



AVIBANK
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 AEROSTRUCTURES DIVISION, A PCC COMPANY

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REV	DCO #	REV DATE	DESCRIPTION OF CHANGE	APPD BY
A	NA	8/23/12	Updated to new format, re-sequenced clauses, added Clause Q25, Q26 & Q27	LK
B	NA	1/27/14	Revised Clause Q2 to add NADCAP; revised Clause Q24 to change obsolete reference and add new DFAR requirements; revised Clauses Q25 and Q26 to clarify requirements, revised Clause Q27 to encompass all suppliers.	LK
C	NA	4/26/14	Added Clause Q28 to cover ITAR/EAR compliance	LK
D	NA	01/29/18	Added requirement for Rev D 8.3.1m to Q1. Updated Q27 and Q11	AF



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Q1 – QUALITY MANAGEMENT SYSTEM

Supplier shall maintain a Quality Management System certified to or compliant with AS9100, ISO9001 or NADCAP requirements (exclusion small disadvantage businesses). Suppliers to Avibank recognize their contribution to product or service conformity, their contribution to safety and the importance of ethical behavior. A Quality Management System is required to perform any work for this Purchase Order. Avibank Mfg., Inc. shall approve your quality system through desktop or on-site quality audits performed by authorized Avibank Mfg., Inc. Quality personnel.

Q2 – APPROVAL OF PRODUCTS, PROCESSES AND EQUIPMENT

Certified processes specified on Avibank drawings must be performed by sources listed on the Avibank Approved Supplier List. Suppliers performing certified processes (Heat Treating, Plating, NDT, etc.) on product manufactured by your company for Avibank Mfg., Inc. must use an Avibank Mfg., Inc. approved supplier. If the supplier must be approved under other credentials, (i.e. NADCAP, Boeing, Sikorsky, Lockheed Martin approved source) that requirement shall be clearly listed in the body of the purchase order. At times, it may be required that a certified process must be performed by a sole source of supply for the listed specification on the Purchase Order to your company. In these cases, only the specified processor or, processor approved to perform that process to the listed specification will be allowed to perform that process.

Q3 – IDENTIFICATION AND REVISION STATUS

The product being manufactured and / or service being performed must be performed to the latest revisions of drawings, specifications or process requirements. This includes and inspection/verification instructions and other relevant technical data. At no time will other revisions be used other than what is indicated in drawings or Purchase Orders without the express, written permission of an authorized Avibank Mfg., Inc. representative.

Q4 – RIGHT OF ENTRY

Avibank Mfg., Inc. requires right of access by the organization, their customer and regulatory authorities to the applicable areas of all facilities, at any level of the supply chain, involved in the order and to all applicable records.

Q5 – NOTIFICATIONS

Supplier shall not use, nor relocate, any Avibank-approved production, manufacturing, testing, or process facilities during performance of the work specified in the procurement document. Supplier shall notify Avibank's Purchasing Dept. in writing when a significant change in management or ownership has occurred. Supplier shall notify the listed Avibank Department in writing when any of the following items occur:

- notify the Quality Department of nonconforming product upon discovery after shipment
- obtain written approval from the Quality Department for nonconforming product disposition if a concession is requested
- notify the Purchasing Department of changes in product and or process, changes of suppliers, changes of manufacturing facility location and obtain Avibank's written approval of the change prior to implementation.



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Q6 – RECORDS RETENTION

Avibank requires all suppliers to maintain all records for a period of no less than ten (10) years unless otherwise stated on the Purchase Order. All records dealing with Flight Safety, Maintenance Critical or Flight Critical parts shall be retained for a period of not less than fifty (50) years or as stated specifically on the Purchase Order. Before any records are destroyed, Avibank shall be given the option to take possession of such files.

Q7 – FLOW DOWN REQUIREMENTS

Avibank shall flow down to the supply chain the applicable requirements, including their customer requirements, in the main body of the Purchase Order. In the use of a Long Term Agreement (LTA), the flow down requirements may be added as additional notes within the body of the LTA or as an addendum attached to the original contract. Seller and its subcontractors will comply with any and all mandatory flow down clauses, including but not limited to, configuration management requirements, design changes, etc., whether pursuant to a U.S. government contract or otherwise, applicable to Buyer for Goods that are the subject of any Avibank Purchase Order.

