

Quality Clause Q3R

Fit Check Processing

The latest issue of this document is the version on the Lockheed Martin website:
www.lockheedmartin.com/us/aeronautics/materialmanagement/scm-quality.html

1. SCOPE

1.1 The Q3R clause establishes the requirements for processing a Fit Check Item (FCI)

2. DEFINITION AND TERM USAGE

2.1 The terms "Item(s)", "PO", "Seller" and "Buyer", as used herein, have the same meaning as the terms "Work", "Contract", "SELLER" and "LOCKHEED MARTIN", respectively.

2.2 A Fit Check Item ("FCI") is an Item from the first production build which is checked to Buyer's next assembly, aircraft and/or tooling, to validate Seller's compliance to Buyer's build-to-package.

3 APPLICABILITY

3.1 Seller shall process the following as a Fit Check Item (FCI):

- a) Items built to Buyer-Furnished control tooling
- b) Buyer-design Items (Build-to-Print) with holes (pilot or full size) from Buyer's next assembly drawing
- c) Buyer-design (Build-to-Print), sheet metal Items with contour

3.2 Seller shall initiate a fit check whenever:

- a) The Seller completes a First Time Build
- b) An Engineering or Tooling change occurs that affects fit or form (except removal of pilot or full-size holes)

3.3 The following Items do not require Fit Check:

- a) Any part that doesn't meet the descriptions in 3.1, and
- b) Spares-only items

4. GENERAL REQUIREMENTS

4.1 Seller shall identify FCI(s), by completing and non-permanently attaching a single internal tag (found in Appendix A) to the FCI(s)

4.2 Seller shall identify, package and ship the completed FCI in accordance with the PO

4.3 Seller shall identify packages on all sides (excluding the bottom) with the external placards (found in Appendix B). The small placard shall be used only on package sides that cannot accommodate the large placard's size

4.4 Seller shall provide a completed part/assembly per the PO requirements

4.5 Successfully completed FCIs will remain on assembly at Buyer

5. FIT CHECK RESULTS AND RECORD KEEPING

5.1 Buyer shall provide Seller with electronic notification of FCI acceptance

5.2 Buyer shall provide Seller with electronic notification of any and all FCI nonconformances

5.3 Seller shall re-perform the requirements of Q3R for failed FCIs

5.4 Seller shall retain and provide records of FCI activity in accordance with requirements of this PO

Fit Check Item

Part Number	
Nomenclature	
Drawing Revision	
POIS Revision	
Supplier	
Supplier Number	
Purchase Order Number	
Purchase Order Line Item	
Quantity Shipped	
Date of Manufacture	
I&R (Y/N)	

Reason for Fit Check:

First Time Build Repaired Tool New Tool

FAI Delta FAI Engineering Change

Detailed Comments (Tooling #, Features Affected, Notable Changes):

Fit Check Item

FCI Internal Tag (Ref 4.1)

FIT CHECK ITEM

Box No. of

Part Number:

Nomenclature:

Supplier:

Purchase Order Number:

Purchase Order Line Item:

Internal LM Receiving Use:

Route to Quality/Production Control for Fit Check Processing

FIT CHECK ITEM

FIT CHECK ITEM

Box No. of

Internal LM Receiving Use:

Route to Quality/Production Control
for Fit Check Processing

All Destinations – FCI External Packaging Placard - Small