

Summary of Changes

095871 Contracts Deliverable Requirements

This is to notify you of changes to the BAE Systems Contracts Deliverable Requirements Manual. Please see the following changes/additions:

Legend:

- Addition
- Change
- Deletion

004 First Article Test (FAT)

The Supplier shall submit a FAT plan in accordance with the Data Submission Instructions (located in the SQAM) for this item within thirty (30) days after receipt of the Purchasing Agreement. The FAT plan shall include:

- Dates for submittal of the FAT procedure
- Dates and location(s) for all testing with anticipated start/completion dates
- Date for submittal of the FAT report

The Supplier shall update/resubmit the FAT plan to cover any changes to the schedule prior to start of the test. The procedure and test reports may be prepared using MIL-HDBK-831 as a guide. **and shall be approved by BAE Systems prior to start of the test.** BAE Systems and its customer reserve the right to witness FAT testing at any point in the schedule.

Following First Article Test approval, it is the Supplier's responsibility to notify the BAE Systems Authorized Purchasing Representative to determine what testing must be repeated when any of the following occurs:

- Receipt of new Purchasing Agreement or contract
- Significant change in manufacturing process (introduction of a new manufacturing technique, etc.)
- Change in any drawing configuration, component, or sub-component parts
- Change in manufacturing location
- A break in production or process in excess of twenty-four (24) months, unless otherwise specified.

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005 Customer Source Surveillance (CSS)

Source surveillance, inspection, and/or test by a BAE Systems source inspection representative is required for each shipment of this item. In order to accommodate BAE Systems source inspection representatives, the Supplier shall make all facilities, equipment, inspection records, and assistance readily available.

The Supplier shall provide five (5) working days advance notification of requests for source inspection through submission of Form 092245 for Combat Vehicles and Form 089559 for Weapon Systems. Requests shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) specified for this item. Unauthorized/unapproved shipment of product without BAE Systems source inspection may result in the shipment being rejected, a supplier corrective action request may be issued and product may be returned to the Supplier at the Supplier's expense.

If parts are returned for repair or rework, a resubmission of source is required. Parts are not to be shipped until the resubmission source has been approved and the source form is annotated with: 'Repair or Rework', and lists the NCR number on the form as applicable.

007A Welding Combat Vehicles Inspection Criteria

- All visual weld inspection must be conducted by either of the following 3 inspector certification platforms, and completed on 100% of all welds.
 - An American Welding Society certified CWI, SCWI
 - A qualified CWB level 2 or 3 through the Canadian Welding Bureau as determined through the Canadian Standards Association.
 - A Government CWI, or Tardec Quality Assurance CWI approved welding inspector certification program.
- All visual weld inspection on armor steel and quenched and tempered steel must be held for 48 hrs prior to final inspection.
- Where NDT is required per print, all welded armor steel and low allow steels 100 KSI tensile strength or greater shall be held a minimum of 48 hours prior to NDT inspection, this is for welded material.
- Welding fixtures to be designed per ASME Y14.43

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084 Process Failure Mode and Effects Analysis (PFMEA) and Control Plans (CP)

A. PFMEA AND CONTROL PLANS PER THE TOP LEVEL DRAWING, AND FLOW DOWN TO ALL SUPPLIERS

The contractor shall develop and implement the use of PFMEA and CPs that ensure compliance with the requirements of this contract. The PFMEA and CP must involve the entire production system and flow down of these requirements to its suppliers.

The contractor shall submit, for BAE Systems approval, an implementation plan which describes in detail: schedule, milestones, exception criteria, submission methodology and Supplier flow down requirements. Specific processes in the manufacturing of the components must be identified that are used to ensure conformance to the requirements. The Implementation plan is to be completed and submitted 30 days following receipt of the contract in accordance with the data submission instructions located in the SQAM.

Control plans shall include outputs from the PFMEA's. Special or key characteristics, whether identified by the Customer or the Supplier, must be used in the development of the control methods. The control methods must also include specific reaction plans when any undesirable measurement results are obtained. The reaction plans, in conjunction with the inspection/test frequency shall effectively mitigate the risk of suspect material being released for shipment from the contractor's/suppliers facility.

The CP and PFMEA documents are to be completed, submitted in accordance with the data submission instructions located in the SQAM **and approved** prior to shipment of any product. CPs shall be treated as a living document and shall always reflect the current process. CPs shall be controlled documents and retained for the life of the contract.

The contractor shall use Automotive Industry Action Group (AIAG) publications "Potential Failure Mode and Effects Analysis" version 4, 2008, and "Advanced Product Quality Planning and Control Plan" version 2, 2008 for development and use of PFMEAs and CPs.

B. PFMEA AND CONTROL PLANS PER THE TOP LEVEL DRAWING, TIER I & II SUPPLIERS

The Contractor shall develop and implement the use of PFMEA and CPs that ensure compliance with the requirements of this contract. The PFMEA and CP must involve the entire production system as defined on the top level drawing.