Q8 – CERTIFICATE OF COMPLIANCE/CONFORMANCE (C of C)

A Certificate of Compliance/Conformance (C of C) shall accompany all shipments. The C of C must be signed by an authorized representative and reflect all Avibank Purchase Order information necessary to identify the product, quantity, current revisions, and what services or processes you have performed. If products are serialized, the applicable serial numbers shall also be listed. When products from the supplier are materials with a limited shelf life, the supplier shall include the expiration date of the materials used and batch identification on the required certifications. When more than one raw material heat lot is presented to Avibank, the supplier shall list the number of parts produced under each heat lot separately on the packing list/shipping document and the C of C. These may be listed as separate line items or as a breakdown in the description of the process or service performed. Heat lot number and quantity of parts shall be clearly marked on each container.

Q9 – FOREIGN OBJECT DAMAGE/DEBRIS - FOD

All parts provided by the Seller must be free of Foreign Object Damage or Foreign Object Debris (FOD). This includes, but is not limited to, any possible damage from the manufacturing environment, handling damage; unknown/unwanted items left in or on a part, packaging, etc. Supplier shall have a FOD Prevention program in place. All parts shall be protected prior to shipping from your facility, as applicable to commodity being shipped. Parts must be returned in the original containers they came in. Depending to the process your company is performing, additional protection may be required by your facility to prevent damage to services or processes you have performed, as applicable. The parts shall be handled to prevent scratches, nicks and dings, or other type of surface damage. Media such as butcher paper, plastic netting, bubble wrap, or other positive protection may additionally be required by your facility. Use of newspaper is not allowed due to the corrosive nature of the ink.



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Q10 – INSPECTION CRITERIA LOT TRACEABILITY

Unless otherwise directed by Avibank Mfg., Inc. Quality Department, a sampling plan for the inspection of product may be used. ANSI/ASQ Z1.4 Level II – AQL 1.0 may be used except “C” Must = 0 (no defects allowed, reject on 1). Otherwise, all parts shipped to Avibank shall be one hundred percent (100%) inspected. In certain instances, sampling plans may not be permitted, such as flight critical dimensions. Lots may not be commingled and must be segregated and identified. Shipments shall consist of no more than two (2) manufacturer's lots for each part number included in an order. No quantity of a single manufacturer's lot may represent less than 20 percent of the total quantity per shipment unless otherwise specified on the purchase order. A production lot shall consist of parts which are all the same configuration fabricated from the same conditions and material, processed (including heat treat) together and produced as one continuous run. This includes ensuring that the lots are kept separate for any processing outside the vendor's facility. Containers shall be identified with the material heat lot number for clarity. A casting, forging, machined part or stamping lot consists of the same part number, of one alloy, produced using the same processing parameters, including heat treat, and contains a homogeneous heat pour, or the same basic material. A plating lot (cadmium, anodize, chemical milling, etc.) shall consist of treated articles on the same order, treated under the same conditions, from the same chemical composition and from the same tank. A coating lot (paint, dry film lube, etc.) shall be processed as one batch, on the same part and on the same order. A batch is defined as the end product of all the raw materials mixed or blended in a single or continuous operation.

Q11 – CERTIFICATIONS / TEST REPORT REQUIREMENTS

When this clause is attached to the purchase order the supplier must provide the mill or foundry test reports for both chemical and mechanical testing per the material specification and each identified to the heat lot shipped. When multiple lines or PO's are shipped to Avibank a single report for each must be furnished and segregated from each other. If the material has been shipped to another customer / supplier prior to the shipment from the seller a chain of custody is required to be furnished. This can be a copy of a packing slip showing shipment to / from the mill or foundry to the customer and the customer to your facility along with the supplier to Avibank. Lot numbers must be present for traceability showing the transfer of the heat lot from each supplier. When material is provided by Avibank, the supplier must ensure that a statement is included on the shipment certification and or shipper identifying “Avibank Mfg., Inc. Supplied Material” and reference the Avibank Mfg., Inc. material lot number. When products from the supplier are materials with a limited shelf life, the supplier shall include the expiration date of the materials used and batch identification on the required certifications. Special process certifications must reflect all Avibank Mfg., Inc. Purchase Order requirements including specification numbers, revisions, quantities, serial numbers processed, types, and any other information necessary to substantiate the process performed.

