

Summary of Changes

095871 Contract Deliverable Requirements (CDR)

Rev 16

This serves as notification that our BAE Systems Contract Deliverable Requirements (CDR) has been updated. Please note that the changes below are listed with the older version first, then the new revision is below it, unless otherwise noted. Please see the following changes/additions/deletions:

Legend:

- Addition
- Change
- Deletion

001 Inspection/Test Data Reports

The Supplier to BAE Systems shall submit all of the Supplier's actual inspection/test data for the specified **item** on a suitable form. The data shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item. As applicable, the data shall include the following information:

- Part Number
- Serial Number
- Quantity of parts
- Identification of each characteristic inspected/tested.
- A ballooned drawing shall accompany the report to identify the notes/characteristics inspected/tested.
- Actual Inspection/test results
- Date of inspection/test
- Inspector's signature, stamp or initials (electronic or digital signatures are acceptable)
- Indication of First Piece (when applicable)

001 Inspection/Test Data Reports

The Supplier to BAE Systems shall submit **for each piece** all of the Supplier's actual inspection/test data for the specified **characteristics identified and specified in the purchasing agreement** on a suitable form. **If your purchasing agreement does not clarify specific inspection or test data requirements, contact your Purchasing Representative for direction or complete a full FAI for each piece is required.** The data shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item. As applicable, the data shall include the following information:

- Part Number
- Serial Number

- Quantity of parts
- Identification of each characteristic inspected/tested.
- A ballooned drawing shall accompany the report to identify the notes/characteristics inspected/tested.
- Actual Inspection/test results
- Date of inspection/test
- Inspector's signature, stamp or initials (electronic or digital signatures are acceptable)
- Indication of First Piece (when applicable)

004 First Article Test (FAT)

When any of the First Article criteria exist, a First Article Test may be required to validate that the production processes are producing results within specification. In the event that a First Article Test is required, BAE Systems will adjust order quantities accordingly in order to define additional parts for the testing. The data shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item. Suppliers are required to inform the BAE Systems Quality Department in writing using VIR 089725 when any of the following occur for any operation or step in the supply chain/manufacturing process prior to shipment of any affected product.

- 1.) *Change in manufacturing process at tier 1 or any sub-tier suppliers (BAE Systems to be notified prior to the change being made)*
- 2.) *Drawing changes provided by BAE Systems or any/all suppliers*
- 3.) *Manufacturing location change at tier 1 or any sub-tier suppliers (BAE Systems to be notified prior to the change being made)*
- 4.) *Break in production of 24 months or more at any sub-tier suppliers.*

The supplier shall update/resubmit the FAT plan within 30 days following the contract award and cover any changes to the schedule prior to the start of the test. The procedure and test reports may be prepared using MIL-HDBK-831 as a guide. BAE Systems and its customer reserve the right to witness FAT testing at any point in the schedule.

004 First Article Test (FAT)

First Article Testing is required to validate that the production processes are producing results within specification. In the event that First Article Testing is required, BAE Systems may adjust order quantities accordingly in order to define additional parts for the testing. The FAT Report shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item. Suppliers are required to inform the BAE Systems Quality Department in writing using VIR 089725 when any of the following occur for any operation or step in the supply chain/manufacturing process, prior to shipment of any affected product to determine what additional testing is required:

- 1.) *Change in manufacturing process at tier 1 or any sub-tier suppliers (BAE Systems to be notified prior to the change (s) being made)*
- 2.) *Drawing changes provided by BAE Systems or any/all suppliers*
- 3.) *Manufacturing location change at tier 1 or any sub-tier suppliers (BAE Systems to be notified prior to the change (s) being made)*
- 4.) *Break in production of 24 months or more at any sub-tier suppliers.*

The Supplier shall update/resubmit the FAT plan within 30 days following contract award and 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. BAE Systems and its customer reserve the right to witness FAT testing at any point in the schedule.

