

IMPAC Quality Notes:

- IMP001 IMPAC will not accept rejectable material. Parts or material with a deviation from drawing, specification or special instructions noted on the purchase order must be dispositioned by IMPAerostructures Manufacturing Engineering. Sellers must notify IMPAC of parts or material that does not meet purchase order requirements by submitting rejection documentation stating the deviation from drawing or specification and a statement of cause and corrective action taken to preclude recurrence.
- IMP002 Seller shall be responsible for rework and/or replacement of all parts or material not conforming to drawing, specification or purchase order requirements. Parts returned to Seller under the order of rework/repair will be accompanied by proof of Sellers inspection acceptance test data when resubmitted to IMP Aerostructures. Resubmitted parts will be accompanied by applicable IMP Aerostructures rejection tag(s).
- IMP003 Seller shall be charged for all IMPAerostructures incurred costs as a result of parts found to be unacceptable when inspected to the requirements called out on the drawing, in the specification or purchase order at the time of fabrication. At the discretion of the Buyer where IMPAC's production schedule does not allow return of defective parts for rework, seller shall be charged the current hourly wrap rate to cover support labour or actual hours incurred reworking any nonconformity of parts into an acceptable condition at IMPAC's facility.
- IMP004 Where required on the purchase order or by specification, certified test reports showing test results and compliance with applicable specifications are required with each shipment.
- IMP005 IMPAerostructures, IMPAerostructures's Customers or regulatory agencies shall be allowed to perform source, quality, or production verification at Seller's facility, or sub-tier seller, during any point of manufacture.
- IMP006 When Purchase Order specifies the requirement for an OEM special process or an approved process source, the process seller must be an approved processor listed in the OEM's list of approved processors.
- IMP007 When parts, material or hardware is a qualified product it must be purchased and distributed from an OEM's qualified source.
- IMP008 Seller is responsible for lab testing of any OEM raw material that has not been tested by the OEM or an OEM approved facility.
- IMP009 Certificate of compliance is required with each shipment stating that the Seller certifies that material and/or finished parts to have been controlled and tested in accordance with, and meet, specified purchase order requirements, and that applicable records are on file subject to examination. Seller agrees to furnish certified copies of test and/or control data, upon request from IMPAC. For traceability purposes, the applicable part lot/serial/batch data must be on both the Certificate of Compliance and annotated on the part by use of an appropriate means of identification. I.e. tagging, labels or temporary marking or by means called out in instructions indicated on the purchase order.

- IMP010 Where applicable Seller shall purchase items listed on this purchase order from OEM approved manufacturers. Seller shall list approved manufacturer and batch number for items supplied on all packing slips and certify that documentation is on file to support this.
- IMP011 Seller shall ensure that all manufacturing and/or special processing to industry recognized standards or OEM specifications is carried out by only qualified personnel.
- IMP012 Seller shall notify IMPAerostructures of changes in product and/or process definition or Quality System approvals. Changes of this nature may require IMPAerostructures approval.
- IMP013 IMPAerostructures may identify on the purchase order a requirement to monitor a “Key Characteristic”. Key Characteristics could be a specific drawing dimension or special process parameter that requires monitoring on a part by part bases. Variation on “Key Characteristics” must be controlled in such a manner as to reduce part to part variation from nominal. All outcome data on Key Characteristics must be reported to IMPAerostructures and supplied with documentation at the time of shipping. The seller shall also monitor Key Characteristic requirements flowed down to it’s sub-tier suppliers in the same manner. Data from monitoring key characteristics from seller sub-tier suppliers shall also be provided to IMPAerostructures.
- IMP014 Upon request form IMPAerostructures Purchasing and/or IMPAerostructures QA representative, the seller shall provide statements of corrective action on failures or non-conformances of seller’s product. All rejected items resubmitted by the seller will bear adequate identification, including reference to IMPAerostructures’s authorized rejection documents.
- IMP015 All time sensitive or date expired materials must have shelf life identified on the product and have at least the minimum time remaining as required by the applicable material specification.
- IMP016 Preference for domestic specialty metals:
(A) Definitions. As used in this clause
(1) “Qualifying Country,” means any country listed in subsection 225.872-1 of the Defense Federal Acquisition Regulation Supplement.
(2) “Specialty metals” means:
(i) Steel:
(a) With a maximum alloy content exceeding one or more of the following limits: manganese, 1.65 percent; silicon, 0.60 percent; or copper, 0.60 percent; or
(b) Containing more than 0.25 percent of any of the following elements: aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, or vanadium;
(ii) Metal alloys consisting of nickel, iron-nickel, and cobalt base alloys containing a total of other alloying metals (except iron) in excess of 10 percent.
(iii) Titanium and titanium alloys: or
(iv) Zirconium and zirconium base alloys.
(B) Any specialty metals incorporated in articles delivered under this contract shall be melted in the United States, its possessions, or Puerto Rico.
(C) This clause does not apply to specialty metals melted in a qualifying country or incorporated in an article manufactured in a qualifying country.
(D) If any article delivered under this order is comprised of or incorporates specialty metals, the contract clause in Federal Acquisition Regulation 52.247-64 (Preference for Privately Owned U.S.-Flag Commercial Vessels) applies and is incorporated herein by reference.

