Design Authority Data) Authority data is identified in the Forging and Specifications sections in the Purchase contract or Delivery Note. Work is to be certified only to this authority. Dimensional or process deviations may only be certified if specifically allowed by an additional document referenced in those sections of the Delivery Note document.

Processing or certification to informal deviations, verbal, or e-mail instructions is prohibited.

New 1/23/17

Q36: (Corrections) Corrections to work instructions or documents shall be recorded, dated, and traceable to the person making the change (e.g. signature, stamp, initials) in ink or other permanent marking method with the original data being legible and retrievable after the change. This includes corrections made to in-process paperwork & inspection data.

New 1/23/17

Q37: (Language) Unless otherwise specified, all written communication, documents, and records shall be in English.

New 1/23/17

Q38: (Measuring & Monitoring Equipment)

- A.** Measuring equipment should have resolution of 10:1 for the feature being measured, i.e. a tolerance of 0.001" should be measured with an instrument with resolution of 0.0001". Ratios as low as 4:1 may be acceptable, but require documented approval from Weber Metals Supplier Quality.

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- B.** Measuring equipment shall be capable of measuring the tolerance features.
- C.** A list of calibrated tools shall be maintained and shall list the accuracy/discrimination needed (Gage R&R is the best method) to help the inspector/operator select the correct measuring instrument based on the tolerance range.
- D.** Measuring equipment used for product acceptance or process control impacting product quality (such as furnace thermocouples) shall be calibrated per the requirements of Weber Metals Quality Clause Q26.
- E.** Measuring Equipment includes, but is not limited to:
 - Dimensional inspection tools, including hand tools.
 - Temperature measuring / monitoring equipment
 - Mechanical testing equipment

New 2/16/17**Q39: (Informal request/ Verbal order) Processing or certification to informal request, verbal orders, informal purchase request, or e-mail instructions is prohibited.****8. SHIPPING & MATERIAL HANDLING/PRESERVATIONS/STORAGE****New 10/5/2005****Revised 3/5/19****SMH1:** (Preservation) All Weber Metals' product must be protected from damage and environmental degradation. See PO/Delivery Note and purchase order notes for required packaging and preservation requirements.**New 9/06/16****SMH3:** (Oil preservation- Extruded Aluminum Stock) All Weber Metals extruded stock must be oil protected. California suppliers use oil compliant to rule 1144 per SCAQMD. (Use Protecsoil 427 or equivalent). Out of State suppliers use oil compliant to your local regulations and MIL-PRF-16173 Grade3 (latest revision)-Use LPS3, Protecsoil 512, or equivalent. Oil application methods: Spray, dip or brush.**New 9/06/16****SMH4:** (Oil preservation- Cast Aluminum Ingot Stock) – Diameters 11.2 and smaller must be oil protected. California suppliers use oil compliant to rule 1144 per SCAQMD. (Use Protecsoil 427 or equivalent). Out of State suppliers use oil compliant to your local regulations and MIL-PRF-16173 Grade 3 latest revision (Use LPS3, Protecsoil 512, or equivalent). Oil application methods: Spray, dip or brush.**New 6/7/2016****SMH5:** (Oil preservation of WIP Forgings) – Weber Metals products must be oil protected. California suppliers use oil compliant to rule 1144 per SCAQMD. (Use Protecsoil 427 or equivalent). Out of State suppliers use oil compliant to your local regulations and MIL-PRF-16173 Grade 3 latest revision (Use LPS3, Protecsoil 512, or equivalent). Oil application methods: Spray, dip or brush. See PO/Delivery Note and purchase order notes for required packaging and preservation requirements.

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9. TESTING**New 10/5/2005****Revised 3/13/18**

TEST3: (Test Records) Identify all paperwork and metallography, including photographs, with forging number, job number (PO job number is now the “assignment” in SAP and “production order” in Delivery note) , PO/ Delivery Note number, serial numbers, drawing revisions, and all applicable specifications. For titanium include heat number and heat treat lot number. Records must be clear and legible.

New 5/30/14

TEST4: (Test Remnants) Aluminum Stress Corrosion Cracking remnants to be maintained by the vendor for a minimum of six months and should be available for review by WM Metallurgy, upon request.

New 5/30/14

TEST5: (Remnant Identification) All test remnants shall be indelibly marked with lab number, job number, and orientation / location. All remnants, macro slices, broken bars, mounts, and chemical analysis samples shall be returned to Weber Metals within 48 hours of testing completion.

