



**SUPPLIER QUALITY REQUIREMENTS**

  
Jennifer Becker, Materials Team Leader

  
William Aviles, Quality Manager

Document: SQR-1  
Revision: D  
Date: February 11, 2008  
Supersedes: C

**CHANGE INDEX RECORD**

<u>REVISION</u>	<u>ISSUE DATE</u>	<u>DESCRIPTIONS CHANGES</u>	<u>BY</u>
N/C	06/03/03	Initial Release	D. Woodside
A	6/11/03	Modified purpose	D. Woodside
B	10/21/03	Changed name from GKN Aerospace to GKN Aerospace	D. Woodside
C	10/8/06	Added SPAR 31 to address Digital Product Definition quality requirements. Added SPAR 32 to address FOD supplier flow-down.	W. Aviles
D	2/11/08	<ol style="list-style-type: none"> <li>1. Added general requirements section H through J.</li> <li>2. Added the statement "This right of access is extended to all sub-tier and raw material suppliers" to Gen Requirement Section G.</li> <li>3. Added SPAR-2F</li> <li>4. Added to SPAR 4 Note: A certificate of analysis can be used in lieu of a certificate of conformance.</li> <li>5. Rewrote SPAR-8 FAI requirement to be in line with AS9102</li> <li>6. Changed SPAR-31 to be in accordance with Boeing D6-51991</li> </ol>	W. Aviles

## I PURPOSE

This document establishes requirements applicable to items ordered under the purchase order, of which this form is part, to assure that such items are of the required quality and reliability. It contains General Requirements for product assurance, which is applicable unless expressly excluded in the Purchase Order, and Special Product Assurance Requirements (SPARS), which apply as designated.

## II DEFINITIONS

Purchase Order (PO) means the purchase order, subcontract or other written agreement with the Supplier (supplier) in which this Form is incorporated by reference.

Buyer means GKN Aerospace, a member of the GKN Group acting by and through its division issuing the purchase order.

Supplier means the legal entity, which is the contracting party with the Buyer with respect to the purchase order.

## III GENERAL REQUIREMENTS

Unless otherwise specified in the purchase order, the following requirements apply to this purchase order:

### A. PROHIBITED PRACTICES

1. Unauthorized Repairs: Without Buyer's approval Supplier may not repair by welding, brazing, soldering or adhesive bonding, parts damaged or found to be faulty during fabrication. Defects in castings or forgings shall not be repaired by any method unless authorized by the Buyer in writing.
2. Changes in Approved Processes, Materials or Procedures: Supplier shall not change any process, material or procedure without prior Buyer approval if such process, material or procedure was originally subject to approval by buyer. As to any product which has been subjected to Buyer or Government specified qualification procedures to qualify the product or to permit the Supplier to become a qualified source for the product, the Supplier shall not change any process, material or procedure from that used to qualify without prior notification to Buyer and approval by Buyer or the Government, as appropriate.
3. Improved Re-submittal: Articles rejected by the Buyer and subsequently resubmitted to the Buyer shall be clearly and properly identified as resubmitted articles. Supplier's shipping document shall contain a statement that articles are replacement or reworked and shall also refer to Buyer's rejection document.
4. Unauthorized Submittal of Production Parts: When the purchase order requires Buyer acceptance of a first article, the Supplier shall not submit parts from a production run for Buyer inspection prior to Buyer's acceptance of such first article.
5. Notification of Facility Change: Supplier shall not relocate any production manufacturing and/or processing facilities during performance of the purchase order, without promptly notifying Buyer and affording Buyer an opportunity to examine such facilities for compliance with Quality Assurance requirements, including any necessary approvals.

**B. RESPONSIBILITY FOR CONFORMANCE**

Neither surveillance, inspection and/or tests made by the Buyer or his representatives at either the Supplier's or Buyer's facility, nor the Supplier's compliance with all applicable Special Product Assurance Requirements shall relieve the Supplier of the responsibility to furnish items which conform to the requirements of the purchase order.

**C. DOCUMENTATION**

The buyer may refuse to accept items delivered under the purchase order if the Supplier fails to submit the certification, documentation, test data or reports specified in the purchase order or SPAR's. Documentation includes GKN Aerospace source inspection record when such source inspection is performed.

