

SC-Q02 Vendor Material Review Request (VMRR): Boeing

Boeing Commercial: Notwithstanding the requirements of G-Q13.02, all nonconformances will be submitted to GKN Orangeburg via [VMRR](#).

Do not deliver the affected product until any required further work identified by the VMRR Engineering & Quality disposition have been completed, and/or you are in receipt of a completed VMRR, or have otherwise been authorized by the Company Permission to Ship (PTS) process to deliver the product for further evaluation per VMRR disposition.

The GKN or Boeing MRR or concession number must be referenced on all Supplier Certificates of Conformity and packing lists, and where required, is permanently added to the part marking.

A red warning label must be attached to the deliverable product; this warning label must reference the product/part number and the applicable GKN or Boeing MRR/concession number, and shall have a statement saying that the label is not to be removed until the product is assembled by GKN.

G-Q01.03 QMS Certification: AS9100

The supplier shall maintain certification obtained from an accredited certification body to AS/EN/JISQ 9100 to the latest revision.

The supplier shall implement and maintain a quality and inspection system acceptable to GKN, and to control product and process quality that meets the latest revision of GKN's Q-Notes as specified in the purchase order. The system shall include a company-wide process that fosters continuous quality improvement in compliance with AS9100, and, as applicable, Boeing D6-82479 of the latest revision at the date of the purchase order.

When AS9100 certified, the supplier shall grant GKN Aerospace South Carolina access to their certification information file in the OASIS database (http://www.sae.org/?PORTAL_CODE=IAQG).

Suppliers producing Boeing parts/products are required to forward copy of their Quality Manual to GKN-SC. The supplier shall also forward a copy of their Quality Management Systems certifications to GKN.

Distributors refer to SC-Q06.

G-Q01.04 Purchase Order Review Process

The supplier is responsible to implement a process in his Quality Management System (QMS) by which all requirements of this purchase order are reviewed and understood prior to its acceptance, and that all quality requirements are incorporated into the manufacturing planning, inspection and test instructions, as well as being responsible for providing the necessary resources to deliver products that meet all the requirements of the purchase order, as applicable, to assure PO compliance. The supplier shall retain evidence of such reviews. The

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supplier is reminded to be certain that the current revision of each requirement is referenced, unless otherwise specified by GKN.

G-Q01.05 QMS Change Notification

The supplier shall promptly notify GKN, in writing, of changes in the supplier's name, ownership, or management representative with assigned authority and responsibility for the supplier's quality system; of any change in the QMS which may affect the inspection, conformity, or airworthiness of the product; of any action taken against the seller by another of its customers, or by any government agency; or any change in the supplier's manufacturing facility location.

G-Q01.15 Inspection Implementation

The supplier shall implement and maintain a quality and inspection system acceptable to GKN, and to control product and process quality that meets the latest revision of GKN's Q-Notes as specified in the purchase order. The system shall include a companywide process that fosters continuous quality improvement in compliance with AS9100 to the latest revision, and, as applicable, Boeing [D6-82479](#) of the latest revision at the date of the purchase order.

Distributors refer to SC-Q06.

G-Q01.16 Sub-tier Flow Down

Supplier is required to flow down any and all pertinent portions of any GKN contract to all sub-tier supplier performing to the requirements of any GKN contract.

With the exception of standard hardware, the use of customer approved processors and customer approved raw material, Supplier does not have approval to move or subcontract any portion of any GKN contract without the written consent and approval of GKN.

GKN will not permit the use of any supplier or supplier sub-tier that does not have an accredited certification by either AS9100 and/or NADCAP.

G-Q03.03 Customer Approved Sources: Raw Material & Hardware

Suppliers shall purchase raw materials and standard hardware from prime customer-approved sources, e.g. [D1-4426](#), ASPL, or other approval listing. Material that will be produced / procured outside the USA will always require customer approved sources. Foreign supplied materials are prohibited on military aircraft.

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G-Q03.04 Customer Approved Sources: Special Processes

All special processes required by this purchase order shall be performed by sources that are approved by the prime customer.

Refer to the respective customer web sites to find their special process

requirements. Boeing (BCA): [Boeing - Approved Process Sources - D1-4426](#)

For all other Customers, see Customer-specific websites.

G-Q03.05 Master Specification Listing

For the current revision of the specification applicable to this purchase order, see [Master Specification Listing](#) available at:

[Quality Information - GKN Aerospace](#) (South Carolina)

G-Q06.01 Right of Entry

During the performance of this purchase order, GKN, its customer and/or regulatory agencies, have the right of entry to determine and verify product quality, records and material, including the right to audit the supplier's quality system at any location. The foregoing pertains equally to the supplier's sub-tiers. Supplier must coordinate any such entry with the GKN buyer.

Work under this PO is subject to GKN's periodic surveillance/audit of supplier's compliance with supplier's internal procedures and other documents applicable to this PO.

GKN's acceptance of such product does not absolve the supplier of the responsibility to provide acceptable product, nor does it preclude subsequent rejection by GKN, its customer or regulatory agencies.

