

GENERAL INFORMATION

This document establishes quality requirements as listed in each Quality Code for procurement items and/or services and defines Supplier responsibilities for ensuring that purchased items and/or services conform to company drawing, specification and all applicable procurement requirements.

NOTE 1: Only the quality codes specified by the applicable purchase order apply to a specific procurement.

NOTE 2: The quality system of each supplier may be subject to periodic audits by company representatives.

NOTE 3: Codes made be revised or modified due to changes in requirements flowed down from Ahlers Aerospace, Inc. Customers. Supplier shall be notified immediately if any actions are to be effected during processing of an existing order/procurement.

QUALITY CODES

QUALITY CODE 1

(The quality requirements listed under the section apply to all Ahlers Aerospace, Inc. Purchase Orders).

Requirements

- a. This Quality Code (1) serves as the basic quality requirements (general aerospace industry standards) associated with products and/or services contracted by Ahlers Aerospace, Inc. as a Buyer. Additional quality codes and clauses may be made a part of procurement actions (subcontracts, purchase orders, etc.), either directly or by reference. Quality Codes describe quality requirements which may be imposed with regard to procurement actions. These requirements generally will not be described in any other document and are exclusive to Ahlers Aerospace, Inc. only. Suppliers are to comply with the requirements of all quality codes as noted on the Ahlers Aerospace, Inc. Purchase Order document.
- b. Quality requirements, codes and clauses are intended to be in addition to, not in derogation of procurement action requirements.
- c. Quality Codes 2 and larger are related to specific activities or actions to be accomplished by the Supplier which may be derived from Ahlers Aerospace, Inc. contractual obligations, industry specifications and/or standards associated with the products and/or services being procured.
- d. A quality clause (statement of requirement) may be noted on the Purchase Order or other procurement action when a specific quality code does not address a specific requirement.
- e. If a Supplier cannot comply with any applicable quality requirement listed within a quality code or quality clause on a procurement action, then resolution and/or changes to the requirements must be obtained prior to acceptance of the Ahlers Aerospace, Inc. Purchase Order. The primary point-of-contact for Suppliers is the Ahlers Aerospace, Inc. Purchasing Representative.
- f. Distributors (considered a representative of the Manufacturer), as the direct supplier to Ahlers Aerospace, Inc., are responsible for compliance with all procurement action requirements. As an approved source, the Distributor maintains an inspection system that ensures that material supplied to the company conforms to the requirements of this procurement. The applicable requirements of all quality codes, quality clauses, and any technical requirements listed on the procurement action will apply to both the Distributor and the Manufacturer of the product.
- g. Supplier's Quality Management System shall conform to a National and/or Internationally recognized system/standard (i.e., ISO 9000/9001, AS9100, MIL-Q-9858, ISO10012-1, ANSI-Z-540, FAA Part 145) as applicable to the type of products and/or services provided to Ahlers Aerospace, Inc., unless an alternate Quality System level/type has been determined acceptable by Ahlers Aerospace, Inc. Quality Manager or given designee.
- h. All data, documents and any Certificates of Conformance from the Supplier and sub-tiers shall be in English or contain an English translation.
- i. Suppliers shall maintain quality records for products, equipment and/or services provided to Ahlers Aerospace, Inc. for a minimum of 10 years after the requirements of the procurement action have been fulfilled and retrievable upon request. Likewise, First Piece/Article Inspection (FPI/FAI) reports are to be maintained for a minimum of 10 years.
- j. Suppliers shall notify Ahlers Aerospace, Inc. when changes occur that will affect their