**D. CERTIFICATION OF COMPLIANCE AUDIT**

Certification furnished under the terms of the purchase order shall be supported by test records and data and are subject to audit by the Buyer.

**E. LOT SAMPLING**

The Buyer reserves the right to use ANSI/ASQC Z1.4 or an equivalent sampling plan for the acceptance or rejection of supplies.

**F. CORRECTIVE ACTION REQUESTS**

When a quality problem exists, the Buyer may request corrective action from the Supplier. Such requests require timely responses and should include the following information. Immediate correction, analysis of the root cause, root cause correction with an estimated completion date (ECD) and corrective action verification plan with ECD. When corrective action is required for Government Source inspected items, the supplier shall coordinate such action with the Government Quality Assurance Representative assigned to his plant.

**G. ACCESS TO FACILITIES**

Supplier must identify those areas, processes, or procedures (without disclosing proprietary information) for which access by Buyer or Government representative is proposed to be restricted. Such identification shall be made in writing to Buyer along with Supplier's quotation or offer to Buyer. If the proposed restricted access involves a supplier not known to Supplier prior to Award of the purchase order, such written identification shall be made as soon as Supplier actively considers award to such supplier. The written identification shall state generally the basis for such proprietary information, and shall include a proposed method of quality control / inspection by Buyer or Buyer's Customer representatives, which Supplier, or the Supplier's supplier, considers acceptable.

The absence of such written identification is a representation by Supplier that all items (including end items), materials, components, and processes are subject to inspection/test and quality control surveillance at all places and at reasonable times prior to acceptance. If such written notification is given, Supplier agrees to negotiate in good faith with Buyer for agreement on an acceptable arrangement for such inspection/test and quality control surveillance.

This right of access is extended to all sub-tier and raw material suppliers.

**H. NOTIFICATION OF NONCONFORMANCE**

In the event a condition is discovered that affects previously delivered product, GKN shall be notified in a timely manner of the condition. Notification shall be in the form of letters address to the attention of GKN Procurement and Quality Assurance Departments. These letters must include all pertinent information concerning the condition (i.e. part numbers, serial numbers, quantities, time frame, description of the condition, etc.) and the corrective action taken to prevent recurrence.

In the event the Supplier requires consideration for concession of nonconforming product, the Supplier must submit a waiver request.

**I. SUB-TIER SUPPLIER CONTROL**

Supplier shall impose requirements comparable to those contained in this document on sub-tier suppliers. This includes key characteristics requirements where applicable. The Supplier shall assure Buyer's right of entry into the sub-tier supplier's facilities.

**J. CONTROL OF QUALITY RECORDS**

The supplier shall establish and maintain control of appropriate quality records to demonstrate conformance of the finished product to specified requirements and the effective operation of the quality system.

Quality records shall be legible and identifiable to the product involved. Quality records that substantiate conformance to the finished product with the specified requirements and the effective operation of the quality system shall be retained for a minimum of 7 year and made available on request.

NOTE: Records may be in the form of any type of media, such as hard copy or electronic media.

**K. PERSONNEL QUALIFICATION**

Supplier shall establish training and qualification policies and procedures necessary to produce products for GKN.

**L. KEY CHARACTERISTICS IDENTIFICATION AND CONTROL**

Supplier and GKN shall jointly identify key characteristics in accordance with ISO 9103 Variation management in Key Characteristics. Supplier shall effectively control variation in each interface key characteristic such that the nominal design/target value is approached. Requirements for control shall include the following:

- a) Identify each Key Characteristic
- b) Identify and document each of the manufacturing processes associated with each identified Key Characteristic
- c) Determine the present manufacturing process capability (Cpk or equiv.) for manufacturing process associated with each identified Key Characteristic
- d) Document process control plan for production manufacturing processes associated with each identified Key Characteristic. This

- includes continuous control over unstable processes to discover and eliminate special causes of defects
- e) Apply Process Variability Reduction Techniques as required for each identified Key Characteristic
  - f) Determine the improved capability for each Key Characteristic. A capability index shall be used to monitor improvements

Definition:

AS9100/EN-9100/JISQ 9100 definition: The features of a material or part whose variation has a significant influence on product fit, performance, service life, or manufacturability.

