



Supplier Quality Flow-Down Requirements

Supplier Instructions: Review your Purchase Order for any “PQC” clauses listed below. Failure to comply with the imposed clauses could result in rejection by PCL LLC (Precision Components)

Receiving Inspection: Any questions regarding these clauses should be directed to Travis Erickson, travis@pcl-llc.com

- PQC 1 CERTIFICATIONS REQUIRED:** A certification is required for all Special Processes with applicable specification and revisions. A Certification of Conformance (C of C) is required, stating that all products or services as applicable meet or exceeds all requirements of the Purchase Order or contract. The certificate must list the following at a minimum: Title and specification number including the revision of the process, name and address of the certifying facility, buyers assigned processor number (if applicable), date the “C of C” was issued, Purchase Order, Part Number, quantity being certified, including quantity being rejected, signature and title of authorized quality representative of seller, and fracture durability classification or serialization when required. List all of the drawings and/or specifications that formed the Purchase Order, as well as the amendment revision level of each document named
- PQC 2 CHEMICAL AND PHYSICAL TEST REPORTS:** Are required with each shipment, which states the specific results of the Material Tests, Showing that the material meets all specifications.
- PQC 3 GOVERNMENT SOURCE INSPECTION:** GSI is required at your facility. Contact the Government representative that normally services your plant immediately upon receipt of this Purchase Order or contract. Notify PCL LLC purchasing / Quality Assurance when inspection has been coordinated. Letter of delegation to be sent by customer who is requesting Government Source Inspection.
- PQC 4 CUSTOMER SOURCE INSPECTION:** CSI is required at your facility. Contact PCL LLC. Quality Assurance Department at least 72 hours prior to the product being ready for inspection. PCL LLC Quality Assurance Department will coordinate the required inspection by PCL LLC customer or regulatory agency.
- PQC 5 SPECIAL PROCESSING SUPPLIER / NDT SUPPLIER REQUIREMENTS:** Qualified Products, Qualified Personnel, Process Control, Control of Records, Indication of Inspection Status and adequate Work Instructions. Any change of approvals, Nadcap, Boeing, etc. contact PCL LLC by e-mail within 72 hours.
- PQC 6 AGE-SENSITIVE MATERIAL:** Certifications to include specification number date of manufacture, and batch / lot number and recommended shelf life.
- PQC 7 MATERIAL SAFETY DATA SHEET:** (MSDS) are required with shipment of all applicable controlled materials.
- PQC 8 100% INSPECTION:** Inspection is required with actual recorded results, for all characteristics on all parts to ensure conformance to drawing and specification requirements. A copy of this inspection record is required with the shipment of product. Sampling inspection is acceptable with an approved sampling plan for surface treatment.
- PQC 9 INSPECTION REPORT REQUIRED:** Showing documented evidence of inspection and verification of all dimensions with actual results by your quality department (Inspection report should show variance of dimensions measured or results of measurements from an acceptable sampling plan). This shall be included with shipment of product.
- PQC 10 CONTRACT / DRAWING DIRECTED SOURCE / QUALIFIED PRODUCT LIST:** This item / service is to be procured from a listed source.
- PQC 11 ROCKWELL HARDNESS / ELECTRICAL CONDUCTIVITY TEST:** Verification as applicable and certify with results per heat treat or other specifications.
- PQC 12 SERIALIZATION:** Requirements are imposed. All parts have unique serial numbers assigned. Maintain S/N Traceability at all stages of manufacturing or processing. Indicate S/N's on all certifications, shipping reports and/or documents.
- PQC 13 PCL LLC FURNISHED DOCUMENTS:** All Drawings, Specifications, Mylar's, or related data is to be returned upon completion of the Purchase Order or contract.
- PQC 14 TECHNICAL OR PROPRIETARY DATA:** All data provided to support manufacturing or processing of this order is proprietary and shall not be reproduced in whole or part, and shall be returned upon completion of the Purchase Order or contract.
- PQC 15 CUSTOMER-FURNISHED PROPERTY:** All customer furnished property utilized in this order is Customer-Furnished and shall be returned with final shipment of parts or product.