- management system (address/location, quality system approval level/type, key personnel). In order to maintain an accurate "Approved Supplier List", Ahlers Aerospace, Inc. may conduct periodic reviews (surveys, questionnaires, on-site visit, etc.) to ensure a Supplier's information is correct and current.
- k. Direct Suppliers to Ahlers Aerospace, Inc. will flow down applicable quality and procurement action requirements (including Non-Disclosure Agreement items) to their sub-tier Suppliers to ensure the integrity of the specified requirements are maintained throughout the supply chain (i.e., first piece/article inspection, customer approved special processes, key characteristics, record retention, etc.) (Ref. AS9100 sect. 7.4.2). Likewise, it shall be the Supplier's responsibility to flow down the specifications and latest revisions to their sub-tier processing supplier.
 - l. All documents supplied by Ahlers Aerospace, Inc. shall be configuration controlled by the Ahlers Aerospace, Inc. Purchase Order. All documentation received from Ahlers Aerospace, Inc. and retained by the Supplier shall be controlled in accordance to AS9100 sect. 7.1.3 by the Supplier. It is the Supplier's responsibility to verify all documents received from Ahlers Aerospace, Inc. and retained past the expiration of the Purchase Order. Whereas, any existing documentation on file may not be valid against any new Purchase Order or Change Order.
 - m. If a sub-tier Supplier is used to provide any portion/part of the product or service being purchased by Ahlers Aerospace, Inc., the primary Supplier must notify Ahlers Aerospace, Inc.'s Procurement representative. Notification must include the name of the sub-tier Supplier and the product and/or service being accomplished on your behalf. It shall be the Supplier's responsibility to flow down the relative and current specifications and latest revisions to their sub-tier processing suppliers. For contractual reasons, Ahlers Aerospace, Inc., our Customer and when required a government representative/inspector (if needed) may request visiting the Suppliers facility and/or a sub-tier Supplier for the purpose of verifying contract compliance and product conformity (i.e., source inspection, witness testing, product audit, quality system audit). Supplier will provide the necessary support to the visiting personnel. Arrangements for such visits will be coordinated through the Ahlers Aerospace, Inc. Procurement and/or Quality Representative.
 - n. Supplier shall notify Ahlers Aerospace, Inc., or issue a recall notice, when discrepancies in the Supplier's process or product are discovered or suspected which may affect the fit, form, or function of any product (Non-conforming Product) which the Supplier has delivered or will deliver to Ahlers Aerospace, Inc.
 - o. Supplier will notify Ahlers Aerospace, Inc., of any non-conforming/suspect material or product that may have been previously delivered. Additionally, departures from drawings, specifications, or procurement requirements shall be submitted to Ahlers Aerospace, Inc. for review and possible deviation consideration and dispositioning (may require our Customer's approval also). Deviation dispositioning of non-conforming product must be processed using Ahlers Aerospace, Inc. Form 11-003 *Request for Deviation/Waiver*, submitted to and then approved /accepted by formal notice by Ahlers Aerospace, Inc. prior to shipment. One copy of the approved Supplier Discrepancy Request (Form 11-003) shall accompany each affected part/shipment (case-by-case basis). Any product that does not Purchase Order requirements shall be returned to Supplier at Supplier's expense
 - p. Supplier is not granted Material Review Board (MRB) authority for any product that is manufactured to an Ahlers Aerospace, Inc. drawing/specification or any Ahlers Aerospace, Inc. Customer's drawing/specification. Any deviations to engineering drawings/specifications must have Ahlers Aerospace, Inc. and/or Ahlers Aerospace Inc's. Customer's approval prior to shipment of product. Ahlers Aerospace Inc. shall determine if the product is submittable to our customer for formal disposition. When applicable, the Customers disposition shall be flowed down to the Supplier through our Purchasing Organization.
 - q. Any MRB disposition or Deviation Waiver received from Ahlers Aerospace, Inc. or Ahlers Aerospace, Inc's. Customer is a conditional acceptance of the item(s) and does not relieve the Supplier of any contractual responsibilities in the event that Ahlers Aerospace, Inc. or an Ahlers Aerospace, Inc's. Customer is dissatisfied with or not willing to accept the as delivered or conditional form of the product. Supplier shall assure that Customer dispositioned non-conforming