007 Welding-Combat Vehicles

- Suppliers SHALL be up-to-date with the required Weld Process Audit PRIOR to submitting Weld Procedure(s) to BAE Systems Weld Engineering for review. Suppliers SHALL provide supporting documentation and evidence for a Weld Process Audit in accordance with the requirements listed in the SQAM. All supporting documentation SHALL be made available to BAE Systems upon request.
- **PRIOR** to the start of fabrication, the Supplier **SHALL** review WE-005 and submit all procedure(s) **and supporting qualification test data to the BAE Systems Weld Engineering Representative**. The Supplier **MAY** utilize BAE Systems Weld Procedure Specification(s) (WPS) in the event that the Supplier has completed the BAE Systems required Weld Training.
- In the event that the Supplier is **NOT** approved to utilize BAE Systems Weld Procedures and/or BAE Systems **DOES NOT** have applicable Weld Procedure(s) to fabricate the Weldment to fulfill the purchase order, the Supplier **SHALL** be responsible for providing and/or qualifying Weld Procedure(s) **PRIOR** to fabrication. BAE Systems Weld Engineering **SHALL NOT** be responsible for providing additional procedure qualifications for the sole use of our Suppliers.
- The Supplier **SHALL** submit the WPS(s) intended for part fabrication to BAE Systems Weld Engineering for review and approval via the Supplier Welding Procedure Submission Form 089136 **PRIOR** to the start of fabrication. The latest version of the form **SHALL** be utilized and is accessible via the BAE Systems Purchasing Website. Each Weldment Part Number and the applicable WPS(s) **SHALL** be submitted individually.
- In the event that the Supplier provides a non-BAE Systems qualified Weld Procedure, the Procedure Qualification Record(s) **SHALL** be submitted along with the respective WPS(s) for review.
- Supplying product to BAE Systems with an unapproved, rejected, and/or incorrect Welding Procedure Specification (WPS) is a violation of the BAE Systems Purchasing Agreement and is considered non-conforming and parts are subject to rejection and **MAY** be returned to the Vendor (RTV) at the Supplier's expense.
- The Supplier **SHALL** resubmit the Supplier Welding Procedure Form to BAE Systems Weld Engineering in the event that the Base Material, Weld Procedure(s), and/or the Part Number Configuration changes from the previously approved form. The form **SHALL** also be resubmitted if the BAE Systems Purchasing Agreement Part Number changes throughout configuration, regardless if all other variables have remained consistent from the previously approved form.
- The Supplier **SHALL** be responsible for maintaining all supporting documentation including, but **NOT** limited, to the following; Performance Qualifications, Sub-Tier Supplier Certifications, Machine Calibration Documentation, and other applicable documentation required to demonstrate compliance in accordance with the requirements per the BAE Systems Purchasing Agreement. All documentation **SHALL** be made available as requested BAE Systems at all times. • Supplier **SHALL** submit Standard and Non-Standard Repair Procedure(s) via the Vendor Information Request (VIR) Form 097908 for review and approval **PRIOR** to use.

Aluminum and Steel Arc Welding; Resistance Welding and Brazing

Procedure submittal requirements for **Document Title**
aluminum, steel, resistance, and brazing
weldments are addressed on the following
forms/ procedures: **Form Number/**
Procedure

090451	Visual Testing Inspection In Accordance With Ground Combat Vehicle Welding Code – Aluminum (12472301)
090504	Visual Testing Inspection In Accordance With Ground Combat Vehicle Welding Code – Steel (12479550)
091866	Brazing or Braze Welding Procedure - Cover Sheet (LAA-5130)
091868	Recorded Joint Welding Procedure for Resistance Welding Cover Sheet (LAA-5131)
092587	Weld Supplier Approval and Weld Procedure Submission Process Guideline (WE-005)
092579	SRP Repair of Steel Base Metal (WE-SRP02)
092580	SRP Repair of Aluminum Base Metal (WE-SRP01)
092589	BAE Systems Code Qualified Suppliers
092585	BAE Systems Weld Procedure Book - Steel
092586	BAE Systems Weld Procedure Book - Aluminum
089136	Supplier Welding Procedure Submission Form
089725	Vendor Information Request