Key Characteristics for a part, subassembly or system are those selected geometrical, material properties, functional and/or cosmetic features, which are measurable, whose variation control is necessary in meeting Customer requirements and enhancing Customer Satisfaction.

Key Characteristics for a process are those selected measurable parameters of a process whose control is essential to manage variation of part or system Key Characteristics.

Substitute Key Characteristics may be identified when a Customer-defined Key Characteristic is not readily measurable within the production setting and other characteristics may need to be controlled to ensure conformance.

#### **IV SPECIAL PRODUCT ASSURANCE REQUIREMENTS (SPAR)**

The following Special Product Assurance Requirements are part of this purchase order when specified by the SPAR Number in the body of the purchase order.

##### **SPAR-1 BUYER SOURCE INSPECTION**

Items to be delivered under this purchase order require source surveillance by the Buyer's Quality Representative at the Supplier's plant. Sufficient advance notice (two working days for local travel plus travel time for distant location) must be given to the Buyer to permit scheduling of source inspection. Source inspection does not relieve the Supplier of the responsibility for compliance with all requirements of this purchase order. Evidence of Buyer source inspection must accompany or be shown on the shipping documents (see III-C). The buyer reserves the right of final acceptance at Buyer's facility. Items submitted under this clause shall have passed Supplier's inspection.

- A. In-process and/or final inspection or tests are required. Parts, assemblies, processes and tests are subject to detailed inspection by the Buyer's Quality Representative prior to assembly, test and/or delivery.
- B. Final inspection and/or testing is required, by the Buyer's Quality Representative, prior to delivery.

- C. In-process inspection and/or testing is required, by the Buyer's Quality Representative, prior to delivery.

#### **SPAR-2 SUPPLIER'S QUALITY CONTROL SYSTEM**

The Supplier shall maintain a quality system, which complies, as a minimum requirement, with the specification designated below. The Supplier's system shall be subject to an audit by the Buyer's Quality Representative. Waivers to quality system requirements are not valid unless obtained in writing from Buyer's Quality Assurance Representative.

- A. Level 1 – Paragraphs 3.2, 3.3, 3.4, 3.7, & 3.8 of MIL-I-45208, as applicable to product manufacture.
- B. Level 2 – MIL-I-45208
- C. Level 3 – The Supplier shall institute and maintain a quality system to assure the integrity or product traceability, certification, test / inspection documentation, storage condition and protection during shipment. The system shall provide for adherence to, and flowdown of the buyer's quality assurance requirements.
- D. Level 4 – The Supplier's quality system shall demonstrate that processes are controlled and products are tested in accordance with the applicable processing specification.
- E. Level 5 – ANSI/ASQC Z540.1.
- F. Level 6 - SAE ISO 9000 / AS9100, "Quality Management Systems – Aerospace – Requirements" Supplier is required to maintain a certified / registered Quality System in compliance with SAE ISO 9000 / AS9100, "Quality Management Systems – Aerospace – Requirements", as may be amended from time to time. GKN ATS reserves the right to conduct surveillance at Supplier's facility to determine that Supplier's Quality System meets the requirements as set forth herein. A copy of SAE ISO 9000 / AS9100 can be obtained from the Society of Automotive Engineers at the following URL: <http://www.sae.org>

#### **SPAR-3 CHEMICAL AND PHYSICAL ANALYSIS**

The Supplier shall submit a report as indicated below (actual or typical) with each lot of material shipped. In the case of a "drop shipment" to other than Buyer's plant, a copy of the report shall also be submitted direct to Buyer, together with a copy of the packing slip, at time of shipment.

- A. Actual Values Test Report-The test report shall list actual test results obtained from an analysis of representative samples of each lot of material used to fill this order.
- B. Typical Value Test Report-The test report shall list the range of values within which the properties of material used to fill this order fall.

