

Quality Requirements Q3R Fit Check

* Revised

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1.0 SCOPE: This Clause Q3R establishes the requirements for a "Fit Check Item", prior to the initiation of a production run. The requirements of this clause are in addition to inspection requirements set forth in Quality Requirements Appendix QR.

- * **2.0 DEFINITION:** A Fit Check Item ("FCI") is an item which supplements the scope and purpose of the First Article Inspection ("FAI") specified in Quality Clause Q2R/Q2A. The FCI is submitted to the Buyer's facility specified in this Purchase Order (PO) to verify fit to Buyer's next assembly, aircraft and/or tooling, prior to Seller's manufacture or delivery of production parts.

3.0 APPLICABILITY:

3.1 Unless otherwise specified in this PO, this FCI requirement applies to the first Item or lot produced for the part number specified in this PO.

- * **3.2** When a partial (Delta) FAI per Q2R/Q2A is performed, forward a copy via Fax to "F-16 Outsource Team" at (817) 762-1566 or "C-130 Outsource Team" at (770) 494-4042 Attention: PQA for determination if a FCI submittal is required.

3.3 The following types of parts generally do not require Fit Check:

- a) Items manufactured as Build-to-Print where parts have no contours, no control tools used, or no holes (pilot or full size) from next assembly drawing
- b) Shims (defined by engineering drawing)
- c) Buyer part numbers with a 16G, 85, 5 or 76 prefix
- d) Machined parts without pilot holes, I/R holes, drill to match holes or where special control tooling is not required.
- e) When form tools used on existing part numbers are used for the manufacture of new part numbers, and only Hole Pattern Analysis Sheet dictated changes are made, then only a Delta FAI is required.

4.0 GENERAL REQUIREMENTS: The following general requirements apply to all Fit Check Items. See section 5.0 Destination-Specific Requirements, below for any unique destination specific requirements or exceptions.

- 4.1** Seller shall manufacture one (See **Destination-Specific Requirements** below) representative FCI using standard production methods.

- 4.2 FCI(s) submitted shall be complete including final finish, unless noted otherwise in **Destination-Specific Requirements** section, below.
- 4.3 Seller shall identify FCI(s), by non-permanent method (e.g., tag, placard, etc.), as a "FIT CHECK ITEM" and shall indicate part number, drawing revision, and/or POIS revision.
- 4.4 Seller shall provide evidence that appropriate manufacturing plan approvals have been completed as required.
- * 4.5 Seller shall complete a FAI report as required by this PO (F-16 or C-130 Program) prior to presentation of Item(s) for Fit Check and final acceptance by Buyer. The FAI shall include verification of FCI whenever it is required. A copy of the FAI must be submitted with the FCI.
- 4.6 Seller shall identify, package and ship the completed FCI according to PM 5010 and any additional Destination-Specific Requirements noted below.
- * 4.7 Any additional production Items manufactured by Seller prior to successful completion and notification of Buyer FCI acceptance shall be solely at Seller's risk, unless, and until, Seller has received prior written approval from Buyer.
- * 4.8 If authorized by Buyer to ship production items concurrent with the FCI, Seller shall complete two (2) Procured Material Reports ("PMR"): one PMR for the FCI and a second PMR for the accompanying production part(s). **Whenever possible, ship the FCI and accompanying production items together in the same container.** If multiple containers are required, the FCI shall be shipped in box number one (1). Any accompanying production item(s) shall be shipped in boxes number two (2) and on. Identify **all** shipping container(s) with the appropriate Destination-Specific FCI placard noted below.

5.0 DESTINATION-SPECIFIC REQUIREMENTS:

5.1 FCI shipping to **Fort Worth, TX**

- * 5.1.1 Seller shall manufacture one (1) FCI. FCI shall be shipped to the Buyer location specified in this PO.
- 5.1.2 Final Finish -- Seller may omit final finish on FCI.
- * 5.1.3 When Seller elects to omit final finish on FCI, Seller shall provide a sketch or identify on the FCI the type and location of final finish, including electrical bond areas, when applicable, and markings to be applied to production parts.