Q12 - AVIBANK MFG., INC. PROVIDED MATERIAL / PRODUCTS

Raw Material or products (assembly items, component parts, hardware, tooling, fixtures, etc.) have been provided with our order to you. Avibank supplied Items were listed on our Purchase Order and included with our shipment to you or, have been drop shipped by an Avibank supplier to your facility. You are required to verify any Raw Material or products through your normal receiving inspection system. This includes verifications of (but not limited to) raw material



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Chemical and physical certifications, dimensional and visual requirements, damage, FOD (Foreign Object Damage), configurations, expiration dates, calibration due dates, types, Classes, and any other identifying information to assure that Avibank Mfg., Inc. supplied products are as required in order to complete the products or services you are providing. For Raw Material provided by Avibank Mfg., Inc. and drop shipped to your location, **all certifications shall be first confirmed and accepted by Avibank Mfg., Inc. prior to any work starting.** You shall contact the Avibank Purchasing Department for an “OK to Begin Work” to verify that raw material certification verifications have been completed.

Q13 – FIRST ARTICLE INSPECTION (FAI/FAIR)

A First Article Inspection is required on this Purchase Order. Requirements when to generate a FAIR and how to complete is defined within AS9102. The First Article must be documented per AS9102 on AS9102 forms. You may use your own form provided it replicates the same format and information as AS9102 forms 1, 2 and 3. The First Article Report shall accompany the first shipment. The First Article Part must be identified (tagged) as “First Article Part”.

Q14 – AVIBANK SOURCE INSPECTION (ASI)

Avibank Mfg., Inc. source inspection is required prior to shipment. The supplier shall contact the Avibank Purchasing Department to coordinate scheduling of source inspection. Contact must be made at least 48 hours in advance of shipment.

Q15 – GOVERNMENT SOURCE INSPECTION (GSI)

Government source inspection (GSI) is required prior to shipment from your facility. On receipt of this order, promptly furnish a copy to the government representative who normally services your plant, or, if none, to the nearest Army, Navy, Air Force, or Defense Supply agency inspection office. In the event the representative or office cannot be located, our purchasing agent shall be notified immediately. Evidence of government source inspection must be included with each shipment.

Q16 – STATISTICAL PROCESS CONTROL (SPC)

Statistical Process Control is required on this order. The supplier must identify on a test report the characteristic and the CpK value achieved at a minimum. The supplier upon request from Avibank will submit SPC charting information in accordance with Purchase Order instructions on the identified Key Characteristic. SPC performed per this quality note must have a CpK of a minimum 1.33. If the CpK falls below the 1.33 threshold, the supplier must perform 100% inspection of the key characteristic and submit that information along with the discrepant SPC data.

Q17 – WORKMANSHIP REQUIREMENTS

The machined surface shall be free of scratches, chatter marks, tool marks, nicks or dings (verification is made using a 0.025 stylus), if the stylus “bumps, stops or hangs on the area it is considered non-conforming. A curved, radius or diameter surface shall achieve a minimum finish of **63 RHR** unless otherwise specified on the drawing. Concentricity shall not exceed a maximum **0.010 TIR**, unless otherwise specified on the drawing, and the radius shall be full and complete in form. Normal forming marks are allowable within 0.003 unless otherwise specified on the drawing. Laser cutting start and stop points shall be controlled off the contour of the part



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To leave no gouge or burr on the surface. No cracks or tears are permitted. Hole dimensions shall apply to the pierced side of the parts unless specified otherwise. On Forgings or Castings, all gates, witness marks and flashes shall be reduced to within the drawing dimensioned tolerance and less than 0.010 unless otherwise specified on the drawing and hold a maximum surface finish of **250 RHR**.