#### **SPAR-4 CERTIFICATION OF CONFORMANCE**

- A. With each shipment of items covered by this purchase order, Supplier shall submit a certificate of conformance, signed by a responsible representative, which shall constitute a representation by the Supplier that:
1. Materials used are those which have been specified by Buyer, and that the items delivered were produced from materials for which Supplier has reports of chemical or physical analysis and any other required evidence of conformance to applicable specifications.
  2. Processes used in the fabrication of items delivered were in compliance with applicable specifications.
  3. The items as delivered comply with all specifications and other requirements of this purchase order.

In case of drop shipment, a copy of the above certificate shall be submitted direct to Buyer at time of shipment.

**Note:** A certificate of analysis can be used in lieu of a certificate of conformance.

- B. **SPAR 4B supersedes SPAR 4A when referenced in the body of the Purchase Order.** With each shipment of items covered by this purchase order, Supplier shall retain a certificate of conformance, signed by a responsible representative, which shall constitute a representation that the Supplier supplied materials used and the processes applied to the articles comply with the applicable drawings and specifications. The Supplier agrees to retain objective evidence, including the aforementioned certificate of conformance, material certifications, records of the inspections and tests performed in the course of manufacturing, testing, preserving, and packaging of said articles for a period of 7 years unless otherwise specified. These records shall be made available to Buyer for review upon request.

#### **SPAR-5 GOVERNMENT SOURCE INSPECTOR**

Government inspection is required prior to shipment from Supplier's plant. Upon receipt of this purchase order, Supplier shall promptly notify the Government Representative who normally services Supplier's plant. In the event that appropriate planning for Government Inspection cannot be arranged, the Buyer should be notified immediately. Buyer may designate this clause as applicable after award of this purchase order, without change in price or schedule, even though this clause was not designated as applicable at time of award. Likewise deletion of this clause after award shall not entitle Buyer to a reduction in purchase order price.

#### **SPAR-6 SERIALIZATION**

With each shipment, the Supplier shall submit a legible copy listing all serialized parts and assemblies by part number with the serialized end item shipped. No two parts having the same part number (under this purchase order or any other purchase order) are to be identified with the same serial number unless otherwise specified. The Supplier must maintain records identifying the serial numbers of serialized subassemblies contained in deliverable end items. Note: When conflict between this SPAR and the drawing or specification exists, the drawing or specification takes precedence.

- A. The serial numbers to be assigned by part number are included with this purchase order.

- B. The supplier shall assign serial numbers to those parts, assemblies and end items required by this purchase order or the part drawing/specification to be serialized.

**SPAR-7 INSPECTION/TEST REPORT**

Supplier shall submit with each shipment a report for the delivered end items or assemblies with the following information included as a minimum: part number, revision letter, nomenclature, purchase order number, lot number, lot quantity, inspection sample size, characteristics/parameters inspected and/or tested, inspection/test data, quantity passed/rejected by characteristics, date of inspection/test, and signature/stamp of Supplier's inspection/test representative. If Go/No-Go test method is used, test program must be identified. In case of drop shipment, a copy of the report shall be submitted direct to Buyer at time of shipment.

**SPAR-8 FIRST ARTICLE INSPECTION (FAI)**

First Article Inspection (FAI) shall be performed by the Supplier. The FAI will be conducted in accordance with SAE AS9100 and SAE AS9102, Aerospace First Article Inspection Requirement, (or international equivalent). When documenting the FAI, the Supplier may use the forms contained within AS9102, or equivalent forms so long as they contain the minimum information required by AS9102. A copy of AS9102 can be obtained through the Society of Automotive Engineers (SAE) at the following web site address: <http://www.sae.org/>. Note: All FAI /Delta (re-accomplishment) must also be in accordance with AS9102. The Supplier shall provide documentation per the following:

The Supplier's requirement is required to:

- A. After completing the FAI in accordance with AS9102, the Supplier shall submit the completed first article part and report to the Buyers quality assurance representative for first article verification at the supplier's facility.
- B. After completing the FAI in accordance with AS9102, the Supplier shall submit the completed first article part and report to the Buyer's Receiving Inspection department for first article verification at the Buyers facility.
- 8B-Note: The Supplier shall also provide to the buyer for all FAI/Delta a copy of the "bubbled" Drawing including (1) FAI corresponding part to the buyer's Quality Assurance representative for FAI/Delta verification.