007 Welding-Combat Vehicles

- Suppliers **SHALL** be up-to-date with the required Weld Process Audit PRIOR to submitting Weld Procedure(s) to BAE Systems Weld Engineering for review. Suppliers **SHALL** provide supporting documentation and evidence for a Weld Process Audit in accordance with the requirements listed in the SQAM. All supporting documentation **SHALL** be made available to BAE Systems upon request.
- PRIOR** to the start of fabrication, the Supplier **SHALL** review WE-005, submit **and gain approval for** all procedure(s) **per the Purchase Order Part Number**. The Supplier **MAY** utilize BAE Systems Weld Procedure Specification(s) (WPS) in the event that the Supplier has completed the BAE Systems required Weld **Procedure Training and Weld Process Audit**.
- In the event that the Supplier is **NOT** approved to utilize BAE Systems Weld Procedures and/or BAE Systems **DOES NOT** have applicable Weld Procedure(s) to fabricate the Weldment to fulfill the purchase order, the Supplier **SHALL** be responsible for providing and/or qualifying Weld Procedure(s) **PRIOR** to fabrication. BAE Systems Weld Engineering **SHALL NOT** be responsible for providing additional procedure qualifications for the sole use of our Suppliers.
- The Supplier **SHALL** submit the WPS(s) intended for part fabrication to BAE Systems Weld Engineering for review and approval via the Supplier Welding Procedure Submission Form 089136 **PRIOR** to the start of **welding and** fabrication. The latest version of the form **SHALL** be utilized and is accessible via the BAE Systems Purchasing Website. Each Weldment Part Number and the applicable WPS(s) **SHALL** be submitted individually.

- In the event that the Supplier provides a non-BAE Systems qualified Weld Procedure, the Procedure Qualification Record(s) **and Mechanical Testing Results SHALL** be submitted along with the respective WPS(s) for review **and approval**.
- Supplying product to BAE Systems with an unapproved, rejected, and/or incorrect Welding Procedure Specification (WPS) is a violation of the BAE Systems Purchasing Agreement and is considered non-conforming and parts are subject to rejection and **MAY** be returned to the Vendor (RTV) at the Supplier's expense.
- The Supplier **SHALL** resubmit the Supplier Welding Procedure Form to BAE Systems Weld Engineering in the event that the Base Material, Weld Procedure(s), and/or the Part Number Configuration changes from the previously approved form. The form **SHALL** also be resubmitted if the BAE Systems Purchasing Agreement Part Number changes throughout configuration, regardless if all other variables have remained consistent from the previously approved form.
- The Supplier **SHALL** be responsible for maintaining all supporting documentation including, but **NOT** limited, to the following; Performance Qualifications, Sub-Tier Supplier Certifications, Machine Calibration Documentation, and other applicable documentation required to demonstrate compliance in accordance with the requirements per the BAE Systems Purchasing Agreement. All documentation **SHALL** be made available as requested BAE Systems at all times.
- Supplier **SHALL** submit Standard and Non-Standard Repair Procedure(s) via the Vendor Information Request (VIR) Form 097908 for review and approval **PRIOR** to use.

Aluminum and Steel Arc Welding; Resistance Welding and Brazing

Procedure submittal requirements for aluminum, steel, resistance, and brazing weldments are addressed on the following forms/ procedures:

Form Number/ Procedure	Document Title
090451	Visual Testing Inspection In Accordance With Ground Combat Vehicle Welding Code – Aluminum (12472301)
090504	Visual Testing Inspection In Accordance With Ground Combat Vehicle Welding Code – Steel (12479550)
091866	Brazing or Braze Welding Procedure - Cover Sheet (LAA-5130)
091868	Recorded Joint Welding Procedure for Resistance Welding Cover Sheet (LAA-5131)
092587	Weld Supplier Approval and Weld Procedure Submission Process Guideline (WE-005)
092579	SRP Repair of Steel Base Metal (WE-SRP02)
092580	SRP Repair of Aluminum Base Metal (WE-SRP01)

092585	BAE Systems Weld Procedure Book - Steel
092586	BAE Systems Weld Procedure Book - Aluminum
089136	Supplier Welding Procedure Submission Form
089725	Vendor Information Request

012 Flammability

A flammability certification to the specification noted on the drawing from the original material manufacturer or a flammability test report from a BAE Systems approved facility is required. Certification shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item.

012 Flammability

A flammability certification to the specification noted on the drawing from the original material manufacturer or a flammability test report from a BAE Systems approved facility is required. Certification shall be submitted in accordance with the Data Submission Instructions (located in the SQAM, [paragraph 8.12](#)) for this item. **This requirement is only applicable to Phoenix parts.**

015 Control Tests

The Supplier shall perform Control Tests at the frequency defined by the specification/QAP. The Supplier is responsible for determining the test schedule based on the production and delivery schedule per the Purchasing Agreement. The Supplier shall notify the BAE Systems Authorized Purchasing Representative of the projected test schedule and any changes as they occur. If any failures occur, either through defect of the test equipment or of the test sample itself, the Supplier shall immediately notify the BAE Systems Authorized Purchasing Representative for further instructions prior to continuance of testing.

