

Quality Requirements Q3R – Fit Check

Notice: A hard copy of this document may not be the document currently in effect. The current version is always the version on the Lockheed Martin network.

1.0 SCOPE: This Clause Q3R establishes the requirements for a “Fit Check Item”, as such term later defined herein, and Buyer approval of Items (including “items” and “Work” as such terms may be used in this PO’s definitions) 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. The FCI is submitted to the Buyer’s facility specified in the Purchase Order 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) is performed, forward a copy via Fax to “Outsource Team” @ (817) 762-1566 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.

3.4 Contact the “Outsource Team” via Fax @ (817) 762-1566 if there is any question determining if a FCI submittal 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 either one or two (See **Destination-Specific Requirements**, below) representative FCI(s) 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/PDS revision.
- 4.4 Seller shall provide evidence that appropriate manufacturing plan approvals have been completed as required.
- 4.5 Seller shall complete a First Article Inspection (“FAI”) report as required by this PO prior to presentation of Item(s) for Fit Check and final acceptance by Buyer. The FAI shall include verification of both Fit Check Items whenever two Fit Check Items are required. A copy of the FAI must be submitted with the FCI.
- 4.6 Seller shall identify, package and ship the completed FCI(s) 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(s), Seller shall complete two (2) PMR(s): one PMR for the FCI(s) and a second PMR for the accompanying production parts. **Whenever possible, ship FCI(s) 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 items 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(s) shipping to Fort Worth, TX

- 5.1.1 Two (2) FCI(s) -- Seller shall manufacture two (2) Fit Check Items. One (1) FCI shall be shipped to the Buyer location specified in the PO, and the other shall be retained at the supplier’s facility for future reference.
- 5.1.2 Final Finish -- Seller may omit final finish on FCI(s).

5.1.3 When Seller elects to omit final finish on FCI(s), Seller shall provide a sketch or identify on the FCI(s) 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(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 ____
Deliver to: Receiving Dock
Fit Check Crib

5.2 FCI(s) shipping to Marietta, GA

5.2.1 One (1) Machined FCI -- Seller shall manufacture and deliver one (1) machined part FCI complete per all PO requirements.

5.2.2 Two (2) Sheet Metal FCI(s) -- Seller shall manufacture two (2) sheet metal FCI(s) complete per all PO requirements. One (1) FCI shall be shipped to the Buyer location specified in the PO, and the other shall be retained at the supplier's facility for future reference.

5.2.3 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 ____
Deliver to: Receiving Dock
Building # B-27

5.2.4 Packing Sheet Routing Instructions - Include the following text within the body of the Packing sheet:

*****FIT CHECK ITEM*****
Deliver to: Receiving Dock Building #B-27

5.2.5 FCI(s) that have successfully completed Fit Check, will be accepted and retained as a production item, and will not be returned to the seller.

5.3 FCI(s) shipping to any of the following destinations:

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

- 5.3.1** One (1) Machined FCI -- Seller shall manufacture and deliver one (1) machined part FCI complete per all PO requirements.
- 5.3.2** Two (2) Sheet Metal FCI(s) -- Seller shall manufacture two (2) sheet metal FCI(s) complete per all PO requirements. One (1) FCI shall be shall be shipped to the Buyer location specified in the PO, and the other shall be retained at the supplier's facility for future reference.
- 5.3.3** Contact the "Outsource Team" via Fax @ (817) 762-1566 if there is any question determining whether one or two FCI(s) are required.
- 5.3.4** 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 ____
- 5.3.5** Seller shall provide an **additional copy** of the shipping documentation package, including a copy of the FAI, to Buyer.
- 5.3.6** FCI(s) that have successfully completed Fit Check, will be accepted and retained as a production item, and will not be returned to the seller.

6.0 Accepted FCI:

- 6.1** Buyer shall provide Seller with written notification of FCI acceptance.
- 6.2** When an acceptable FCI is returned to Seller from Lockheed Martin Aeronautics Company Fort Worth, TX, Seller shall retain FCI(s) until Buyer provides final disposition instructions.
- 6.3** While retaining FCI(s) at Seller's facility, Seller shall protect FCI(s) against damage/deterioration, and shall use the FCI, as a guide during final acceptance activities.

7.0 FAILED FCI:

- 7.1** Buyer shall provide Seller with written notification of all FCI nonconformances.
- 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.