

# PECO PO REQUIREMENTS - MANUFACTURER

**GENERAL INFORMATION:** This document defines PECO purchased material flow-down requirements. Additional specifications may also apply and will be documented on the purchase order; all requirements must be complied with fully.

- NOTES:**
- A) Supplier is required to flow-down applicable standards to vendors for purchased product or material.
  - B) Anomalies (non-conformances) or changes in processing which deviate from first article approval must be reported to PECO before shipment of product or as soon as deviations are discovered.
  - C) The quality system of each supplier may be subject to periodic audits by PECO, its customers, and/or regulatory agencies.
  - D) Supplier must implement appropriate action to correct recurring or repetitive non-conformances.

## QUALITY SYSTEM REQUIREMENTS

**Inspection System General** – The supplier shall maintain an inspection system that complies with MIL-I-45208, ARP-9134, AS9100, and/or ISO 9001, and is acceptable to PECO. The inspection system shall ensure that all product complies to purchase order or referenced specifications.

**Inspection System Boeing-Designed Products** - The supplier shall maintain an inspection system that complies with Boeing D6-82479: (1) AS9100; or (2) AS9003. Acceptance sampling shall conform to Boeing D1-8007.

**NADCAP Accreditation** – Boeing D1-4426 suppliers, and sub-tier suppliers, must be accredited by NADCAP for heat treat, non-destructive testing, chemical processing, welding, brazing, material testing, shot peening, & composite mfg.

**Digital Data** – Boeing D6-51991 suppliers, and sub-tier suppliers, must have an approved system to control digital data, where applicable.

**Calibration System Requirements** – The supplier shall maintain a calibration system in accordance with MIL-STD-45662, or ISO-10012-1. This system shall control the accuracy of all devices used to measure, gage, test, inspect or otherwise examine items to verify acceptability of materials or services in performance of this purchase order.

**Documentation – Record Retention**

Data that provides objective evidence of implementation shall be retained for a minimum period of seven years. Retention periods begin at the end of the purchase order or contract. Storage methods must prevent, or minimize, deterioration and loss to records.

**Change in Quality Management Representative** – PECO shall be promptly notified of any changes in the Management Representative with assigned responsibility and authority for the quality system.

**Change in Quality System Procedures** - PECO shall be immediately notified, in writing, of any changes to the quality system that may affect inspection, conformity, or airworthiness of the product.

**Tooling** – Boeing tooling document D33200 is applicable for the receipt and / or fabrication of Boeing or Boeing customer-owned accountable tools.

## INSPECTION REQUIREMENTS

**Source Surveillance** – All items specified by the purchase order are subject to surveillance by our Quality Assurance staff or that of our customers. Suppliers shall provide all the necessary inspection equipment needed to substantiate complete conformance of materials or services and a suitable area for this inspection. This may include a review of the suppliers' inspection system, procedures, and quality or test records.

**First Article Inspection (FAI)** – The supplier shall perform and document a 100% FAI on one representative piece or sample of material. FAI, to include tool/fixture modifications, shall be conducted in accordance to PECO Mfg. document WI: 8-04, or to requirements specified in AS9102. The supplier shall submit a marked-up drawing denoting item numbers corresponding to the FAI Report and sample part(s).

**Statistical Process Control** – Parts containing special control characteristics (KEY CHARACTERISTICS) as indicated on the drawing or by special requirement on the purchase order shall include process capability data. A process capability plan must be approved in writing by PECO prior to delivery of materials or services when this requirement applies.

## TECHNICAL / CERTIFICATION REQUIREMENTS

**Certification of Conformance (COC)** – Each shipment shall be accompanied by one legible copy of a COC which includes a statement that attests to the supplier's conformance with all the requirements of the purchase order. At a minimum, this COC shall contain the following:

1	Conformance Statement.
2	PECO Purchase Order Number.
3	PECO Part Number.
4	Part Revision.
5	Supplier's Shipping Document Number.
6	Serial Numbers, Lot Numbers and Heat or Batch Number, as applicable.

**Raw Material, Chemical and Physical Test Reports** – Each shipment shall be accompanied by one legible copy of a certified test report listing the actual results of tests (mill or independent lab certifications) for all materials supplied. These reports must agree in every respect with the raw material, chemical and physical requirements of the applicable specification(s).

**Special Process Certifications** – Each shipment shall be accompanied by one legible copy of a certified special process test report. Special processes include, but are not limited to, heat treating, plating, coating, non-destructive testing, etc. The certificate shall include all specifications and revisions, type or class (if applicable), the date, number acceptable and rejectable with inspector's stamp for inspection results (NDT), part number, quantity, PECO purchase order number and the signature of a duly authorized supplier representative.