New 5/30/14

TEST6: (Hydrogen Test) For titanium testing, the hydrogen shall be tested first; all other tests to be conducted after acceptable hydrogen analysis.

New 5/30/14

TEST7: (Testing Sequence) If both tensile and fracture toughness testing is required, perform the tensile testing prior to fracture toughness testing. If only the toughness test has been subcontracted, the applicable yield strength will be supplied by Weber Metals Test Laboratory personnel.

New 5/30/14

TEST8: (Testing Failure) If a failure occurs in any test on a given Weber Metals Job, immediately discontinue all testing from the same Job and contact Weber Metals Product Metallurgy for further instructions.

10. RAW MATERIAL**New 5/30/14**

RM1: (Material Certifications) Certifications for all material shall be sent material@webermetals.com for all material.

New 5/30/14**Revises 1/19/15**

RM2: (Material Length) Weber Metals requires the shipping length of material to be listed on all mill certificate paperwork.

New 5/30/14**Revised 3/16/18**

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RM3: (Raw Material Specification) Weber Metals' Material Specification (WMMS) applies to this order. Contact Weber Metals' Purchasing buyer Amy Koga at amykoga@webermetals.com for latest revision of these documents.

11. MISCELLANEOUS**New 3/16/2018**

MISC4: (Environmental and Safety rules) Weber Metals Inc. and our customer require all suppliers to follow environmental and safety rules and regulations.

New 3/16/2018

MISC5: (Material contamination and prohibited materials/chemicals) Weber metals Inc. and our customer require from our raw material suppliers that the titanium and other alloys are to be free of any radiation, and mercury. Supplier shall comply with REACH requirements.

New 6/8/2018

MISC6: (Acceptance Authority Media –AAM) The supplier shall comply with the AS9100 requirements and 14CFR part 21.1 regarding the application of the AAM and ensure that the use of AAM is clearly defined within its QMS. The supplier shall maintain compliance to the AAM by assessing its process as part of its internal audit process. The areas of focus shall include but not limited to:

- Application errors (i.e. Omission, typos, legibility)
- Misrepresentation (i.e. Uncertified personnel, falsification of documentation, work not performed as planned).
- Training deficiencies (i.e Ethics, code of conduct, culture awareness, proper use of electronic or stamp buy-off).
- 14CFR part 21.1- falsification of reports or records, fraudulent false statements, false or altered certifications,
- Stamp Control/electronic buyoff (password/signatures/initials) Log with re-occurring verification

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The following tables summarize the applicable clauses by process or service being procured that can be listed on the purchase order or Delivery Note. Please reference the quick guide of Quality Clauses by supplier type at the end of the document.

CLAUSE APPLICATION GUIDE

Summary of Application Reference Tables	
<u>Supplier Type</u>	<u>Reference Table #</u>
Chem Mill	Table 1
Coating	Table 2
Die Sinking	Table 3
Forge-Include Conversion/Tooling	Table 4
Heat Treat	Table 5
Dimensional Inspection Service	Table 6
Machining	Table 7
Macro Etch	Table 8
Non-Destructive Testing (NDT)	Table 9
Raw Material- Titanium	Table 10
Sandblast	Table 11
Testing	Table 12
Raw Material- Aluminum Extruded Stock	Table 13
Raw Material- Cast Aluminum Ingot	Table 14
Calibration Services	Table 15
NDT Level 3 Services	Table 16

Table 1: Chem Mill

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data.
HT3	Chemical Milling	
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	As applicable
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	As Necessary
Q17	Notification	
Q18	Counterfeit Materials	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program – Awareness	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 2: Coating

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data.
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	
Q17	Notification	
Q18	Counterfeit Materials	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q31	Key Characteristics	As applicable, per PO
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program – Awareness	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

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Table 3: Die Sinking

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
DS1	Die Impression Plaster Cast	
DS2	Part Identification	
ENG1	Electronic Data and Secure Transmission	
ENG2	Digital Data Quality Plan	
ENG3	Software Control	
MACH3	Source Inspection	As Necessary
Q7	1 st Article Inspection AS9102	As applicable
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q15	Revisions	
Q17	Notification	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required