Following the completion of testing, a test report shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item prior to or with the shipment of product for approval.

MIL-HDBK-831 should be used as a guide in developing the test report format. As a minimum, the test report shall include:

- BAE Systems Part Number
- BAE Systems Purchasing Agreement Number
- Prime Contract Number (this is specified on the Purchasing Agreement)
- Applicable drawings/specification and revision level
- Type of test (i.e., Group "C," Group "D," etc.)
- Tests performed and results
- Test completion date
- Sample size
- Sample identification, if applicable
- Production interval (or Purchasing Agreement line number)
- Printed name, signature, and title of Supplier's representative
- Report date
- Any additional data or information required to show full compliance to the control test requirements

015 Control Tests

The Supplier shall perform Control Tests at the frequency defined by the specification/QAP. The Supplier is responsible for determining the test schedule based on the production and delivery schedule per the Purchasing Agreement. The Supplier shall notify the BAE Systems Authorized Purchasing Representative of the projected test schedule and any changes as they occur. If any failures occur, either through defect of the test equipment or of the test sample itself, the Supplier shall immediately notify the BAE Systems Authorized Purchasing Representative for further instructions prior to continuance of testing.

Following the completion of testing, a test report shall be submitted in accordance with the Data Submission Instructions (located in the SQAM, paragraph 8.12) for this item prior to or with the shipment of product for approval.

MIL-HDBK-831 should be used as a guide in developing the test report format. As a minimum, the test report shall include:

- BAE Systems part number
 - All applicable BAE Systems Purchasing Agreement Number(s)
 - Prime Contract Number (this is specified on the Purchasing Agreement)
 - Applicable drawings/specification and revision level
 - Type of test (i.e., Group "C," Group "D," etc.)
 - Tests performed and results
 - Test completion date
 - Next test date/submittal
 - Applicable serial number(s) tested
 - Sample size
 - Sample identification, if applicable
 - Production interval (or Purchasing Agreement line number)
 - Printed name, signature, and title of Supplier's representative
 - Report date
 - Any additional data or information required to show full compliance to the control test requirements
-

016 Plating

The supplier shall provide written certification that the plating was performed in accordance with all Purchasing Agreement, drawing, and Purchasing Agreement specification requirements prior to or with shipment of the product. The facility actually performing the plating shall prepare the certification.

The Certification **MUST** include as a minimum:

- Part number
- Purchasing Agreement number
- Plating process specification used
- Complete lot traceability to all certifications related to the BAE Systems Purchasing Agreement
- Printed name, signature, and title of Supplier's representative
- Report date

The certification/data shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item.

The following requirements apply when zinc plating per ASTM B633 is specified:

When embrittlement relief pretreatments and/or post treatments are required and unless otherwise specified on the component, drawing the following requirements shall apply:

A) Pretreatment on steel parts with a tensile strength 1000 MPa (31 HRC) or greater that have been machined, ground, cold-formed, or cold-straightened subsequent to heat treatment. Bake times and temperatures shall be in accordance with Table 1 of ASTM B849.

B) Post coating treatments for the purpose of reducing the risk of hydrogen embrittlement in accordance with ASTM B850 on iron or steel parts having a tensile strength ≥ 1000 MPa (with corresponding hardness values 303 HB, or 31 HRC) and surface-hardened parts unless otherwise specified. Bake times and temperatures shall be in accordance with Table 1 of ASTM B850.

C) The certification shall also include:

- Baking temperature; Requirement and Actual
- Baking time; Requirement and Actual
- A statement that the baking operation was started within 3 hours of plating completion

016 Plating

The supplier shall provide written certification that the plating was performed in accordance with all Purchasing Agreement, drawing, and Purchasing Agreement specification requirements prior to shipment of the product. The facility actually performing the plating shall prepare the certification.

The Certification **MUST** include as a minimum:

- Part number
- Purchasing Agreement number
- Plating process specification used
- Complete lot traceability to all certifications related to the BAE Systems Purchasing Agreement
- Printed name, signature, and title of Supplier's representative
- Report date

The certification/data shall be submitted and approved prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item.

