

## SELLER QUALITY REQUIREMENTS QCS-001 PROCESSING SOURCES

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*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.*

### **A. GENERAL REQUIREMENTS**

1. Seller, where used herein, is defined as a QCS-001 Source performing work for either a Lockheed Martin PO or for a Lockheed Martin subtier's purchase order where work is performed for Lockheed Martin Items.
2. QCS-001 is used to identify both the process sources and the processes that require Lockheed Martin approval, prior to use for Items delivered to Lockheed Martin. A controlled process is an operation performed on an Item where the operation is not readily inspectable subsequent to its conclusion. Controlled processes have verifiable controls inherent to the process i.e. heat treat, plating, nondestructive testing, etc.

The controlled processes listed in QCS-001 are not applicable to standard hardware (nuts, bolts, washers, etc.) that is ordered to military, federal or industry specifications or standards (e.g., MS, AN, NAS, etc.) or to metallic raw material (plate, sheet, bar, extrusion, etc.) that is purchased from a mill.

The list of both Lockheed Martin-controlled processes and Lockheed Martin-approved sources can be found on Lockheed Martin's Internet Home Page at:

<http://www.lmaeronautics.com/material-management>

- Select "Quality Requirements"
- Select "QCS-001 Directory"
- Select "QCS-001 Links" to view:
  1. Specification Index
  2. Inquire by Processor (Vendor) Name, Process code or Name of Process
- Select "Other Helpful Links" to view:
  1. Corporate Process Checklists
  2. Corporate Job Audit Sheets
  3. Material Management Process Checklists
  4. Material Management Product Guides

3. Seller shall identify in writing to Buyer, the personnel holding Level II and Level III certification for performing the following nondestructive test methods. (**Note:** Seller must retain a copy of this list for Seller's internal records):
  - a. Radiography
  - b. Penetrant
  - c. Magnetic Particle
  - d. Ultrasonic

Seller shall notify Buyer of changes to the Level II and Level III personnel identified to perform the nondestructive test methods identified above within 48 hours of such changes being made.

Buyer shall notify Seller if an on-site review of Seller's Level II or Level III personnel is required. Buyer shall provide Seller instructions for delivery of items prior to completion of Buyer's on-site review.

4. A process approval for a given process will include all variants of the process unless otherwise noted in the limitation of the QCS-001 listing.

#### **B. Quality System**

1. Seller shall maintain a documented Quality System that meets the requirements of Appendix QJ and this PO for the Items (including "items" and "Work" as such terms may be used in this PO's definitions) covered herein.

#### **C. Access to Facilities**

1. Seller shall provide and obtain for Lockheed Martin, Lockheed Martin's Customers, and appropriate regulatory agencies access to any and all facilities, including those facilities Seller's subcontractors, where work on Items is being performed or is scheduled to be performed under this Purchase Order ("PO"). Lockheed Martin shall have right to perform in-process inspection, audits, and system surveillance at Seller's and Seller's subcontractors' facilities as part of verification of conformance to the requirements of this PO.

Work under this PO is subject to Lockheed Martin's periodic audit of Seller's compliance with Seller's internal procedures and other documents applicable to this PO. Seller shall provide, at no cost to Lockheed Martin, Government or appropriate regulatory agencies, suitable facilities at Seller and Seller's subcontractors' manufacturing locations for Lockheed Martin, Government, and regulatory agency representatives to perform compliance verification. Seller shall include the provisions of this paragraph E in each purchase order, if any, with each of its subcontractors where work is being performed or is scheduled to be performed in connection with this PO, and shall require that this paragraph E is inserted in all subcontracts at every tier.

**D. Contract Review and Planning**

1. Seller must maintain and control QCS-001 processes through written work instructions or planning.
2. Seller shall have a system in place to ensure that all Lockheed Martin unique requirements are translated to operational work instructions or planning.
3. Seller shall review all purchase orders to ensure that purchase orders contain referenced specification(s), revision level(s) and drawing(s) requirement(s).
4. Seller shall have a documented system to ensure that work instruction or planning changes are reviewed, as a minimum, by production, engineering, and quality.
5. Seller shall clearly define control of processes, training, certification of personnel, interpretation of results, and final disposition of parts, in documented procedures.
6. Seller shall ensure that personnel are commensurate with the required training and experience necessary to perform work.
7. Seller shall inspect Items received either from Lockheed Martin or Lockheed Martin's subtiers for verification of condition, quantity, serialization, when required and dimensional data, when required.
8. Seller shall have a documented system for controlling and maintaining traceability of Items processed.
9. Seller shall review QCS-001 and ensure Seller is approved to perform each QCS-001 controlled process, prior to performing work.