- product is/are properly identified with appropriate documentation when shipped-stating non-conformance conditions. All costs incurred by Ahlers Aerospace Inc. for any non-conformance submittal shall be flowed down to the Responsible Supplier. Ahlers Aerospace Inc. reserves the right to refuse a submittal to our Customer, if it affects our Quality Rating with our Customer.
- r. Supplier shall provide a definitive Root Cause Analysis (RCA) and Corrective Action Plan when a Supplier Corrective Action Request (SCAR) is issued as a result of non-conforming products and/or services. Also, for any unsatisfactory rating regarding; on-site survey/evaluation or documentation, delivery of product (late, damaged, incomplete, scrap...etc.) or other performance or product related issues.
 - s. Product/materials shall have a minimum of 80% shelf life remaining at time of receipt by Ahlers Aerospace, Inc. If the Supplier desires to provide product with less than 80% shelf life, the Supplier is required to obtain approval from the Ahlers Aerospace, Inc. Procurement representative prior to shipment. Shelf life information (i.e., expiration date, cure date) of product/materials subject to degradation with age or varying temperatures must be clearly stated on either of these items; the Certificate of Conformance, the packing slip, the product or its packaging. Additionally, all applicable Code of Federal Regulations (CFR), OSHA and applicable federal policies and documents must be followed. A MSDS for each applicable item shall be sent (or available from the product manufacturer's website) with the product shipment.
 - t. Products/materials which are volatile or toxic in nature shall be properly packaged in accordance with the applicable Code of Federal Regulations. Containers will be plainly marked as to the contents with appropriate warnings, precautions, instructions and storage conditions. Appropriate documentation (MSDS, handling, etc.) will accompany each shipment.
 - u. Product/material categorized as Electrostatic Sensitive Devices (ESD) shall be packaged and labeled in accordance with the appropriate specification/drawing requirements (i.e., MIL-STD-1686; MIL-STD-129) for the product/material being provided to Ahlers Aerospace, Inc.
 - v. When Digital Data is provided to the Supplier by Ahlers Aerospace Inc., the Supplier is required establish and maintain a Digital Product Management System for the control of Digital Product Definition Data in accordance with Ahlers Aerospace Inc.'s end item Customer requirements.
 - w. The purchase order and/or design drawing/specifications shall specify part identification requirements, including serialization control when applicable and the Supplier shall ensure and verify prior to shipment that all items are permanently and legibly identified. Identification requirements may include the following, as specified by the Purchase Order and/or Ahlers Aerospace, Inc. documents: part number and revision level, manufacturer's identification, lot or date code, serial number and quantity. The following exceptions apply: a) Items too small to be individually marked are packaged in suitable containers identified with the requirements stated above. b) Raw material is identified as required above and meets recognized industry standard color code requirements. If the Supplier disagrees or is not capable to comply with the specified requirements due to conflicts with the specification and the Ahlers Aerospace, Inc. Purchase Order or due to capabilities, they are to contact the Ahlers Aerospace, Inc. Purchasing Agent in writing to resolve the issue.
 - x. If Supplier has received product from Ahlers Aerospace, Inc. (customer furnished material/item) as related to an issued procurement action, the Supplier is required to maintain traceability (i.e., lot/batch identification, part marking) of the product throughout the processes when possible. Product life cycle is inclusive of special processes (electroplating, chemical film, paint/primer, welding, cutting, bending, etc.) testing and assembly.

QUALITY CODE 2 **Requirements**

Dependent upon the type of product procured by Ahlers Aerospace, Inc., the Supplier is required to provide with each shipment of product a document (Certificate of Conformance or FAA Form 8130-3 or JAA Form 1 or EASA Form 1 or equivalent-as appropriate) with a statement of conformity that contains the following:

- 1) Ahlers Aerospace, Inc. procurement Purchase Order number,

- 2) Part number and/or description of the ordered item,
- 3) Revision number/letter of the item being provided, when applicable,
- 4) Date/lot code of the item being provided, when applicable,
- 5) Statement declaring that no rework/repair or alteration has been performed on the product/s (new items).
- 6) Country of Origin
- 7) Date of item/s shipped
- 8) Signature and/or stamp of the Supplier's representative.

NOTE: A Certificate of Conformance (C of C) document that includes the company letterhead and a Certificate of Conformance statement may be deemed acceptable (at Ahlers Aerospace, Inc's. discretion) in lieu of providing a Supplier representative's signature and/or stamp.

QUALITY CODE 3 **Requirements**

Distributor is to provide the Manufacturer's Certificate of Conformance (C of C) for ordered item. The Certificate of Conformance should, at a minimum, contain:

- 1) Part number and/or description of the ordered item,
- 2) Revision number/letter, date code, batch number, date of manufacture, expiration date, etc., of the item being provided, when applicable,
- 3) Statement declaring that no rework/repairs or alterations have been performed on the product (new items).
- 4) Signature and/or stamp of the Manufacturer's representative.

Distributors – A manufacturer Certificate of Conformance is the preferred document for the ordered item. If a Manufacturer Certificate of Conformance is not provided with the shipment of product, Ahlers Aerospace, Inc. reserves the right to request receipt from the Distributor (at the time of or after receipt of product) a Manufacturer's Certificate of Conformance.

