Quality Clause Q3R
Fit Check Processing

The latest issue of this document is the version on the Lockheed Martin website:
https://www.lockheedmartin.com/en-us/suppliers/business-area-procurement/aeronautics/quality-requirements/clauses.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", "PO", "Seller" and "Buyer", as used herein, have the same meaning as the terms "Work", "Contract", "Supplier" and "Lockheed Martin", respectively.

2.2 A Fit Check Item ("FCI") is an item which is checked to Buyer's next assembly, aircraft, and/or tooling in order to validate Seller's compliance to LM Aero Build-to-Print requirements.

3. APPLICABILITY

(Ref. Appendix A)

3.1 An item meeting the following criteria is considered an FCI:

3.1.1 Item that has complex contour that cannot be validated to the drawing or tooling during FAI.

3.2 Seller shall initiate a fit check only when the part meets the FCI criteria of 3.1 AND either of the following are true:

3.2.1 The Seller is accomplishing a First Time Build (FTB)

3.2.2 An Engineering or Tooling change occurs that affects fit, form, or function (except omission of pilot or full-size holes)

3.3 Any item that is purchased on a Spares or Sustainment Purchase Order and not intended for LM Aero Production does not require a Fit Check.

4. GENERAL REQUIREMENTS

4.1 Seller shall provide a single completed part/assembly per the PO requirements.

4.1.1 Seller's Delivery Rating will not be negatively impacted by an FCI.

4.1.2 Seller shall pause further part shipment until notified of an accepted FCI.

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

4.3 Prior to shipment of an FCI, Seller shall provide an electronic notice of FCI shipment to Buyer by e-mailing the Buyer at FitCheck.dl-AERO@exch.ems.lmco.com

4.3.1 Seller shall include part number, Seller name, and destination address for the FCI within this electronic notice.

4.4 Seller shall identify FCI by attaching a single completed, non-permanent internal tag (found in Appendix B) to the FCI.

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

4.6 When deemed necessary and mutually agreed to by a Buyer representative, Seller may submit an FCI as a "Voluntary Fit Check" even when the Applicability conditions of Section 3 do not apply.

5. FIT CHECK RESULTS AND RECORD KEEPING

5.1 Buyer shall provide Seller with electronic notification of FCI acceptance.

5.1.1 A successfully completed FCI will remain on assembly at Buyer.

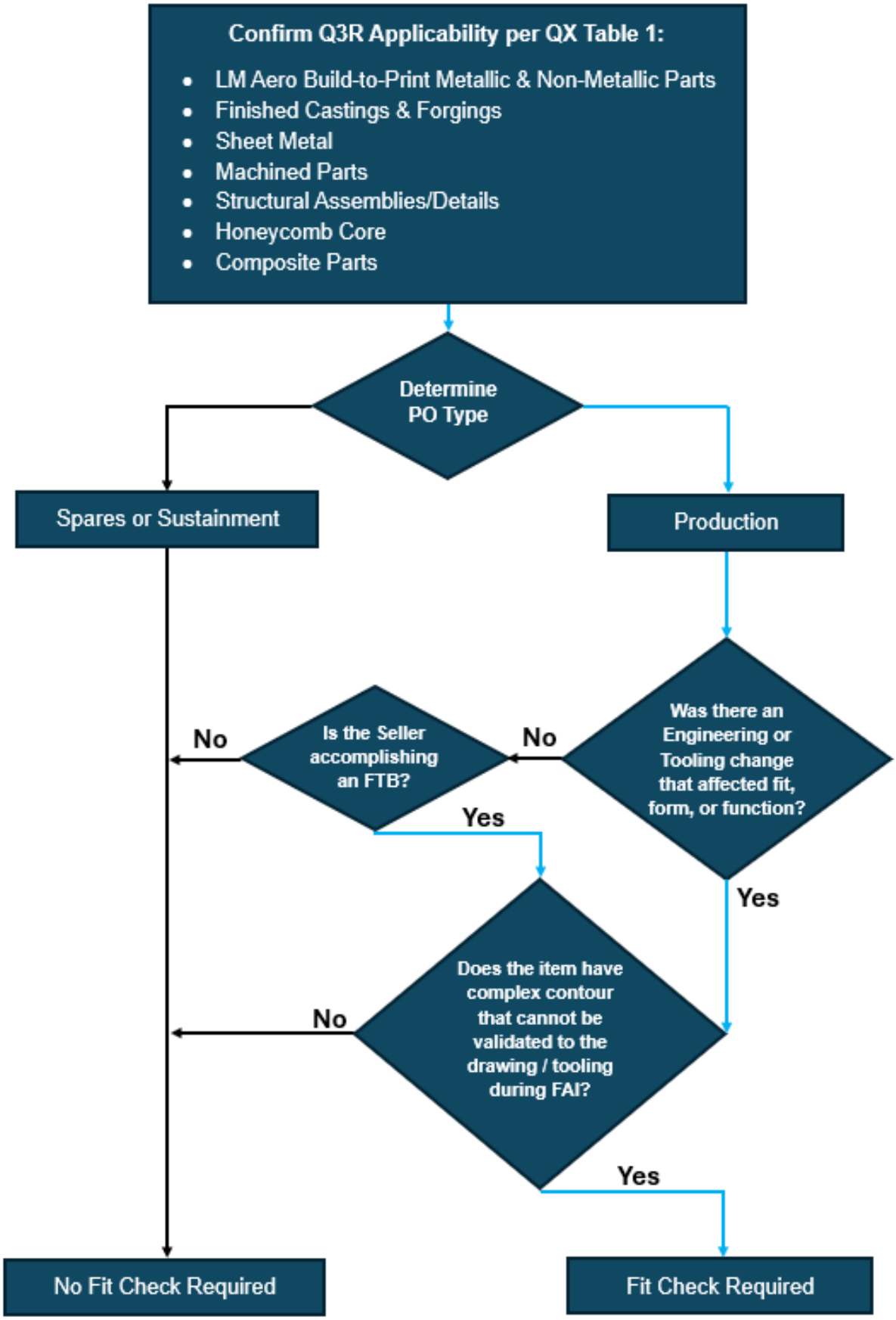
5.2 Buyer shall provide Seller with electronic notification of all FCI non-conformances.

5.2.1 Seller's Quality Rating will not be negatively impacted by a single FCI non-conformance. If the Seller does not adhere to Section 4.1 and sends excessive FCIs, the excess FCIs may impact the Seller's Quality Rating.

5.3 Seller shall re-perform the requirements of Q3R for a failed FCI.

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

APPENDIX A – Decision Flowchart



APPENDIX B – Internal Tag

Fit Check Item

NOTE: Parts on Spares/Sustainment POs do NOT require Fit Checks

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 ☐

Tooling Change ☐ Engineering Change ☐

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

Fit Check Item

FCI Internal Tag (Ref 4.1)

All Destinations – FCI External Packaging Placard - Large

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

All Destinations – FCI External Packaging Placard - Small

FIT CHECK ITEM

Box No. of

Internal LM Receiving Use:

Route to Quality/Production Control

for Fit Check Processing