**SPAR-9 SUPPLIER SUPPLIED INFORMATION**

With the initial shipment, the Supplier shall furnish at no cost to the Buyer two legible copies of applicable specifications, drawings, and/or catalogs or catalog page(s) sufficient to inspect and/or test the product(s) specified in the purchase order.

**SPAR-10 PRODUCT CHANGE APPROVAL**

The Supplier shall not make any changes in product design, composition, configuration (including form, fit, function, or interchangeability), material, fabrication or processing, Supplier's supplier(s), place of manufacturer, or outside processing without prior written approval from the Buyer. Supplier shall flow down this requirement to Supplier's suppliers.

**SPAR-11 AGE CONTROL**

The Supplier shall have an effective system of control of items whose acceptability is limited by age of the item. The system must include a method of identifying the age of such items and provisions for the rotation of stock. Age control of rubber goods shall conform to the requirements of MIL-STD-1523 unless otherwise specified in the purchase order.

- A. Supplier shall indicate on the containers or certifications those materials having a limited or specified shelf life. The information provided shall include expiration date(s), lot or batch number as required, and any special storage and handling conditions as may be applicable. This information shall be in addition to the normal identification requirements for each container, name, part or code number, size, quantity, etc.
- B. Time lapse between cure or manufacturing date and date of scheduled receipt by Buyer under the Purchase Order shall not exceed one-third of the shelf life for the material without prior written waiver of Buyer as to each shipment.

**SPAR-12 NOTIFICATION OF PRODUCT CHANGE**

Prior to delivery, Supplier shall notify the Buyer of any significant changes in product design, fabrication methods, material or processing from those used by Supplier at time of Supplier's quotation or offer to Buyer which resulted in the Purchase Order. [Refer to SPAR-10]

**SPAR-13 GOVERNMENT REVIEW OF QUALITY CONTROL OF INSPECTION**

The Supplier's Quality Control of Inspection System and manufacturing processes are subject to review, verification and analysis by authorized Government Representatives upon request.

**SPAR-14 REPORT OF DISCREPANCY FOR BUYER MATERIAL REVIEW**

A discrepancy report is to be initiated by the Supplier for any departure from drawings, specifications or other purchase order requirements and must adequately describe such departures, including a complete description of the cause and corrective action taken to preclude recurrence. The discrepancy report shall be submitted to the Buyer's Purchasing Department, which will arrange for material review. A copy of the discrepancy report will be returned to the Supplier, showing the action taken by the Material Review Board. Supplier shall not ship a discrepant item reported on a discrepancy report without Buyer's concurrence. The Supplier shall reference the serial number or date of the discrepancy report on each shipping document that covers items on the discrepancy report. Items shipped on a discrepancy report must be segregated from other items to permit separate identification to be maintained. The supplier may submit discrepant material on GKN Aerospace Form QFM 9067. Supplier may request the form from the Buyer purchasing representative.

**SPAR-15 FOUNDRY CONTROL OF CAST PARTS**

Foundry control castings are required when new tooling (patterns or molds) is made, when a change is made in gates, risers, chills, or as-cast shape, or when a pattern is

transferred to a different supplier. Foundry control castings shall be submitted to the Buyer for review and approval, as required below, prior to initiation to continuation of production. Foundry control castings are in addition to purchase order end item quantity requirements.

- A. Radiographic film of foundry control castings and test report shall be reviewed and approved by the Buyer's Quality Representative at the Supplier's radiographic department or agency. Applicable film and test reports will accompany foundry control castings delivered to Buyer.
- B. Supplier will deliver to Buyer a minimum of one foundry control casting, heat treated and straightened to the casting drawing requirements, for examination and approval by the Buyer. Such casting(s) shall be representative of the foundry practices and processes to be used for the production castings.
- C. Supplier will submit a certified statement of the test bar mechanical properties with each foundry control casting. The test bar(s) must be from the same melt and heat treat as the foundry control casting.
- D. Supplier will submit a certified statement of chemical analysis of the material in the foundry control casting showing the percentage of each element contained in the specimen.
- E. Radiographic film of foundry control castings and test report shall accompany such castings when delivered to the Buyer for review and approval at Buyer's facility.