QUALITY CODE 4 **Requirements**

Ahlers Aerospace, Inc. has identified the ordered item as being subject to meeting the requirements of a QPL (Qualified Products List). As such, the ordered item may only be provided via the Manufacturer direct or their authorized distributor as posted/published in the applicable QPL.

Supplier is to provide a Certificate of Conformance that, at a minimum, contains the following information:

- 1) Ahlers Aerospace, Inc. procurement action number,
- 2) Part number and/or description of the ordered item,
- 3) Revision number/letter and/or Date/lot code of the item being provided, when applicable,
- 4) Signature and/or stamp of the Supplier's representative.

Distributors – A manufacturer Certificate of Conformance is the preferred document to be provided for the ordered item. If a manufacturer Certificate of Conformance is not provided with the shipment of product, Ahlers Aerospace, Inc. reserves the right to receive from the Distributor, at the time of or after receipt of product, a manufacturer's Certificate of Conformance.

QUALITY CODE 5 **Requirements**

Ahlers Aerospace, Inc. has identified the ordered item to be electronic in nature which is now classified by the U.S. Department of Defense (DOD) as a potential high risk for being suspect/counterfeit material.

Procurement of this product type may now only be obtained via the Manufacturer direct or their authorized distributor.

The Supplier/Distributor is to provide a Certificate of Conformance based on their type of organization:

- A. If an OEM/OCM - Provide an OEM/OCM Certificate of Conformance
- B. If an Authorized Franchised Distributor – Provide an Authorized Franchise Distributor Certificate of Conformance.

The Certificate of Conformance should, at a minimum, contain the following information:

- 1) Ahlers Aerospace, Inc. procurement Purchase Order number,
- 2) Part number and/or description of the ordered item,
- 3) Revision number/letter of the item being provided, when applicable,
- 4) Date/lot code of the item being provided, when applicable,
- 5) Country of Origin,
- 6) Date of item/s shipped,
- 7) Signature and/or stamp of the Supplier's representative.

NOTE: A Certificate of Conformance (C of C) document that includes the company letterhead and a Certificate of Conformance statement may be deemed acceptable (at Ahlers Aerospace, Inc's. discretion) in lieu of providing a Supplier representative's signature and/or stamp.

Distributors – A manufacturer Certificate of Conformance is the preferred document to be provided for the ordered item. If a manufacturer Certificate of Conformance is not provided with the shipment of product, Ahlers Aerospace, Inc. reserves the right to receive from the Distributor, at the time of or after receipt of product, a manufacturer's Certificate of Conformance.

QUALITY CODE 6 **Requirements**

First Piece/Article Inspection report is required for the ordered item/service. Report should contain at a minimum, the following:

- a) Engineering drawing number, configuration, and revision,
- b) Notation of applicable material and process specifications used,
- c) Notation and verification of all dimensions and applicable notes on the drawing(s),
- d) Notation of any document generated during the FPI/FAI process related to any nonconforming condition,
- e) Certificates of Conformance (copies) for all materials, processes, parts used in the production of the ordered item(s), where applicable.

If the quantity of the ordered item consists of more than one piece, the item from which the First Piece/Article Inspection report was generated from shall be identified (tagged, bagged, labeled, or other accepted means of i.d.). Ahlers Aerospace, Inc. reserves the right to request/receive documented evidence of compliance to specification requirements (training, qualifications, etc.) for any employee or subcontractor that performed a special process associated with an ordered item.

NOTE: Supplier may use specification AS9102 *Aerospace First Article Inspection Requirement* as a reference or guide document for FAIRs.

QUALITY CODE 7 **Requirements**

Supplier is to provide a copy of the raw material test data (chemical, physical, heat treatment, etc.) for the ordered product that demonstrates compliance with applicable specifications (QQ-N-; AMS-; SAE-; etc.) and/or drawings requirements. If the Ahlers Aerospace, Inc. Purchase Order and/or provided drawing does not call out any particular material specification for the material type being ordered, then the Supplier may provide material to a specification as agreed to by Buyer.

QUALITY CODE 8

Requirements

Supplier is required to manufacture and test product against written standards defining work quality, process controls, and acceptance or rejection criteria as required. These are to be accepted/approved by Ahlers Aerospace, or when appropriate, the Supplier may substitute existing in-house standards upon acceptance by an Ahlers Aerospace, Inc representative.

QUALITY CODE 9

Requirements

Supplier is required to provide an independent lab/test report that validates the raw material being provided conforms to the mill certification/test report and applicable specifications.