G-Q06.04 Commercial: Additional Inspection, Surveillance, & Test

At no additional cost to GKN, products may be subject to inspection, surveillance and test at reasonable times and places, including supplier's subcontractors' or suppliers' locations. GKN will perform inspections; surveillance and tests so as not to unduly delay the work. Supplier shall maintain an inspection system acceptable to GKN for the products purchased under any order.

If GKN performs an inspection or test on the premises of supplier, its subcontractors or

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supplier shall furnish and require its subcontractors or suppliers to furnish, without additional charge, reasonable

facilities and assistance for the safe and convenient performance of these duties. The supplier's documentation accompanying the shipment shall reflect evidence of these sections.

When requested by GKN Aerospace or its customers, the supplier will provide test specimens for inspection/verification, investigation, and/or auditing purposes.

G-Q09.01 Product Certifications

Copies of all material, processing, testing, chemical and physical analysis certifications, of the current revisions, shall accompany each shipment of parts as required by the blueprint or applicable specification.

See [Quality Information - GKN Aerospace](#) (South Carolina).

G-Q09.03 Certificate of Compliance

The supplier shall submit a Certificate of Compliance (C of C) asserting that the items contained within this shipment are in total compliance with the requirements of the purchase order, and summarizing all processes and tests performed to the applicable specification revisions, along with the name of each facility utilized. The supplier shall annotate in the delivery package any exceptions, e.g. variances. The supplier shall include a copy of the C of C with the supplier's product shipper.

In addition, for Boeing (BCA) designed product only:
 I.A.W. BCA Purchase Order Quality Clause "Q31".

This procurement is under Boeing's Federal Aviation Administration (FAA) issued Production Certificate 700 quality system supplier control program.

THE SELLER WILL PLACE THE FOLLOWING STATEMENT WITH ALL SHIPMENTS ON THE SHIPPER AND/OR C of C:

"Seller hereby acknowledges that the parts and/or materials being shipped under this order are intended for use under Boeing's Federal Aviation Administration (FAA) issued Production Certificate 700 and no articles (or constituent parts thereof) or the accompanying paperwork (e.g. packages, shippers, etc.) contain any Federal Aviation Administration- Parts Manufacturer Approval (FAA-PMA) markings"

The preferred location for the statement is on the shipping document, next to, or following the Certificate of Conformance (C of C). The statement may be printed, stamped, or attached as a label or sticker to the shipping documentation. It is allowable to replace "Seller" with the company name or "we".

Attention: Boeing requires that the provisions/requirements set forth above be included in Seller's direct supply contracts as well as the obligation that they be flowed to the applicable sub-tier supply chain.

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G-Q09.12 Quality Acceptance of Shipments

The supplier shall provide with all shipments the following evidence of acceptance by its quality assurance department:

- (a) Certified physical and metallurgical or mechanical test reports where required by controlling specifications,
- (b) A signed, dated statement on the packing sheet certifying that its quality assurance department has inspected the products and they adhere to all applicable drawings and/or specifications.

The following information shall be stated on the supplier's declaration of conformity or shipping documentation:

- a) GKN-SC Purchase Order Number.
- b) Quantity in the delivery.
- c) Date of delivery.
- d) Part Identity and applicable change letter and/or suffix number. For material not having a specific part number the nominal dimensions shall be stated. If materials/parts are ordered to a trade designation this designation shall be recorded.
- e) Heat, lot, batch, serial number or other identifying number or symbol when such identification is required.
- f) Source and type of compound or predominant polymer and compound number for non-metallic raw material.
- g) Reference to approved non-conformance reports if any
- h) Any information required for subsequent machining/processing.
- i) Country of origin.

G-Q13.01 Control of Nonconforming Material

The supplier shall implement and maintain a documented QMS that provides for the identification, documentation, and disposition of nonconforming material. The supplier shall ensure that effective corrective action is taken (including repetitive nonconformances dispositioned "Use-As-Is" or "Repair" by Material Review Board ["MRB"] actions) to prevent, minimize, or eliminate nonconformances. The supplier's QMS shall ensure that nonconforming material is not used for production purposes, or for unintended use.

The supplier shall maintain records of all nonconforming material, dispositions, assignable causes, corrective actions, and effectiveness of corrective actions for the period specified in the applicable Quality Notes.

The supplier shall respond to all GKN's requests for corrective action. When so requested,

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the supplier shall provide trend data and findings for GKN rejected Items. The supplier shall identify root cause findings and corrective actions required to preclude recurrence by utilizing tools such as cause mapping, cause and effect analysis, Five Why's etc.

The supplier shall assess all GKN-identified nonconformances, whether or not Item(s) was/were returned to the supplier, and take appropriate actions to ensure causes of nonconformance are corrected.

G-Q13.02 Vendor Material Review Request (VMRR): General

The supplier shall report nonconforming material to GKN using a [VMRR form](#). Nonconforming material shall not be shipped without GKN quality assurance approval. GKN reserves the right to disposition nonconforming material as scrap without submitting product for customer MRB. VMRR forms are available from the GKN.