**E. Use or Performance of Controlled Processes or Processors  
Listed in Quality Control Specification (QCS)-001**

1. Seller shall use Lockheed Martin-approved sources for QCS-001 controlled processes.
2. Lockheed Martin approval, if any, of a QCS-001 Source to perform a QCS-001 controlled process is limited to that process specification and does not imply approval for any other process specifications embedded therein.

**Note:**

Where Lockheed Martin's approval is a requirement within a process specification, approval will be controlled by Lockheed Martin. (Examples: Penetrant demonstration programs, heat-treat re-qualification programs, etc.)

3. Seller shall ensure testing performed in-house is certified as meeting required drawing or specification requirements.
4. Seller shall be responsible for ensuring that Seller has the appropriate revision level of the process standards or specifications prior to performing work in connection with the Items.
5. Seller shall ensure process controls are established and required process control tests are accomplished at required intervals to ensure continued compliance to process specifications.
6. Seller shall, when used, have a documented system for the issuance and control of inspection stamps.
7. Seller shall ensure parts are suitably wrapped, boxed or racked to guard against shipping damage and apply rust or corrosion protection.

**F. Calibration**

1. QCS-001 Source shall maintain a calibration system that is compliant with the requirements in ISO 9001, ISO 10012-1, MIL-STD 45662A, or ANSI 2540.

**G. Product Certifications and Acceptance**

1. QCS-001 Source shall prepare and submit with each shipment a Certificate of Conformance that includes the following information:
  - a. title and specification number (including revision letter) of the process;
  - b. name and address of the process or NDT facility;
  - c. Lockheed Martin assigned processor number;
  - d. date the C of C was issued;
  - e. purchase order part number;
  - f. quantity of parts (to include quantity accepted/rejected);
  - g. signature and title of authorized quality agent of seller; and
  - h. fracture durability classification or serialization when required.

**H. Records**

1. Seller shall maintain complete records of all manufacturing, inspecting and testing in connection with the Items. At Lockheed Martin's election, such records shall be made available to the Lockheed Martin, Lockheed Martin's Customers and/or appropriate regulatory agencies during the performance of this PO and for at least seven (7) years after completion of this PO or for such longer periods, if any, as may be specified elsewhere in this PO. Upon Lockheed Martin's request therefor, QCS-001 Source shall forward such records to Lockheed Martin at no cost to Lockheed Martin.
2. Seller shall ensure all purchase orders for Lockheed Martin-approved processes, which contain the below statement, are maintained and provide, upon Lockheed Martin request:

A statement with the words, "Work to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company PO and must be accomplished in accordance with process specification on purchase order and Lockheed Martin Aeronautics Company Appendix QJ."

3. Seller shall maintain activity data on each Lockheed Martin-approved process performed for Lockheed Martin or any QCS-001 Source utilized, if any, compile an annual report, and submit to Buyer by 1 November, each year. The report shall contain the following information:
  - a. QCS-001 Source name;
  - b. Lockheed Martin's assigned QCS-001 Source number;
  - c. process specification used by specification number; and
  - d. annual frequency of use.

The report shall be mailed to the following address:

**Lockheed Martin Aeronautics Company  
Attention: Process Audit Group  
P.O. Box 748  
Mail Zone 5809 (PQA)  
Fort Worth, Texas 76101**

**I. Control and Processing Nonconforming Material and Corrective Action**

1. QCS-001 Source shall implement and maintain a system, which provides for identification, documentation, segregation and disposition of nonconforming material and shall ensure effective, positive corrective action is taken (including repetitive nonconformances dispositioned "Use As Is" by Lockheed Martin's material review board ["MRB"] actions) to prevent, minimize, or eliminate nonconformances. Seller's system shall ensure that nonconforming material is not used for production purposes.
2. QCS-001 Source shall maintain records of all nonconforming material, dispositions, assignable causes, corrective actions, and effectiveness of corrective actions for the period specified in this PO.
3. QCS-001 Source shall evaluate each nonconformance for its potential to exist in previously produced or delivered Items. If a nonconformance exists, QCS-001 Source shall notify Lockheed Martin, in writing, within 24 hours for issues impacting flight safety, and, in writing, within 5 working days for all other issues.

4. Lockheed Martin shall forward requests for corrective action, if any, to QCS-001 Source when unsatisfactory performance by QCS-001 Source and/or any of its subcontractors is detected by Lockheed Martin. QCS-001 Source shall respond to all Lockheed Martin requests for corrective action. When requested by Lockheed Martin, QCS-001 Source shall provide trend data and findings for Lockheed Martin returned Items.
5. QCS-001 Source shall assess all Lockheed Martin identified nonconformances and take the appropriate actions to ensure causes of nonconformance are corrected. If QCS-001 Source is unable to verify or duplicate the nonconformance or refuses responsibility for the nonconformance, QCS-001 Source shall notify Lockheed Martin in accordance with the instructions at: <http://www.lmaeronautics.com/material-management>.
  - Select "Quality Requirements"
  - Select "Corrective Action"
  - Select "SCAR Form" to view and print the form.