NOTE: It may be required for reports to be reviewed and/or validated by an Ahlers Aerospace, Inc. representative prior to order shipment from Supplier.

QUALITY CODE 10

Requirements

Source Inspection by Ahlers Aerospace, Inc. and/or Ahlers Aerospace, Inc.; Customer is required prior to shipment of product. Supplier is to contact Ahlers Aerospace, Inc. Procurement representative in advance of product shipment to make arrangements for source inspection activity. (no less than 4 business days advance notice before scheduled shipping date to permit scheduling of a Source Inspection).

QUALITY CODE 11

Requirements

Source Surveillance by Ahlers Aerospace, Inc. Representative and/or Ahlers Aerospace, Inc.; Customer is to witness acceptance testing at Supplier's facility or an assigned/contracted sub-supplier/agency. This may also include review of Supplier's inspection system, procedures and/or quality or test results during the production run for ensuring manufacturing process conformance and stability. Supplier is to contact Ahlers Aerospace, Inc. Procurement Representative in advance of acceptance testing activities in order to make arrangements for witnessing of testing.

QUALITY CODE 12

Requirements

Supplier is to furnish Certificates of Conformance for special processes or testing (i.e., NDT, Spectral Scans, coatings such as electroplating, chemical film, paint, anodizing,...etc.) that includes the specification(s) associated with the performed process(es). Ahlers Aerospace, Inc. reserves the right to request/receive documented evidence of compliance to specification requirements (training, qualifications, etc.) for any employee or subcontractor that performed a special process associated with an ordered item.

QUALITY CODE 13

Requirements

The Government imposes Selective Evaluation on this order. During performance of this order, your Quality Control or Inspection System and manufacturing processes are subject to review, verification, and analysis, by authorized Government representatives.

QUALITY CODE 14

Requirements

Product must have been inspected, tested, overhauled, or repaired as necessary by a Federal Aviation Administration (FAA) certificated Repair Station. Each/such product must have the appropriate maintenance release form attached, (FAA 8130s, etc.) as related to the analysis, testing rework, or repair of product on this purchase order.

QUALITY CODE 15

Requirements

For each item or service a Supplier provides that is used to monitor conditions or validate dimensions, the Supplier is required to provide or as specifically defined in the Purchase Order requirements show proof of a Certificate of Calibration that meets the requirements of ANSI-Z-540 or ISO 10012-1. Equipment or calibration standards are to be traceable to the National Institute of Standards and Technology (NIST). Certificates of Calibration will include the actual Standard/s used and a due date of the last day of the month for which the calibration was performed (i.e., calibration performed on June 12. Due date = June 30).

QUALITY CODE 16

Requirements

Supplier is to provide copies of applicable documents (teardown reports, analysis, work orders, repair reports, (FAA 8130s, etc.) as related to the analysis, testing rework, or repair of product on this purchase order.

QUALITY CODE 17

Requirements

Supplier is to provide a maintenance record entry (a.k.a. – log book entry) for the service/work that will be performed.

QUALITY CODE 18

Requirements

Supplier is to provide applicable documents (engineering analysis, FAA 8110-xx, 8130-xx, reports, etc.) as related to the analysis, approval, service and review of item/s per Purchase Order.

QUALITY CODE 19

Requirements

A Certificate of Calibration that meets the requirements of ANSI-Z-540, ISO 10012-1 or other applicable standard is required to be provided for this item. Equipment or calibration standards are to be traceable to the NIST.


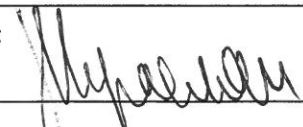

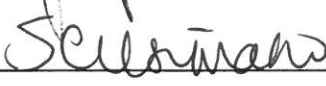
QUALITY CODE 20

Requirements

Technicians/Personnel performing the NDT/NDI examination described on this Purchase Order shall be qualified and certified to the current applicable standard/specification (NAS 410, ASNT SNT-TC-1A, etc.).

QUALITY CODE 21
Requirements

Flammability test reports meeting the requirements of FAR 25.853 are required for the ordered item(s).

ENGR: 	MFG: 
QA: 	OPS: 

Revision History

Initial Release: 8/11/1999

Revision A, 10/12/1999: Extensively revised to remove military type quality system references

Revision B, 1/5/2004: Company name change

Revision C, 04/16/2011: Update procedure per ECO 6270

Revision: D per ECO 7969

Revision: E per ECO 8061