Table 4: Forge-Includes: Conversion/Tooling

Clause #	Clauses	Conditional Items
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data.
Q2	Mandatory Inspection Point- MIPS	As Necessary
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	As Necessary
Q17	Notification	
Q18	Counterfeit Materials	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q28	On-Site First Article Review	As Necessary
Q31	Key Characteristics	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Awareness	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 5: Heat Treat

Clause #	Clauses	Conditional Items
STAN6	Prohibited Materials	
HT4	Heat Treatment Guide Lines	
HT5	Beta Transus	
HT6	Weber Metals HT process specification	Reference WMPS
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data
ENG3	Software Control	
Q2	Mandatory Inspection Point- MIPS	As Necessary
Q4	Source Inspection	As Necessary
Q6	Heat Treat Certification	
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	
Q17	Notification	
Q18	Counterfeit Materials	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q29	Flight Safety / Critical Parts	
Q31	Key Characteristics	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 6: Dimensional Inspection Service

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data
ENG2	Digital Data Quality Plan	
ENG3	Software Control	
Q4	Source Inspection	As Necessary
Q7	1 st Article Inspection AS9102	
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	As applicable
Q11	Right of Entry	
Q13	Special Processors and Nadcap for M&I	Recommended
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	As applicable
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q31	Key Characteristics	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program - Awareness	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

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Table 7: Machining

Clause #	Clauses	Conditional Items
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	
ENG2	Digital Data Quality Plan	
ENG3	Software Control	
MACH2	Manufacturing Plan	As applicable, per PO
MACH3	Source Inspection	As necessary
MACH7	Traceability, ID Transfer	
MACH8	Inspection Expectations	
MACH9	Quarterly self-audits per PWA370) Pratt forgings	Only if machining Pratt & W.
Q2	Mandatory Inspection Point - MIPS	As applicable
Q4	Source Inspection	As applicable
Q7	1 st Article Inspection AS9102	
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	As applicable
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q28	On-Site First Article Review	As Necessary
Q29	Flight Safety / Critical Parts	Per PO
Q31	Key Characteristics	As applicable, per PO
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
SMH5	Oil preservation of WIP Forgings	As applicable
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 8: Macro Etch

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q29	Flight Safety / Critical Parts	
Q31	Key Characteristics	As applicable
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

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Table 9: NDT

Clause #	Clauses	Conditional Items
STAN6	Prohibited Materials	
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data
Q2	Mandatory Inspection Point - MIPS	As Necessary
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	
Q29	Flight Safety / Critical Parts	
Q31	Key Characteristics	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
SMH1	Preservation	
SMH5	Oil preservation of WIP Forgings	As applicable
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 10: Raw Material- Titanium

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
Q5	Raw Material Test Reports	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	As applicable, Billet
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	As applicable
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program Awareness	
Q35	Design authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
RM1	Material Certification	
RM2	Material Length	
RM3	Material Specification	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC5	Material contamination and Prohibited material/chemicals	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 11: Sandblast

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
Q4	Source Inspection	As Necessary
Q8	Certificate of Conformance	As applicable
Q9	Nonconforming Material Control	
Q10	Quality Records	As Necessary
Q11	Right of Entry	
Q14	Quality System	Ref. WMPS-003 sandblast
Q15	Revisions	
Q16	Approval Status	As Necessary
Q17	Notification	
Q18	Counterfeit Materials	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q27	Commingling	
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program Awareness	
Q35	Design authority Data	
Q36	Corrections	
Q37	Language	
Q39	Informal request/ Verbal order	
SMH1	Preservation	Per PO requirements
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

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Table 12: Testing

Clause #	Clauses	Conditional Items
STAN6	Prohibited Materials	As Applicable
ENG1	Electronic Data and Secure Transmission	Includes ITAR controlled data
ENG3	Software Control	
Q2	Mandatory Inspection Point - MIPS	As applicable, per PO requirements
Q8	Certificate of Conformance	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q13	Special Processors	
Q14	Quality System	
Q15	Revisions	
Q16	Approval Status	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q20	Traceability, General	
Q21	Nonconforming Material Submittals	
Q23	Subcontracting	
Q25	Conformance	
Q26	Calibration	
Q27	Commingling	As applicable
Q29	Flight Safety / Critical Parts	
Q31	Key Characteristics	Per PO Requirements
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
TEST3	Test Records	
TEST4	Test Remnants	
TEST5	Remnant Identification	
TEST6	Hydrogen Test	
TEST7	Testing Sequence	
TEST8	Testing Failures	
SMH1	Preservation	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 13: Raw Material- Aluminum Extruded Stock