(E) The contractor shall insert the substance of this clause, including this paragraph (e), in all subcontracts for items containing specialty metals.

- IMP017 The supplier shall maintain Quality Records including but not limited Quality and Engineering records/data. The records shall be retained for a period of not less than (10) years from completion of purchase order. Documentation shall not be destroyed without prior permission granted from IMP Aerosturctures. The supplier shall impose this requirement on their sub tiers.
- IMP018 Seller shall establish and maintain a Counterfeit Parts/Material Prevention and Control Plan using AS-5553 (Ref. element of Section 4) and/or AS6174 (Ref. elements of Section 3) to ensure that Counterfeit Work is not delivered to Buyer.
- IMP019 Seller shall have a FOD program that meets the requirements of NAS 412.
- IMP 020 When digital data is provided for Buyer to Seller for Boeing products, Seller must comply to the current requirements of D6-51991, Quality Assurance Standard for Digital Product Definition at Boeing Suppliers.
- IMP021 The Seller shall not “re-grade” any materials that are specified in the drawings, specifications, procedures or purchase order from its original intended use.
- IMP022 Unless otherwise specified, material specifications must be to the revision applicable at the date of the Purchase order.
- IMP023 Boeing has requested suppliers flow down to sub-tiers the requirement of “Acceptance Authority Media” defined as, “medial used to record the status of tasks/operation on product or product records during and upon completion of the development, manufacturing, modification, repair, and support process. Per AS9100 Rev C Section 7.5.3 (...) when acceptance authority media are used (e.g., stamps, electronic signatures, passwords), the organization shall establish appropriate controls for the media.”
- IMP024 FAI requirements are required (must meet AS9102 standards) when included on the PO or when one of these conditions apply:
- 1) First time purchase of unique item number.
 - 2) A change in manufacturing source(s), process (es), location of manufacture, tooling or materials that can potentially affect fit, form or function.
 - 3) A change in numerical control program or translation to another media that can potentially affect fit, form or function.
 - 4) A lapse in production for two year
- IMP025 This is a flow down requirement from Lockheed Martin Aeronautics Company. Documents can be found at:
<http://www.lockheedmartin.com/us/aeronautics/materialmanagement/scm-quality.html>
- Seller is responsible:
- 1) To meet the requirements of the latest revision of Appendix QX and QJ
 - 2) To comply with the engineering specifications and other requirements set forth in note A83. Material shall be procured from approved vendors

Seller shall insure they have:

* IMP unique LM Aero identification number: 100435

* LM Aero unique “process codes” for each Buyer-controlled process to be performed, QCS-001 controlled specifications including revision (Example: 200H: STP58-209 Rev M)

* Clearly defined processing and nondestructive testing requirements including special procedures, inspections, tests and approval criteria as required .

* Program Finish Specification and revision: C-0477 Rev AG

* Processing to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company purchase order and must be accomplished in accordance with process specification(s) on this purchase order and Lockheed Martin Aeronautics Company Appendix QJ

If the Seller uses a sub-tier:

* Seller’s sub-tier must file and maintain a copy of all purchase orders containing the above statement and make these available for review by Buyer, upon request

* Seller’s sub-tier must submit a Certificate of Conformance (“CoC”) with a unique certification number which contains the elements listed in QJ

* Seller shall ensure all Seller sub-tier purchase orders and/or associated purchase order documents for Buyer-controlled processes include the following data elements.

* Seller’s unique LM Aero identification number (“vendor code”),

* All QCS-001 controlled specifications including revision for which processing which will be performed,

* LM Aero unique “process codes” for each Buyer-controlled process to be performed

* Applicable program Finish Specification and revision

* A statement with the words, “Processing to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company purchase order and must be accomplished in accordance with process specification(s) on this purchase order and Lockheed Martin Aeronautics Company Appendix QJ

* A statement to ensure Seller’s sub-tiers suitably wraps, boxes or racks parts to guard against shipping damage and to apply rust or corrosion protection

Company Name: _____

Authorized Signature: _____

Date: _____