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- PQC 16** **SUBCONTRACTING:** All or part of the work procured on this Purchase Order without written approval of PCL LLC is prohibited. All approved subcontracted operations must meet all provisions of the Purchase Order and be certified to by the subcontractor.
- PQC 18** **ISO-9001:2001 OR BETTER:** Quality System Compliance is required.
- PQC 19** **QUALITY SYSTEM FLOW DOWN:** Quality System Requirements are flowed down to ensure that characteristics not verifiable upon receipt are adequately controlled by the subcontractor.
- PQC 20** **SPC DATA REQUIRED WITH SHIPMENT:** ___ Control Plans ___ Control Charts ___ Histograms.
- PQC 21** **CALIBRATION:** A calibration system in conformance with ANSI/NCSL Z540-3, ANSI/ISO/IEC 17025 must be maintained that is traceable to the National Institute of Standards and Technology and provides positive identification of calibration status. Adequate process controls, records, and certifications shall also be sufficiently maintained to satisfy purchase order requirements.
- PQC 22** **MATERIAL CERTIFICATION/RECORDS OF INSPECTION:** Supplier shall provide original or photocopy of Certified Material Test Report (CMTR) from the mill. The CMTR shall provide mill identity and mill tests and analysis of material.
- PQC 22A** Supplier shall provide the original or photocopy of Certified Chemical and/or Physical Test Report(s) from an independent test lab, per applicable specifications. The report shall reflect the mill source of material. A1) Chemical, A2) Physical. A full material chain of custody is required.
- PQC 22B** For Steel and Titanium purchases, the supplier shall provide certification as to the country of origin of the material provided. No foreign-poured materials shall be submitted for use on the United States Military Aircraft. (Bell Helicopter: the starting raw material has been melted in the United States, its possession, Puerto Rico, or a country listed on the DFARS 225.872-1 attachment. NOTE: Applies to steel and titanium only). A full material chain of custody is required.
- PQC 23** **MATERIAL IDENTIFICATION:** All materials supplied under this purchase order must be identified with: A) Heat/lot number, B) Specification, C) Grade, D) Alloy and Temper, E) Mill marking including material type.
- PQC 24** **PACKAGING / PROTECTION:** Sheet stock shall be protected by appropriate material interleaved between individual sheets and on top and bottom surfaces of material. Supplier shall individually wrap or box items to prevent damage in transit. Supplier shall package items for shipment so as to prevent metal-to-metal contact of formed surfaces. Protective devices accompany materials or items when shipped to supplier; supplier shall maintain protection during processing, apply rust or corrosion protection as required and return all such items with return shipment.
- PQC 25** **NONCONFORMANCE / CORRECTIVE ACTION:** The supplier shall have a system for investigating and implementing nonconformance, corrective action and preventive action. A written request for corrective action will be issued from PCL LLC to the supplier when the root cause is the responsibility of the subcontractor. The response to PCL LLC includes: Restatement of finding, immediate corrective action, root cause analysis, root cause correction, corrective action verification and follow-up.
- PQC 26** **NONCONFORMANCE NOTIFICATION REQUIREMENTS:** The supplier shall notify PCL LLC in detail when nonconformity is discovered in the supplier's processes or products that may affect product already delivered.
- PQC 27** **SUPPLIER RESOURCES:** Supplier resources, equipment, and number of trained personnel are adequate to perform verification activities that support the complexity of hardware or services provided.
- PQC 28** **WRITE-IN REQUIREMENTS:** Any requirements not specified above shall be explained in detail here or in an accompanying document.
- PQC 29** **NADCAP:** National Aerospace and Defense Contract Accreditation Program. Accreditation System Requirements are hereby imposed.
- Heat treat and Non-Destructive Testing.
 - Chemical processing.
 - Welding, Material testing, and Shot Peening.
- PQC 30** Any delay in shipment for any reason has to be conveyed to PCL LLC quality as soon as the delay is known by the supplier.