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
Q5	Raw Material Test Reports	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	As applicable
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program Awareness	
Q35	Design authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
RM1	Material Certification	
RM2	Material Length	
RM3	Material Specification	
SMH1	Preservation	
SMH3	Oil preservation- Extruded Aluminum Stock	
MISC4	Environmental and Safety Rules	Required
MISC5	Material contamination and Prohibited material/chemicals	Required
MISC6	Acceptance Authority Media (AAM)	Required

Table 14: Raw Material- Cast Aluminum Ingot

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
STAN6	Prohibited Materials	
Q5	Raw Material Test Reports	
Q9	Nonconforming Material Control	
Q10	Quality Records	
Q11	Right of Entry	
Q14	Quality System	
Q17	Notification	
Q18	Counterfeit Materials	
Q19	Eye Exams	
Q23	Subcontracting	
Q24	FOD	
Q25	Conformance	
Q26	Calibration	As applicable
Q32	Corrective Action	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program Awareness	
Q35	Design authority Data	
Q36	Corrections	
Q37	Language	
Q38	Measuring & Monitoring Equipment	As applicable
Q39	Informal request/ Verbal order	
RM1	Material Certification	
RM2	Material Length	
RM3	Material Specification	
SMH1	Preservation	
SMH4	Oil preservation- Cast Aluminum Ingot Stock	As applicable
MISC4	Environmental and Safety Rules	Required
MISC5	Material contamination and Prohibited material/chemicals	Required
MISC6	Acceptance Authority Media (AAM)	Required

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Table 15: Calibration Services

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
Q8	Certificate of Conformance	
Q10	Quality Records	
Q14	Quality System	As applicable
Q15	Revisions	
Q17	Notification	
Q19	Eye Exams	
Q26	Calibration	
Q33	QMS/Awareness compliance and Code of Ethics	
Q36	Corrections	
Q37	Language	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required


Table 16: NDT Level 3 Services

<u>Clause #</u>	<u>Clauses</u>	<u>Conditional Items</u>
ENG1	Receipt of Electronic Data and Security data	Include ITAR data
Q14	Quality System	As applicable
Q16	Approval Status	ASNT certification required/Examinations
Q17	Notification	
Q19	Eye Exams	
Q33	QMS/Awareness compliance and Code of Ethics	
Q34	Flight Safety Program Awareness	
Q35	Design Authority Data	
Q36	Corrections	
Q37	Language	
MISC4	Environmental and Safety Rules	Required
MISC6	Acceptance Authority Media (AAM)	Required

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SUPPLIER REVIEW FROM QP 8.4-F006

Weber Metals QA Documents & Specifications - Supplier Review Form



WEBER METALS
An Otto Fuchs Company

Date Document Transmitted to Supplier: _____
 Supplier Review Due Date: _____

Specification Title & Revision Date: _____ Review Table No.: (Select an option) ▼
 Supplier Name: _____ Transmitted By: _____

Supplier Reviewers:

Specification Reviewed By:

Reviewer #1:

Job Title:

Date Completed:

If Multiple reviewers required:

Reviewer #2:

Job Title:

Date Completed:

Reviewer #3:

Job Title:

Date Completed:

Weber Metals Use

Specification Category:

Spec/Doc Type: (Select an option) ▼

Vendor Type: (Select an option) ▼

Required Point of Implementation:

For future orders For all orders on books already started

For all orders on books not started

Supplier Disposition: Indicate production cut in for new revision below. Use PO # or Heat # as appropriate.

Ok to implement

Ok with noted exceptions below

Supplier Summary: See additional attachments:

Supplier has 30 days from receipt to review and comment. Lack of response constitutes acceptance as-is.

Supplier Name: Date:

Supplier QA Manager Name or Technical Authority Signature (electronic signature is acceptable): _____

Weber Comments for Exceptions:

Weber Disposition of Exceptions:

Accepted:

Rejected:

Exceptions Reviewed By:

Date:

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QWI 8.7-3 F001



Weber Metals, Inc. 16706 Garfield Avenue, Paramount, CA 90723 PH 562.602.0260

Quality Work Instruction	DOCUMENT NUMBER	REVISION DATE
	QWI 8.7-3 F001	12/17/2019
	Supplier Deviation Submittal Form:	Page 1 of 1