The Contractor shall submit, for BAE Systems approval, an implementation plan which describes in detail: schedule, milestones, exception criteria, and submission methodology. Specific processes in the manufacture of the components must be identified that are used to ensure conformance to the requirements. The Implementation plan is to be completed and submitted 30 days following receipt of the contract in accordance with the data submission instructions located in the SQAM.

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Control plans shall include outputs from the PFMEA's. Special or key characteristics, whether identified by the Customer or the Supplier, must be used in the development of the control methods. The control methods must also include specific reaction plans when any undesirable measurement results are obtained. The reaction plans, in conjunction with the inspection/test frequency shall effectively mitigate the risk of suspect material being released for shipment from the supplier's facility.

The CP and PFMEA documents are to be completed, submitted in accordance with the data submission instructions located in the SQAM **and approved** prior to shipment of any product. CPs shall be treated as a living document and shall always reflect the current process. CPs shall be controlled documents and retained for the life of the contract.

The Contractor shall use Automotive Industry Action Group (AIAG) publications "Potential Failure Mode and Effects Analysis" version 4, 2008, and "Advanced product Quality Planning and Control Plan" version 2, 2008 for development and use of PFMEAs and CPs.

085 First Article Inspection

The Contractor shall conduct First Article Inspection (FAI) in accordance with AS9102B for all provided parts and those not previously subjected to First Article Inspection requirements in accordance with the Supplier Quality Assurance Manual, to ensure Supplier product/processes have the capability of meeting design and/or specification requirements.

FAI's shall be conducted, reviewed, submitted in accordance with the data submission instructions located in the SQAM **and approved** prior to the first shipment of product. Where changes require only a delta FAI, the delta FAI will be limited to the impact of the change only. The customer reserves the right to review any/or all associated FAI documentation at its discretion.

086 Counterfeit Material Program:

This requirement is applicable to Phoenix for hardware and electronic purchases and to Combat Vehicles for electronic purchases only.

Prior to first product delivery the supplier is required to submit and gain approval, by BAE Systems Procurement, documentation confirming the traceability of parts to be delivered were produced by the Original Equipment/Component Manufacturer or sourced directly from an Authorized Distributor. Parts from sources other than the OEM/OCM or Authorized Distributor will require submission and approval, by BAE Systems Procurement, of Certificates of Conformance, Certificates of Origin and/or Performance Test Reports. With every delivery the supplier is required to provide a Certificate of Authenticity stating compliance with sourcing from OEM/OCM, Authorized Distributor or BAE Systems pre-approved supplier.

032 Ballistic Requirements-Transparent Armor

A ballistic first article test shall be performed and accepted prior to any production of transparent armor. All drawing and specification requirements shall be met as required for the ballistic FAT and ballistic lot testing.

BAE Systems source inspection shall be requested prior to shipping the samples for ballistic testing.

In addition to the marking requirements, specified in the PO and on the drawings, ALL test specimens, shipping containers and associated documents shall be clearly marked "First Article Sample" or "Lot Sample."

Ballistic sample submission process for York purchased material tested at BAE San Jose:

- Supplier shall request BAE Systems source inspection prior to shipping the samples for ballistic testing.
 - Supplier shall submit Form 092245 Source Inspection Request/Approval Form as required by CDR005 with Form 089689 Supplier CDR or Source Submission Cover Sheet Form 089689 per the Data Submission Instructions on Form 09225.
 - Both forms are available on the Purchasing website listed in the PO text.
- During source inspection, the supplier and BAE Systems P&S source inspector shall complete Form 091889 Ballistic Test Submittal Form.
 - Source inspector shall determine if contract requires DCMA witness of the ballistic test.
 - Source inspector shall enter the Project and Task numbers on the submittal form (when applicable).
- Signed copies of the Source Inspection Approval and the Ballistic Test forms shall be included with the shipping documents for the test sample
- In addition to the marking requirements, specified in the PO and on the drawings, ALL test specimens, shipping containers and associated documents shall be clearly marked "First Article Sample" or "Lot Sample."
- Following Ballistic First Article approval, the supplier shall submit lot samples for testing per the schedule in the ballistic test specification.

Ballistic sample submission process for Anniston purchased material tested at BAE San Jose:

- Supplier shall submit a copy of 091889 Ballistic Test Submittal Form in accordance with the Data Submission Instructions located in the SQAM
- Signed copy of the Ballistic Test form shall be included with the shipping documents for the test sample
- In addition to the marking requirements, specified in the PO and on the drawings, ALL test specimens, shipping containers and associated documents shall be clearly marked "First Article Sample" or "Lot Sample."
- Following Ballistic First Article approval, the supplier shall submit lot samples for testing per the schedule in the ballistic test specification.

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Ballistic sample submission process for Anniston purchased material tested at another testing facility other than BAE Systems San Jose:

- All ballistic test documentation shall be provided in accordance with the Data Submission Instructions (located in the SQAM) for this item
- The supplier shall submit lot samples for testing per the schedule in the ballistic test specification.
- The supplier is responsible for tracking compliance to ballistic testing for each product supplied to BAE Systems P&S.