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- PQC 31** Any change to the contract requirements by the supplier must be approved by PCL LLC in writing. Notify PCL LLC of changes in product and/or process, changes of suppliers, changes of manufacturing facility location, and where required obtain PCL LLC approval.
- PQC 32** All information in the contract must be held in confidence by the supplier and no third party request for information will be authorized unless instructed in writing by an PCL LLC representative. When ITAR and/or government rated data is noted on the purchase order, the US government restrictions must be followed. If you have any questions concerning ITAR or government rating notify the company buyer. All concerns must be answered prior to you accepting this order. All documents to be retained for 10-year min unless extended retention is required by PCL LLC or its customers.
- PQC 33** Supplier must notify PCL LLC of nonconforming product. Counterfeit Parts from being delivered to PCL LLC (A product produced or altered to imitate or resemble a product without authority or right to do so, with the intent to mislead or defraud by passing the imitation as original or genuine.)
- PQC 34** Requirements for the supplier to flow down to their sub-tier suppliers the applicable requirements in PCL LLC purchasing documents, including key characteristics and applicable F.O.D. control processes where required.
- PQC 35** Requirements for the supplier to comply with executive order E13224. Supplier shall not engage in any transaction of any type with persons or businesses or organizations who commit, threaten to commit or support terrorism. Ensuring that persons are aware of: – , their contribution to product or service conformity; – their contribution to product safety; – the importance of ethical behavior. And that the Competence of Personnel as applicable meet the requirements of the PCL LLC Purchase Order Service or Products Ordered.
- PQC 36** Unless otherwise specified, seller agrees to adhere to meeting or exceeding 90% on-time delivery of product and 90% product quality ratings.
- PQC 37** A First Article Inspection (FAI) shall be performed by the seller in accordance with the requirements of AS9102 (latest revision).

General Terms and Conditions combined for Processing suppliers.

Processing suppliers must furnish processing certifications to PCL LLC purchase order requirements and shall not process any parts for which they are not certified or approved. Acceptable quality system requirement are AC7004, ISO9001, or AS9100; PCL LLC may make conditional exceptions based on supplier survey information or applicable customer requirements. Supplier must have the ability to ensure the adequacy of the special process provided and provide PCL LLC the required documentation per purchase order requirements. **PQC 1,2,5,9,13,14,17,18,19,21,24,25,26,27,29,30,31,32,33,34,35,36**

General Terms and Conditions combined for Material suppliers.

Material suppliers must furnish material certifications to PCL LLC purchase order requirements and shall not supply material for which they are not certified or approved. When noted on our purchase orders, raw material supplied must be USA domestic material. Acceptable quality system requirements are ISO9001, AS9100 or AS9120; PCL LLC may make conditional exceptions based on supplier survey information or applicable customer requirements. The Supplier must have the ability to ensure the adequacy of the product provided and provide PCL LLC the required documentation per purchase order requirements.

PQC 1,2,5,9,11,13,14,17,18,19,21,24,25,26,27,29,30,31,32,33,34,35,36

General Terms and Conditions combined for Calibration and Testing suppliers.

Calibration and Testing suppliers must furnish calibration/test reports to PCL LLC purchase order requirements and be traceable to the specific equipment or item for which they are calibrating or testing, traceability to NIST and/or other national or international standards must be supplied. ISO9001, ISO 17025, ANSI/NC SL Z540.3-2006, Nadcap testing, ANSI Z540, and/or Navlap accreditation will be the quality system requirements; PCL LLC may make conditional exceptions based on supplier survey information or applicable customer requirements.

PQC 1,5,9,17,18,19,21,25,26,27,31,32,33,34,35