Supplier Entered Information		
Supplier:	Material #:	Total Amount (pcs, lbs., etc.)
PO Number:	Production Order:	Discrepant Amount (pcs, lbs., etc.)
Prepared By:	Title:	Date:
Phone:	Email:	

Material Condition & Disposition

(Supplier to include additional photos, sketches, etc. with this form as needed to describe the issue)					
Item#	Quantity	Serial # (If applicable)	Requirement (Should Be)	Actual Condition (As Found)	Weber Metals Disposition
					Weber Disposition ▾
					Weber Disposition ▾
					Weber Disposition ▾
					Weber Disposition ▾
					Weber Disposition ▾
					Weber Disposition ▾
					Weber Disposition ▾

Supplier Comments

Weber Metals Entered Information			
SDF Number:			Date:
Weber Metals disposition by:		Date:	
Weber Metals disposition by:		Date:	

Special Instructions (filled in by Weber Metals):

If accepted by Weber Metals, supplier must reference deviation approval date on their certification and attached this approved document to the certification once issued to Weber Metals Inc.

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QWI 8.7-3 F002

Weber Metals, Inc. 16706 Garfield Avenue, Paramount, CA 90723 PH 562.602.0260

Quality Work Instruction	DOCUMENT NUMBER QWI 8.7-3 F002	REVISION DATE 7/6/2018
Supplier Deviation Submitted Form: Raw Material/Tooling Services		Page 1 of 1

Supplier Entered Information			
Supplier	Material Code	Total Amount (pcs, lbs, etc.)	
Purchase Order		Discrepant Amount (pcs, lbs, etc.)	
Prepared By	Title	Date	
Phone			
Email			

Material Condition & Disposition

(Supplier to include additional photos, sketches, etc. with this form as needed to describe the issue.)

Heat Number	Requirement 'Should Be'	Actual Condition 'As Found'	Weber Metals Disposition
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>
			Weber Disposition <input type="checkbox"/>

Supplier Comments

Weber Metals Entered Information

SDF number:		
Weber Metals acknowledgement:		Date:
Weber Metals disposition by:		Date:

Special Instructions (filled in by Weber Metals):

If accepted by Weber Metals, supplier must reference deviation approval date on their certification and attach this approved document to the certification once issued to Weber Metals Inc.

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Quick Reference of Quality Clauses by Supplier Type