Q18 – GRAIN FLOW

Grain flow direction is a requirement of this Purchase Order. Control of grain flow direction as noted on the drawing is a requirement. The supplier shall certify to the grain flow direction of the parts produced. If there are any questions or concerns, contact the Avibank Purchasing Department for resolution before accepting the order or proceeding with manufacturing the product.

Q19 – FRACTURE CRITICAL / FLIGHT SAFETY

100% inspection is required on all flight safety products no sampling allowed. The supplier shall comply with the requirements of all Flight Safety and or Fracture Critical designated products. Changes in sequencing of manufacturing or any other substitution is not allowed. The supplier shall follow all instructions without deviations unless written permission by authorized Avibank Mfg., Inc. representative is given. The words "Flight Safety" and or "Fracture Critical" must appear on all certifications, shippers, pack lists, and inspection documentation.

Q20 – INSPECTION CHECK FIXTURE (ICF)

Avibank Mfg., Inc. has provided inspection check fixtures that shall be used for product acceptance for those features only. Any other use must be authorized in advance by Avibank Mfg., Inc., in writing. The use of the acceptance check fixture does not absolve you from assuring all dimensions and requirements are produced to drawing and specification requirements.

Q21 – DIGITAL DATA

Digital media or data has been provided with this order. The supplier is required to follow the requirements of the purchase order.

Q22 – X-RAY

When x-ray is a requirement by the drawing, x-ray film and x-ray inspection report shall be included with every shipment.

Q23 – FAA "STATEMENT OF CONFORMITY"

Products on this order are subject to mandatory Federal Aviation Administration (FAA) conformity inspection verification. Supplier shall notify Avibank at least 48 hours in advance if conformity is to be performed on supplier premises. When this conformity inspection is performed at supplier's facility, Avibank will complete FAA form 8130-9 "Statement of Conformity" and notify the appropriate FAA representative. After completion of the FAA conformity inspection verification, supplier shall include one copy of FAA form 8130-3 with each conforming part shipped as evidence of inspection. These forms may be provided by Avibank purchasing department, if desired.



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Q24 – SPECIALTY METALS

Material supplied must be in accordance with Domestic Specialty Metals Regulation DFARS 252.255-7008 and 252.255-7009, with Qualifying Countries per DFARS 225.872.1 (reference DFARS 252.225-7014, Alternate 1, superseded). The country of origin must be declared on the certification.

Q25 – LOCKEED MARTIN ORDERS

Purchase orders identified as having Lockheed Martin as the end customer shall comply with all provisions of Appendix QX and Appendix QJ, latest revision and NADCAP certification at a minimum. The LMCO Process Code, Avibank Supplier number and Supplier's LMCO number shall be on all certifications. Avibank's supplier number is 106042.

Q26 – LOCKEED MARTIN RAW MATERIAL ORDERS

Purchase orders identified as having Lockheed Martin as the end customer shall supply raw materials using a qualified LMCO source verified in Engineering Materials & Approved Products (EMAP), LMAD0006, as revised.

Q27 – COUNTERFEIT PARTS or MATERIALS PREVENTION

This purchase order requires compliance with AS5553 or AS6174 Counterfeit Parts/Materials Prevention Program. Any parts or material received under this program are subject to verification by Avibank and any suspect parts shall be processed per Avibank internal procedures and returned to the supplier identified as suspect or counterfeit material. It is the supplier's responsibility to ensure material is not re-introduced to the industry until origin is 100% identified as not a suspect or counterfeit product. Avibank will not accept that lot of material in any future shipment regardless of origin.

Q28 – ITAR/EAR COMPLIANCE

This Purchase Order, as well as documents attached to and or provided under this Purchase Order, contain technical data, the use of which is restricted by the US Arms Export Control Act. This data has been provided in accordance with, and subject to, the limitations specified in paragraph 126.5 of the International Traffic in Arms Regulations (ITAR) and or Export Arms Regulations (EAR). By accepting this data, the consignee agrees to the requirements of the ITAR and or EAR. All provided data information shall be returned to Avibank Mfg., Inc. after the quotation process or contract duration.