The following requirements apply when zinc plating per ASTM B633 is specified:

When embrittlement relief pretreatments and/or post treatments are required and unless otherwise specified on the component, drawing the following requirements shall apply:

A) Pretreatment on steel parts with a tensile strength 1000 MPa (31 HRC) or greater that have been machined, ground, cold-formed, or cold-straightened subsequent to heat treatment. Bake times and temperatures shall be in accordance with Table 1 of ASTM B849.

B) Post coating treatments for the purpose of reducing the risk of hydrogen embrittlement in accordance with ASTM B850 on iron or steel parts having a tensile strength ≥ 1000 MPa (with corresponding hardness values 303 HB, or 31 HRC) and surface-hardened parts unless otherwise specified. Bake times and temperatures shall be in accordance with Table 1 of ASTM B850.

C) The certification shall also include:

- Baking temperature; Requirement and Actual
- Baking time; Requirement and Actual
- A statement that the baking operation for hydrogen embrittlement relief was started within 3 hours of

plating completion or as required per specification

017 Paint Certification

The Supplier shall provide a copy of the written certification documenting that painting was performed in accordance with all Purchasing Agreement, drawing, and specification Purchasing Agreement requirements prior to or with the product shipment. Certification shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item. The facility actually performing the painting shall prepare the certification, which shall include:

- Name and address of the finisher
- Part number
- Purchasing Agreement number
- List of specifications used in the processing of the paint
- Paint thickness of a sample of actual parts for the primer
- Paint thickness of a sample of actual parts for the top coat
- Material lot/batch number(s)
- Material expiration date(s)
- Printed name, signature, and title of Supplier's representative
- Certification date

All test and inspection documentation shall be available for BAE Systems' review upon request.

Documentation submittal is required for Anniston Spares and for all non-approved paint resources.

BAE Systems Combat Vehicle approved painters are not required to submit any documentation with the parts but are required to maintain all required documentation validating compliance to all requirements and make this documentation available for BAE Systems review upon request.

Items requiring painting in accordance with MIL-STD-1303 shall instead be painted in accordance with NAVSEA Drawing 7250920 and associated paint photographs (if applicable).

017 Paint Certification

The Supplier shall provide a copy of the written certification documenting that painting was performed in accordance with all Purchasing Agreement, drawing, and specification Purchasing Agreement requirements prior to or with the product shipment. Certification shall be submitted in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item. The facility actually performing the painting shall prepare the certification, which shall include:

- Name and address of the finisher
- Part number
- **BAE Systems** Purchasing Agreement number
- List of specifications used in the processing of the paint
- Paint thickness of a sample of actual parts for the primer
- Paint thickness of a sample of actual parts for the top coat
- Material lot/batch number(s)
- Material expiration date(s)
- Printed name, signature, and title of Supplier's representative
- Certification date

All test and inspection documentation shall be available for BAE Systems' review upon request.

Documentation submittal is required for Anniston Spares and for all non-approved paint resources.

BAE Systems Combat Vehicle approved **CARC** painters are not required to submit any documentation with the parts but are required to maintain all required documentation validating compliance to all requirements and make this documentation available for BAE Systems review upon request.

Items requiring painting in accordance with MIL-STD-1303 shall instead be painted in accordance with NAVSEA Drawing 7250920 and associated paint photographs (if applicable).

019A Test Samples – Tensile Testing

The Supplier shall provide a set of two samples (un-machined test bars/sheet stock) suitable for the mechanical testing as required by Purchasing Agreement or referenced specification. Both shall be made from the same melt and heat treated in the same lot as the supplied parts. **Identify by paint marking.**

019A Test Samples – Tensile Testing

The Supplier shall provide a set of two samples (un-machined test bars/sheet stock) suitable for the mechanical testing as required by Purchasing Agreement or referenced specification. Both shall be made from the same melt and heat treated in the same lot as the supplied parts.

021A Mercury Added to the table of contents

The Supplier shall certify that the material shipped under this Purchasing Agreement does not contain functional mercury in any form and that no mercury-bearing instruments and/or equipment that might cause contamination have been used in the manufacture, fabrication, assembly, or testing of any material shipped under this Purchasing Agreement. This requirement must be included in all sub-tier Purchase Orders however, certification is only required from the BAE Systems tier1 suppliers when requested.

021B Lead Added to the table of contents

The Supplier shall certify that the material shipped under this Purchasing Agreement does not contain lead in any form and that no lead-bearing instruments and/or equipment that might cause contamination have been used in its manufacture, fabrication, assembly, or testing of any material shipped under this Purchasing Agreement. This requirement must be included in all sub-tier Purchase Orders however, certification is only required from the BAE Systems tier 1 suppliers.