Notwithstanding any other provisions herein, to the extent Supplier's performance is the direct cause of a financial impact to GKN's customer due to a Supplier nonconformance submittal and evaluation of such nonconformance(s) which has the potential to cause a disruption to aircraft production and delivery schedules as determined by GKN's customer, the costs of the financial impact the defective product(s) has caused will be flowed down to the Supplier and Supplier shall pay to GKN the amount equal to the charges received by GKN's customer.

G-Q13.03 Notification of Escapes (NoE)

The supplier shall provide written notification to GKN within one business day after a nonconformance is determined, or suspected, to exist on product already delivered to GKN under any GKN PO, with the following information provided to GKN:

1. Affected process or part number and name
2. Description of the problem (i.e., what it is and what it should be)
3. Quantity and dates delivered
4. Suspect/affected serial number(s) or date codes, when applicable.

If the non-conformity has been identified by GKN and communicated to the supplier using a nonconformance record, or other equivalent means, requesting a corrective action response, the supplier shall notify GKN if additional product has been found to be so affected.

For Boeing product: At a minimum, the Supplier (or sub-tier) shall notify GKN-SC within 3 days from the day of discovery of **known** or **suspect** discrepancy (for Boeing product). Submit information to GKN- SC to forward to Boeing. If the investigation to obtain all required information is not completed within 3 days from the day of discovery, submit supplier required information in section 1 and 2 (above) and any known information elements listed in 3 and 4 (above) to GKN-SC using Boeing's Preliminary Escapement Notification Form X39312. This notification requirement is applicable to

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all suppliers for Boeing product, including suppliers with D-13709-4 Appendix C Escaped Product Disposition authority.

G-Q13.04 Corrective Action

The supplier shall implement a system of corrective action for discrepancies identified by the supplier, GKN, or GKN's customers. When GKN requests written corrective action, then the supplier shall document the cause of the discrepancy, the corrective action taken, the effective date of the corrective action, and submit this to GKN for review. GKN reserves the right to verify the effectiveness of the stated corrective action at the supplier's facility.

G-Q14.01 Foreign Object Debris/Damage

Supplier shall establish and maintain a Foreign Object Debris/ Damage (FOD) prevention program in accordance AS9146 "Foreign Object Damage (FOD) Prevention Program- Requirements for Aviation, Space, and Defense Organizations" or, as described in NAS412, as applicable.

G-Q15.01 Damage and Corrosion Prevention

All materials, parts, and age control products must be protected against damage and corrosion during delivery using sound standard packaging practices. Special packaging instructions, when required, will be as specified on the purchase order.

G-Q15.02 Inventory Control

The supplier agrees to insure that materials utilized in the performance of this purchase order, whether furnished by GKN or by the supplier, shall be segregated and controlled to insure traceability and to prevent them from being intermingled with any other materials. In addition, the supplier shall strictly control all inventory of customer property that is in excess of the PO contract quantity, so as to prevent it from being sold or provided to any third party.

G-Q15.04 Customer Property: General

Any parts supplied by GKN are solely for the purpose of being processed and remain the property of GKN.

G-Q16.02 Record, Document Retention

Quality documentation records and certifications shall be maintained on file for a period of 1 Calendar Year + 10 Years from the date of shipment under each applicable order for all product/part numbers unless otherwise specified on the Purchase Order. After this period the supplier shall not destroy such records without the written approval of GKN.

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Customer-specific Record Retention Requirements

Customer	Retention period (years)	Comments
Boeing Commercial (BAC)	1 + 10 (See Comments)	1 Calendar Year + 10 Years from the date of shipment under each applicable order for all product/part numbers unless otherwise specified on the order.

G-Q18.02 Personnel Certification

The supplier shall ensure that his personnel performing work to customer specifications which require certified persons, shall attain such certification prior to the performance of such work, (e.g., sealant installation per BAC 5000, NDT per NAS410, etc.)

G-Q22.01 Etch Cleaning

GKN requires its parts to be etch cleaned only when it is required by the processing specification. GKN parts supplied to your facility for processing have surfaces that have been polished and/or blended, and where this is a concern, are considered by most processing specifications as surfaces that have “smeared metal.” If a process specification contains etch cleaning requirements on parts having such surfaces (see each individual specification for its definition of “smeared metal”), GKN requires such parts to be etch cleaned.

GKN process instructions assume parts will be etch cleaned, and will note on the process purchase order if holes or surfaces require masking prior to etch cleaning. The supplier is responsible for masking such features to totally prevent etching of their surfaces.

G-Q24.01 AECA, ITAR

This order contains parts and directs the use of documents and technical data subject to the U.S. Arms Export Control Act (AECA), and the International Traffic in Arms Regulations (ITAR), enacted pursuant to such act. Any of the parts, documents, or data mentioned in these quality notes may not be transferred to any foreign person or entity in the United States, or to any person or entity abroad, nor shall such persons or entities have access to such documents and technical data except as authorized by the U.S. Department of State or the International Traffic in Arms Regulations (ITAR).

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