Clause #	Clauses	Table 1 Chem mill	Table 2 Coating	Table 3 Die sinking	Table 4 Forge	Table 5 Heat treat	Table 6 Dimensi onal Insp serv	Table 7 Machini ng	Table 8 Macro etch	Table 9 NDT	Table 10 Raw Mtl Titanium	Table 11 Sand blast	Table 12 Testing	Table 13 Raw Mtl Aluminum Extruded	Table 14 Raw Mtl Cast Aluminum ingot	Table 15 Calibration Serv	Table 16 NDT Level 3 services
STAN6	Prohibited Materials	x	x	x	x	x		x	x	x	x	x	x,C	x	x		
ENG1	Electronic Data and Secure Transmission	x,C	x,C	x	x,C	x,C	x,C	x	x,C	x,C			x,C				x,C
ENG2	Digital Data Quality Plan (DDP)			x			x										
ENG3	Software Control			x		x	x	x					x				
Q2	Mandatory Inspection Point- MIPS				x,C	x,C		x,C		x,C			x,C				
Q4	Source Inspection	x,C	x,C	x,C	x,C	x,C	x,C	x,C	x,C	x,C		x,C					
Q5	Raw Material Test Reports										x			x	x		
Q6	Heat Treat Certification					x											
Q7	1st Article Inspection AS9102			x,C			x	x									
Q8	Certificate of Conformance	x	x	x	x	x	x	x	x	x		x,C	x			x	
Q9	Nonconforming Material Control	x	x	x	x	x	x	x	x	x		x	x	x	x		
Q10	Quality Records	x	x	x	x	x	x,C	x	x	x	x	x,C	x	x	x	x	
Q11	Right of Entry	x	x	x	x	x	x	x	x	x	x	x	x	x	x		
Q13	Special Processors	x,C	x			x	x,C		x	x			x				
Q14	Quality System	x	x	x	x	x	x	x	x	x	x	x,C	x	x	x	x,C	x,C
Q15	Revisions	x	x	x	x	x	x	x	x	x		x	x			x	
Q16	Approval Status	x,C	x		x,C	x	x,C	x,C	x	x		x,C	x				x,C
Q17	Notification	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x
Q18	Counterfeit Materials	x	x		x	x	x	x	x	x	x	x	x	x	x	x	
Q19	Eye Exams						x	x	x	x	x,C		x	x	x	x	x
Q20	Traceability, General	x	x		x	x	x	x	x	x		x	x				
Q21	Nonconforming Material Submittals	x	x	x	x	x	x	x	x	x		x	x				
Q23	Subcontracting	x	x	x	x	x	x	x	x	x	x	x	x	x	x		
Q24	FOD	x	x	x	x	x	x	x	x	x	x	x		x	x		
Q25	Conformance	x	x	x	x	x	x	x	x	x	x	x	x	x	x		
Q26	Calibration	x	x	x	x	x	x	x	x	x	x,C		x	x,C	x,C	x	
Q27	Commingling	x	x		x	x	x	x	x	x		x	x,C	x			
Q28	On-Site First Article Review				x,C			x,C									
Q29	Flight Safety / Critical Parts					x		x	x	x			x				
Q31	Key Characteristics		x,C		x	x	x	x	x,C	x			x,C				
Q32	Corrective Action	x	x	x	x	x	x	x	x	x	x	x	x	x	x		
Q33	QMS, awareness compliance/ Code of Ethics	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x
Q34	Flight Safety Program- Awareness	x	x		x		x				x	x		x	x		x
Q35	Design Authority Data	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x
Q36	Corrections	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x
Q37	Language	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x
Q38	Measuring & Monitoring Equipment	x,C	x,C	x,C		x,C	x,C	x,C	x,C	x,C	x,C		x,C	x,C	x,C		
Q39	Informal request/ Verbal order	x	x	x	x	x	x	x	x	x	x	x	x	x	x		
SMH1	Preservation	x	x	x	x	x	x	x	x	x	x	x,C	x	x	x		
SMH5	Oil preservation of WIP Forgings							x,C		x,C							
SMH3	Oil preservation - Extruded Aluminum Stock												x				
SMH4	Oil preservation- Cast Aluminum Ingot Stock														x,C		
DS1	Die Impression Plaster Cast			x													
DS2	Part Identification			x													
HT3	Chemical Milling	x															
HT4	Heat Treatment Guide Lines					x											
HT5	Beta Transus					x											
HT6	Weber Metals process HT specification					x											
MACH2	Manufacturing Plan							x,C									
MACH3	Source Inspection			x,C				x									
MACH7	Traceability, ID Transfer							x									
MACH8	Inspection							x									
MACH9	PWA 370 quarterlys for Pratt & W. forging							x									
RM1	Material Certification										x			x	x		
RM2	Material Length										x			x	x		
RM3	Material Specification										x			x	x		
TEST3	Test Records												x				
TEST4	Test Remnants												x				
TEST5	Remnant Identification												x				
TEST6	Hydrogen Test												x				
TEST7	Testing Sequence												x				
TEST8	Testing Failures												x				

Legend x= Mandatory, C= Conditional item

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Rev	Section	CHANGE HISTORY LOG
New	5/30/14	Quality clauses taken from F003 to form F005 a standalone Quality document. F003 was released in 2005.
A	8/1/14	Added Q21.
B	8/21/14	Added Q22, Q23, Q24, Q25, Q28, Q29, Q30, MACH 8
C	1/19/15	Revised numbering system to previous version. Added or obsoleted items as identified in document.
D	9/6/16	<p>Added SMH3, SMH4, SMH5, Table 13, Table 14.</p> <p>Changed title of Table 10 from "Raw Material" to "Raw Material- Titanium"</p> <p>Added SMH5 to Table 7, Table 9</p> <p>Added Q34, Added Q34 to Table 10, 13, 14</p> <p>Added Q35, Added Q35 to Table 1, 2, 3, 4, 5, 6, 7, 8, 9, 11, 12</p> <p>Fixed spelling error- all tables for Q33- now it read "supplier" instead of "suppler".</p> <p>ENG2 remove reference to WMS-001. And removed Sikorsky from the UTC group and added as stand along.</p> <p>Revised Q5- added- The providers of extruded Aluminum material the source of the ingot/billet material shall be identified on the test report. Weber shall approve the ingot/billet suppliers prior to the extruded Aluminum supplier acquires the ingot/billet material.</p> <p>Q8 removed "must" and added "shall". Removed Q8 from Table 10.</p> <p>Q12 added- measuring equipment shall have proper resolution and it shall be capable of measuring the close tolerance features using a 10 to 1 rule.</p> <p>Q14 added- Metal distributors shall be certified to AS9100 or AS9120.</p> <p>Q32 added supplier quality group contact information.</p> <p>Q33 added Quality Cardinal Rules and Code of Ethics to UTC section of table.</p> <p>Q35 added purchase contract</p> <p>Mach2 added Note for fixed operations work is to be conducted per fixed practices such as frozen HT plans, machine plans or NDT inspection plans.</p> <p>RM3 added flohaynes@webermetals.com</p> <p>Added Summary Table to Clause Application Guide, page 16</p> <p>Modified MACH8 added KC 100% inspection, and calibrated tools accuracy/resolution, added contact info.</p> <p>HT4, Mach8, Q21, Q28 added contact information:</p> <p>Q29 added FSP clarifications.</p> <p>Q16 added prime approval requirements.</p> <p>DS1 modified- removed cast impression</p> <p>Table 9 removed all testing requirements</p> <p>Q10 modified retention time. Added 10 years for non FSP/CR parts.</p> <p>Added table 15 for calibration suppliers</p>