026A Quality System Requirements

The Supplier shall maintain on file, and provide to BAE Systems upon request, objective quality evidence demonstrating Registration/Certification by an **approved** Registrar to ISO 9001, AS 9100, TS 16949, ISO/IEC 17025 **or other recognized Quality System Standard**. When the Registration/Certification Certificate is requested by BAE Systems, the documentation shall be provided in a commonly readable electronic format and shall be provided to BAE Systems in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 or uploaded to HICX.

026A Quality System Requirements

The Supplier shall maintain on file, and provide to BAE Systems upon request, objective quality evidence demonstrating Registration/Certification by an **Accredited** Registrar to ISO 9001, AS 9100, TS 16949, **IATF 16949**, ISO/IEC 17025 **or a quality system approved by an Accredited Third Party Registrar**. When the Registration/Certification Certificate is requested by BAE Systems, the documentation shall be provided in a commonly readable electronic format and shall be provided to BAE Systems in accordance with the Data Submission Instructions (located in the SQAM, paragraph 8.12) or uploaded to HICX.

027 Certificate of Compliance

The Supplier shall provide **with** each shipment **a copy of their Certificate of Compliance** as defined by paragraph 8.5 of the SQAM. Copies shall be delivered and approved prior to shipment as specified by the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item.

027 Certificate of Compliance

The Supplier shall provide **an electronic copy of their Certificate of Compliance for** each shipment as defined by paragraph 8.5 of the SQAM. Copies shall be delivered and approved prior to shipment as specified by the Data Submission Instructions (located in the SQAM, paragraph 8.12) for this item.

028 Unique Identification (UID)

This item requires UID marking in accordance with the TDP requirements.

If the UID marking is already present, verify that it is intact and able to be scanned. If the scan fails, replace the existing marking with new UID marking.

It is acceptable to add UID marking to an existing data plate as long as the following human readable information (HRI) is present:

- **Cage Code**
- **Part Number**
- **Serial Number**

028 Unique Identification (UID)

This item requires UID marking in accordance with **the Mil-Std-130/TDP** requirements.

If the UID marking is already present, verify that it is intact and able to be scanned. If the scan fails, replace the existing marking with new UID marking.

030A Approved Special Processors (BAE Systems)

The supplier is to use BAE Systems approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current Approved Processor Listing may be obtained from the cognizant BAE Systems Buyer.

030A Approved Special Processors (BAE Systems)

The supplier is to use BAE Systems approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current Approved Processor Listing may be obtained from the cognizant BAE Systems Buyer. **This requirement is only applicable to Phoenix parts.**

030B Approved Special Processors (Customer)

The supplier is to use BAE Systems' customer approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current approved processor listing may be obtained from the cognizant BAE Systems Buyer.

030B Approved Special Processors (Customer)

The supplier is to use BAE Systems' customer approved sources for special processes such as thermal processing, metal finishing, metal joining, non-destructive testing, etc. A current approved processor listing may be obtained from the cognizant BAE Systems Buyer. **This requirement is only applicable to Phoenix parts.**

030C NADCAP Approved Special Processes Added to the table of contents

All special processes identified herein and utilized on a BAE Systems purchase order/subcontract require certification by NADCAP. NADCAP Certification will be required for heat treating, painting/coating (non-CARC) and plating. These Special Process requirements identified herein shall be flowed down to all sub-tier suppliers as applicable. The supplier shall provide a current Certificate of Conformance (C of C) certifying compliance for the special process identified and performed as required by the TDP. All Special Process suppliers or their sub-tier suppliers utilized on the purchase order/subcontract shall have a current accreditation by NADCAP. The Certificate of Compliance shall define and document each process used in satisfying the TDP/Subcontract requirements and the date of the last audit. Special processes will be as defined in our SQAM, AS9100 and by NADCAP. All costs associated with NADCAP accreditation shall be borne by the Special Processor. The NADCAP Certificate shall be provided to BAE Systems in accordance with the Data Submission Instructions (located in the SQAM, paragraph 8.12) or uploaded to HICX when requested.