If QCS-001 Source does not respond by Seller Confirmation Action Request ("SCAR") within 30 days of receipt by QCS-001 Source of the nonconforming Item, QCS-001 Source shall be deemed to have accepted responsibility for the identified nonconformance.

#### **J. Material Review Authority and Submittals**

1. Seller dispositions, for Lockheed Martin-designed Items, are limited to scrapping of Items, eliminating the nonconformance by rework to engineering, or returning to vendor. On Items of Lockheed Martin design, Seller shall document nonconforming Items for submittal to Lockheed Martin's MRB for dispositions as required by this PO. Seller's continued processing, prior to Lockheed Martin's MRB disposition, of any Lockheed Martin-designed Items containing a nonconformance prior to Lockheed Martin's MRB disposition will be at Seller's risk.
2. All MRB submittals for Lockheed Martin-designed Items shall be submitted in accordance with Lockheed Martin instructions, located on Lockheed Martin's Internet home

page, <http://www.lmaeronautics.com/material-management>.

- Select "Quality Requirements"
  - Select "Corrective Action"
3. Seller shall not incorporate any nonconforming Items into any product, process, procedure or data that affects a parameter controlled by Lockheed Martin drawing or specification or has an effect on form, fit, function, interchangeability or reliability unless and until Seller has received prior written approval from Buyer.

Lockheed Martin and Lockheed Martin's customers shall each have the right to refuse to accept any nonconformances.

**K. Selection, Control and Requirements Flowdown to Sub-tier Sources**

1. Seller's quality system shall include procedures for determining the capability of sub-tier suppliers, prior to issuance of Seller's PO.
2. When Seller performs a Quality System Survey or Evaluation for a sub-tier supplier facility, the results of each survey or evaluation shall be documented.
3. Seller shall ensure all materials, services and components it procures for incorporation into the Items conform to all requirements of this PO.
4. Seller shall define and establish a program for determining the need for periodic re-audit or re-evaluation of Seller's sub-tier suppliers.
5. Prior to production and award of subcontracts, Seller shall institute a program that will ensure control of the quality of all Items procured by Seller in support of this PO.
6. **Seller shall include the applicable portions of this PO in each of its purchase orders, if any, with each of its subcontractors where work is being performed or is scheduled to be performed in connection with this PO and**



**require that, where applicable, such portions are inserted in all subcontracts at every tier.**

7. Seller shall maintain objective evidence that each Lockheed Martin-approved process source, selected by a Seller, is being monitored on a periodic basis to assure compliance with all applicable process specifications. Seller shall provide objective evidence of such compliance to Lockheed Martin upon request.
8. Seller shall review the list of Lockheed Martin-approved process sources, prior to using a process source for a QCS-001 controlled process, and select QCS-001 Sources that are approved by Lockheed Martin.
9. Seller's utilization of Lockheed Martin-approved sources does not relieve the QCS-001 Source from the obligation to ensure subcontracted sources are in full compliance with applicable process specifications and to deliver conforming Items. QCS-001 Source shall provide objective evidence of such compliance to Lockheed Martin upon request.
10. Seller shall ensure all purchase orders for Lockheed Martin-approved processes contain:
  - a) A statement with the words, "Work to be accomplished in performance of this purchase order is directly related to a Lockheed Martin Aeronautics Company PO and must be accomplished in accordance with process specification on purchase order and Lockheed Martin Aeronautics Company Appendix QJ."
  - b) A requirement to file and maintain a copy of all purchase orders containing the above statement and make these available for review, upon request.
  - c) A requirement to submit a Certificate of Conformance ("C of C") with a unique certification number containing the following information:
    1. title and specification number (including revision letter) of the process;
    2. name and address of the process or NDT facility;
    3. Lockheed Martin assigned processor number;

4. date the C of C was issued;
5. purchase order part number;
6. quantity of parts (to include quantity accepted/  
rejected);
7. signature and title of authorized quality agent of  
seller; and
8. fracture durability classification or serialization  
when required.

d) A requirement to ensure parts are suitably wrapped,  
boxed or racked to guard against shipping damage and  
apply rust or corrosion protection.

**L. Changes to Seller's Operations**

1. Seller shall notify Lockheed Martin, in writing, of any  
change in status of Seller's quality system as a result of  
any Government or regulatory agency action.
2. Seller shall also notify Lockheed Martin, in writing, upon  
any relocation or transfer of manufacturing operations, or  
change in any organization or procedure that could impact  
Item quality.