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E	1/23/17	<p>Obsoleted Q12</p> <p>Removed Q12 from Table 7</p> <p>Added to Q17 wording</p> <p>Added Q36, Q37, Q38.</p> <p>Added Q36, Q37, Q38 to Tables 1-15</p> <p>Updated MACH8 to clarify requirements, added requirement E (previously from Q12). Added sampling plan.</p> <p>Q10: Added ABC designations. Added requirement for B. Changed retention period- 11 years was 10 years.</p> <p>Q5: Added ABC designations for clarity.</p> <p>Q33: Deleted table and references to Prime specifications. Re-named clause. 'Code of Ethics' was 'Supplier Quality System Requirements'</p> <p>ENG2: Removed table of reference specifications. Added WMPS-001.</p> <p>Added to ENG1 the <i>File Transfer Security portal.</i></p> <p>Added ENG3 software control and added to tables: 3, 4, 5, 6, 7, 12</p> <p>Added ENG3 to table 3, 4, 5, 6, 7, 12, 16.</p> <p>Added table 16 for dimensional inspection</p> <p>Added to Q13 the Nadcap M&I recognition flowed down by Boeing and Spirit.</p> <p>Updated HT4, added frozen plan control</p> <p>Revised Q24-added Train PowerPoint present. Contact SQG.</p> <p>Updated Q25, removed WM approval, added, conformance. Updated all tables w/previous words.</p> <p>Updated table 15 removed Q9, Q11, Q38.</p> <p>Updated Q28 added could be, instead of is.</p> <p>Remove Q1 from tables, remove Q12 table 7.</p> <p>Revised DS1 to cast references. Remove full cast and added partial cast to verify raised characters.</p> <p>Revised Q14</p> <p>Added attachments of forms: SDF, SCAR, QA,</p> <p>Updated all tables. Added table 16 for NDT L3 services.</p> <p>Added HT6,</p> <p>Added Q34 to table 10, 13, 14</p>
F	3.16.18	<p>Updated to meet new IMSAS9100D and SAP words. Removed shipper and added SAP "Delivery Note". Update forms.</p> <p>Added REACh statement and location of weber metals website. Added awareness in Q33.</p>