#### **SPAR-16 CONTROL OF NONDESTRUCTIVE TESTING (NDT)**

Items requiring NDT shall be submitted, complete with part drawing or document establishing NDT requirement, to a laboratory acceptable to Buyer. Test results shall be reported in writing to the Buyer, identifying the laboratory and the certified technician who performed and/or evaluated the tests, signed by a responsible laboratory representative. An adequate method of identifying and cross-referencing each x-ray film exposure, report and item must be provided. When parts are serialized, serial numbers must appear on the report and film with the control number.

- A. Minimum radiographic requirements are included in this purchase order on attached sketch.
- B. Radiographic film of each lot and other NDT results, including foundry control NDT, shall be inspected by the Buyer at the laboratory performing the work prior to shipment. The Supplier shall notify the Buyer when the film is ready for review.
- C. NDT reports shall be submitted with each shipment to the Buyer and shall include x-ray film when radiographic inspection is required.

#### **SPAR-17 CONTROL OF SPECIAL PROCESSES**

The Supplier must be approved by the Buyer to perform required special processes or must use special process suppliers acceptable to Buyer. A list of such suppliers will be provided upon request. If the Supplier wishes to use suppliers not on such list, he should request authorization from the Buyer prior to commitment to an unlisted supplier.

Certification by a responsible representative of the Supplier shall be included with each shipment. Certificate shall indicate all special processes performed, applicable specifications (including class, type, grade, etc.) and the name of the special processor(s).

Special Processes:

- Castings/Forgings
- Plating
- Heat Treating
- Metal Joining
- Surface Finish/Coating/Treatment
- Testing (NDT Chemical Environment, etc.)
- Adhesive Bonding and Plastic Fabrication
- Printed Wiring Board Fabrication
- Other, specified as: \_\_\_\_\_

**SPAR-18 CONTROL OF FORGINGS**

- A. The Supplier shall furnish the Buyer a sample test forging from the first production run for destructive qualification testing that is representative of all processing used. This test forging is in addition to the production quantities required.
- B. With each shipment, the Supplier shall submit two test samples from each heat of material used in the shipment. The samples shall be suitable to make specimens conforming to R-3 of Federal Test Standard No. 151 and be subjected to the same processing the production forgings receive including working and heat treatments.
- C. The forgings shall be made with a detachable tab. The tab shall not be removed until completion of all processing including heat treatment. The tabs shall be removed and shipped with the forgings to the Buyer. The tabs shall be identified to material heats and heat treat lots, and shall include serial numbers when serialization is required.

**SPAR-19 INSPECTION AND TEST PLAN**

The Supplier shall prepare an inspection and test plan for the items delivered under this purchase order. Two reproducible copies of the plan shall be submitted for Buyer approval a minimum of thirty days prior to production.

- A. The plan shall include identification of the item to be inspected or tested, measuring or test equipment to be used, method of inspection (visual, test equipment, gage, etc.) and type of inspection (dimensional, functional, test, NDT, etc.).
- B. The plan shall contain the operational sequence and inspection/test points in relation to procurement, manufacture, assembly, checkout, and delivery.

**SPAR-20 IDENTIFICATION**

- A. Apply part number and revision letter per applicable drawing note.
- B. Bag and tag parts.
- C. Tag parts.

- D. Identify per PO instructions and requirements.
- E. Identify parts in accordance with MIL-STD-130 (latest revision as of the date of purchase order issuance).

**SPAR-21 TEST SAMPLES**

The Supplier shall furnish to the Buyer the test samples required by this purchase order. The samples shall be identified as "Test Samples" with applicable part number. The test samples shall be processed simultaneously with each batch or lot of parts. Supplier's shipping document shall indicate part number, process, processor, batch / lot number.