041 Critical Items (CI)

The Supplier shall provide documentation for all Critical Safety Items (CSI), Hardness Critical Items (HCI), or Observable Critical Items (OCI) identified for this item by the TDP. **Sample size for this inspection shall be 100% for the identified characteristic(s).** Actual results, including an authorized signature and date of acceptance, traceable to a specific shipment shall be recorded, provided and approved prior to shipment. Submission of documentation shall be made in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item.

A. The heat treat supplier shall conduct 100% testing for hardness. Hardness testing will occur at designated locations identified on the BAE Systems drawing. Hardness testing will be conducted in accordance with the method defined in the SPS document specified on the drawing. In the event location for hardness testing is not indicated on the BAE System's drawing, the heat treat supplier may select an appropriate location on the part for testing to be conducted. In the event the BAE Systems drawing does not specify an SPS document for hardness testing, hardness testing is to be conducted per ASTM-E18. Actual results, including an authorized signature and date of acceptance, traceable to a specific shipment shall be recorded and provided prior to shipment. Submission of documentation shall be made in accordance with the Data Submission Instructions (located in the SQAM) paragraph 8.12 for this item.

041 Critical Safety Items (CSI)

The Supplier shall provide documentation for all Critical Safety Items (CSI), Hardness Critical Items (HCI), or Observable Critical Items (OCI) identified for this item by the TDP. **Sample size for this inspection shall be 100% for the identified characteristic (s).** Actual results, including an authorized signature and date of

acceptance, traceable to a specific shipment shall be recorded, provided and approved prior to shipment. Submission of documentation shall be made in accordance with the Data Submission Instructions (located in the SQAM, paragraph 8.12) for this item.

- A. The heat treat supplier shall conduct 100% testing for hardness. Hardness testing will occur at designated locations identified on the BAE Systems drawing. Hardness testing will be conducted in accordance with the method defined in the [Standard Process Specification](#) (SPS) document specified on the drawing. In the event location for hardness testing is not indicated on the BAE System’s drawing, the heat treat supplier may select an appropriate location on the part for testing to be conducted. In the event the BAE Systems drawing does not specify an SPS document for hardness testing, hardness testing is to be conducted per ASTM-E18. Actual results, including an authorized signature and date of acceptance, traceable to a specific shipment shall be recorded and provided prior to shipment. Submission of documentation shall be made in accordance with the Data Submission Instructions ([located in the SQAM, paragraph 8.12](#)) for this item.

042 SPC Program

Statistical methods and procedures used by the supplier to implement and maintain a documented continuous improvement program may be subject to review by BAE Systems’ Quality Assurance. Using statistical process-control methods, tools, and documentation, the supplier must monitor key characteristics noted directly on the PO or engineering documents. Copies of the control charts, (including notes and corrective action for assignable causes) must be delivered with each shipment. Processes **that are out of control or** yielding a Cpk of less than 1.33 require 100% inspection for key characteristics prior to certification and delivery of the production lot. Documented inspection reports shall accompany each shipment. The supplier is responsible for the flow down of this CDR to their subcontractors.

042 SPC Program

Statistical methods and procedures used by the supplier to implement and maintain a documented continuous improvement program may be subject to review by BAE Systems’ Quality Assurance. Using [Statistical Process-Control \(SPC\)](#) methods, tools, and documentation, the supplier must monitor key characteristics noted directly on the PO or engineering documents. Copies of the control charts, (including notes and corrective action for assignable causes) must be delivered with each shipment. Processes yielding a Cpk of less than 1.33 require 100% inspection for key characteristics prior to certification and delivery of the production lot. Documented inspection reports shall accompany each shipment. The supplier is responsible for the flow down of this CDR to their subcontractors. [Submission of documentation shall be made in accordance with the Data Submission Instructions \(located in the SQAM, paragraph 8.12\) for this item.](#)

068 Sterling Heights CAGE Code Added to the table of contents

The CAGE code to be marked on this part is 6BTJ2

044 Packaging Instructions for Hardware Kits

In the table of contents, [removed C. Labels.....33](#), and [moved 44D up to C](#). Therefore, the new 44C is as follows:

C. Packing

Palletize and/or consolidate required kit quantities per contract schedule. Before stretch wrapping or banding, place fiberboard on four sides and top to further protect cartons from damage. The palletized load(s) shall be marked with the appropriate shipping address as specified in the Purchasing Agreement. Apply special handling marking "Do Not Stack".



Example A

Unit Pack Label



Example B

Consolidation Pack Label