- * **5.1.4** Container Marking -- Seller shall clearly identify the outside of **all** containers containing FCI and/or accompanying production item(s), with an 8-1/2" X 11" (approximately) placard which specifies the following:

FIT CHECK ITEM
Box No. ____ of ____
Deliver to: Receiving Dock
Fit Check Crib

- ** 5.1.5 FCI that has successfully completed Fit Check shall be returned to Seller and retained, until and unless Buyer provides final disposition instructions.
- ** 5.1.6 While retaining FCI at Seller's facility, Seller shall protect FCI against damage/deterioration, and shall use the FCI as a guide during final acceptance activities.

5.2 FCI shipping to Marietta, GA

- * **5.2.1** Seller shall manufacture one (1) FCI complete per all PO requirements and ship to the Buyer location specified in this PO.
- * **5.2.2** Container Marking -- Seller shall clearly identify the outside of **all** containers containing FCI and/or accompanying production item(s), with an 8-1/2" X 11" (approximately) placard which specifies the following:

FIT CHECK ITEM
Box No. ____ of ____
Deliver to: Receiving Dock
* **Building # B-1**

- * **5.2.3** The PMR shall include the following text within Block 11 :

*****FIT CHECK ITEM*****
* **Deliver to: Receiving Dock Building #B-1**

- * **5.2.4** FCI that has successfully completed Fit Check will be accepted and retained as a production item, and will not be returned to Seller.

- ** **5.3** FCI(s) shipping to any of the following destinations per PO requirements:

- a) Meridian, MS
- b) Pinellas, FL
- c) Clarksburg, VA
- d) Johnstown, PA

- ** 5.3.1 A copy of the FAI report shall be mailed to Buyer when a C-130 FCI is shipped directly to Johnstown, Meridian, and Pinellas feeder plant facilities. The mailing address is:

Lockheed Martin Aeronautics Company
Dept. 274M, Mail Zone 0392
Attention: PQA
86 South Cobb Drive
Marietta, GA 30063

A copy of the FAI report shall be mailed to Buyer when a F-16 FCI is shipped directly to Pinellas, FL. The mailing address is:

Lockheed Martin Aeronautics Company
Dept. 274, Mail Zone 5809
Attention: PQA
PO Box 748
Fort Worth, TX 76101

- * 5.3.3 Seller shall manufacture one (1) FCI complete per all PO requirements and ship to the Buyer location specified in this PO.
- * 5.3.4 Contact the "F-16 Outsource Team" via Fax at (817) 762-1566, or the "C-130 Outsource Team" via Fax (770) 494-4042, Attention: PQA, as required.
- 5.3.5 Container Marking -- Seller shall clearly identify the outside of **all** containers containing FCI(s) and/or accompanying production items, with an 8-1/2" X 11" (approximately) placard which specifies the following:

FIT CHECK ITEM
Box No. _____ of _____

- ** For F-16 or C-130 Program FCI shipped directly to the Pinellas Park, Florida address, identify placard:

Address : Lockheed Martin Aerospace -Pinellas
9300 28th Street North
Pinellas Park, FL 33782
USA

FIT CHECK ITEM
Box No. _____ of _____
Attn: Quality Assurance
Ph. # 727-578-6942

- * 5.3.6 FCI that has successfully completed Fit Check will be accepted and retained as a production item, and will not be returned to Seller.

6.0 ACCEPTED FCI:

- * **6.1** Buyer shall provide Seller with electronic notification of FCI acceptance.

7.0 FAILED FCI:

- * **7.1** Buyer shall provide Seller with electronic notification of all FCI non-conformances.
- 7.2** Any nonconforming Item identified during Buyer FCI process will be returned to Seller for processing in accordance with Seller's internal system for processing nonconforming Items.

8.0 RESUBMITTAL OF A FAILED FCI:

- 8.1** Prior to resubmitting a previously failed FCI, Seller shall provide:
- a) Description of root cause,
 - b) Description of corrective/preventive action(s) taken,
 - c) Effectivity of corrective/preventive action(s), and
 - d) Copy of Buyer's problem report that was returned with the Item.

9.0 FIT CHECK RECORDS:

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