Test samples are required for following special processes:

- A. Case Hardening.  
(Nitriding, carburizing, induction hardening, flame hardening, tuftriding, etc.)
- B. Heat Treat.
- C. Plating.
- D. Other, as specified \_\_\_\_\_

**SPAR-22 LOT CONTROL AND MATERIAL TRACEABILITY**

- A. Items furnished under this purchase order, packing list, certifications and other applicable documents must be identified by manufacturing lot or batch number. Where impractical to stamp individual parts due to size or shape, the lot or batch number shall be stamped on identifying tags or the smallest unit package.
- B. Materials used must be identified by lot number, material type, specification and applicable change number, heat number, etc., and traceable to the lot number(s) of material(s) used. Traceability records shall be available for review by the Buyer's Representatives.

**SPAR-23 TOOL PROOFING**

Tooling required for production under this purchase order is subject to acceptance by the Buyer. The Supplier shall notify Buyer when tooling is ready for inspection. Acceptance will be contingent upon a quantity of resultant dimensional samples inspected under surveillance of the Buyer's Representative at the Supplier's facility or the items will be shipped to Buyer for inspection when directed by the Buyer. Dimensional samples are to be identified with the tool number from which they were manufactured.

**SPAR-24 DROP SHIPMENTS**

The material ordered hereunder is to be shipped to other than the Buyer's facilities. Copies of the Product Assurance data required by this order shall accompany the shipment; in addition, one copy of such data and a copy of the Shipping Document shall be mailed to the Buyer on the same day that shipment is made.

**SPAR-25 SPECIAL PROCESS DOCUMENTATION**

Supplier shall promptly submit, for Buyer approval, those specific procedure(s), identified in the purchase order, which are to be used in manufacture of each differently numbered part to be delivered under this purchase order. Such Buyer approval is required prior to production.

**SPAR-26 ACCEPTANCE TEST PROCEDURE**

Supplier shall prepare an acceptance test procedure for the items to be delivered under this purchase order, to include, as a minimum, the equipment, sequences, and steps necessary to perform the acceptance test. The procedure shall contain a requirement for recording the following data: part number, part name, revision letter, purchase order number, serial/lot number, sequence number, criteria measured or tested, test results, test data, and signature of Supplier's Inspection Representative. Two reproducible copies of the acceptance test procedure shall be submitted for Buyer's approval at least thirty (30) days prior to performance of the initial acceptance test. Any subsequent change to the acceptance test procedure requires prior approval of Buyer's Quality Assurance representative.

**SPAR-27 TEST EQUIPMENT CERTIFICATION**

All equipment used for acceptance testing of deliverable products under this purchase order shall be certified by the Buyer (or the cognizant Government agency) prior to use.

**SPAR-28 CONFORMITY CERTIFICATION**

Supplier shall issue an FAA Form 8130-3, completing Blocks 14 through 18, and certifying the parts conform to the Design Data and are in a condition for safe operation.

**SPAR-29 AIRWORTHINESS CERTIFICATION**

Supplier shall issue an FAA Form 8130-3, completing Blocks 19 through 23, and approving the parts for Return-To-Service.

**SPAR-30 CERTIFIED SUPPLIER**

Supplier shall perform inspection and complete documentation in accordance with GKN Aerospace's Quality Assurance Procedure QAP-917.

**SPAR-31 DIGITAL PRODUCT DEFINITION QUALITY PLAN**

Supplier shall implement a Digital Product Definition (DPD) Quality Assurance Plan in accordance with Boeing D6-51991 Quality Assurance Standard for Digital Product Definition at Boeing Suppliers. Supplier shall obtain a copy of D6-51991 from the GKN Buyer. GKN ATS reserves the right to conduct DPD Compliance Audits at Supplier's facility to determine that Supplier's DPD system meets the requirements as set forth in D6-51991.

Supplier shall provide GKN Aerospace with their DPD Quality Assurance Plan for review and approval.

Supplier shall provide access to their process to GKN and GKN customers to ensure configuration control and conformance to their DPD Quality Assurance Plan.

**SPAR-32 FOREIGN OBJECT DEBRIS/DAMAGE (FOD) PROGRAM**

Supplier shall implement a Foreign Object Debris/Damage Program to establish general workmanship practices for the prevention and elimination of Foreign Object Debris/Damage (FOD) to GKN ATS supplied products.