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G	2/7/2019	<p>Updated to meet new IMSAS9100D and SAP words. Removed shipper and added SAP "Delivery Note". Update forms. See updates in blue color Pg 1 expanded the SCAR supplier responsibilities Pg 1. Added REACH statement and location of weber metals website. Q4, Q11, Q20, Q29, Q35, SMH1 added delivery note, Q8- updated statements for FSP/CC Q21, TEST3, TEST5, update with SAP PO new terms Q23 added words- work transfer/written Q29 added product safety, Q31 added preapproval..., Q32 added QP 7.4 F008 Q33 Added awareness and product safety ethical behavior, updated customer spec names Q39 added informal request, verbal order Updated MICS4 added environ/safety rules, MISC5 added material radiation, mercury contamination and MICS6 AAM Removed obsoleted MICS clauses New 10/5/2005 Obsoleted 5/30/14 MISC1: (Executive Order 11375) New 10/5/2005 Obsoleted 5/30/14 MISC2: (Payment terms) New 10/5/2005 Obsoleted 5/30/14 MISC3: (Confidentiality) New 10/5/2005 Obsoleted 5/30/14 STAN1: (Packaging Identification) New 10/5/2005 Obsoleted 5/30/14 STAN2: (Acknowledgment)</p> <p>New 10/5/2005 Obsoleted 5/30/14 STAN3: (Blanket Orders) New 10/5/2005 Obsoleted 5/30/14 STAN4: (Shippers) New 10/5/2005 Obsoleted 5/30/14 STAN5: (Effectivity Date) New 10/5/2005 Obsolete 1/19/15 HT2: (Sand blast) New 10/5/2005 Obsolete 1/16/15 MACH4: (Audit Approval) New 10/5/2005 Obsolete 1/19/15 MACH5: (NRE Cost) New 10/5/2005 Obsolete 1/19/15 MACH6: (Tooling) New 10/5/2005 Revised 1/19/15 MACH7: (Traceability) See Q20 for traceability requirements. New 10/5/2005 Obsoleted 1/19/15 Q1: (Right of Entry, Government) see Q11. New 10/5/2005 Obsoleted 5/30/14 Q3: (Basic Inspection System) New 10/5/2005 Obsoleted 1/26/17 see ENG 8 and Q38 Q12: (Close Tolerance Features)</p>
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	2/26/2019	<p>New 5/30/14 Obsolete 2/16/17 see Q25 Q22: New 8/21/14 Obsoleted 1/19/15 Q30: (Boeing D1-4426) replaced by Q16. New 10/5/2005 Obsoleted 5/30/14 SMH2: (Shipping contact) Updated to meet ASQR-01 rev 11</p> <p>Changed all references from ASQR to SSQR.</p> <p>Clarification of AAM -stamp/electronic buyoff signatures/initial control log</p> <p>Added QWI 8.5-29 to replace QWI 7.5-29 to the Heat Treat table under Procedure/ Requirements</p>
Transition to QP 8.4 F002 from QP 7.4 F005		
New	3/5/2019	Initial release and added MACH7- this was on the E rev. it got deleted in Rev G- updated several clauses.
A	12/17/2019	<p>MACH8 F) Added additional requirements, inspection table was modified</p> <p>Added MACH9 PWA370 quarterly audits- by jb</p> <p>Page 1 Updated this section Forms and Quality Clauses Code Matrix: update and remove form numbers on page 2. jb</p> <p>Q14 added contact information and clarification. jb</p> <p>SMH5 added clarification "see PO/delivery Note..." jb</p> <p>MACH8 removed reference to SSQR-07.5 jb</p> <p>Q32 updated form number to QP 8.4... jb</p> <p>Q14 updated form number to QP 8.4... jb</p> <p>Update matrix to include MACH9 to machine suppliers jb</p> <p>Updated <i>Quick Reference of Quality Clauses by Supplier Type</i> jb</p>
B	8/5/2020	Added "preferred" for quality clauses review form
C	8/19/2020	<p>MACH9: Removed requirement to submit quarterly audits to Weber Metals.</p> <p>Forms and Quality Clauses Matrix replaced "QWI 8.3-4 F001 Supplier Deviation Form for WIP, HT, NDT, Coating, Machining" with "QWI 8.7-3 F001 Supplier Deviation Submittal Form"</p> <p>Replaced "QWI 8.3-4 F002 Supplier Deviation form for Raw material Aluminum, Titanium billet/ingot, tooling" with "QWI 8.7-3 F002 Supplier Deviation Submitted Form : Raw Material/Tooling Services "</p> <p>Raw Material & Tooling Suppliers Replaced "QWI-8.3-4 F001 and F002" with "QWI 8.7-3 F001 Supplier Deviation Submittal Form & QWI 8.7-3 F002 Supplier Deviation Submitted Form : Raw Material/Tooling Services"</p> <p>Q23 Added " and documents" after "Relevant quality clauses "</p> <p>Q32 Added "Supplier can be required to provide Corrective Action/Preventive action if the supplier delivers non-conforming material, does not meet On Time Delivery KPI (≥85%), does not meet Quality KPI (≥80%) or any other issue deemed sutible by Quality Management "</p> <p>Supplier Deviation Submittal Forms Replaced QWI-8.3-4 F001 with QWI 8.7-3 F001 and QWI-8.3-4 F002 with QWI 8.7-3 F002</p>