



PUR-REC-002

# Quality Codes

Rev: 20240105



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## Introduction

This document provides requirement details for Quality Codes that are placed on purchase orders by Beehive Industries (Beehive) to ensure the relevant requirement(s) are communicated to the supplier. The supplier's failure to comply with all codes specified on the PO will be cause for rejection of the products/services they provide.

# Quality Management System Requirements

## A. QMS

The Supplier must have a Quality Management System (QMS) compliant to AS9100.

## B. Survey/Audit

The Supplier's inspection/QMS is subject to survey/audit.

## C. Product Conformity

Unless otherwise specified by written approval, the supplier's product/service must conform to all drawings, specifications, and PO requirements.

## D. Handling of Sub-tiers

The Supplier must ensure that their sub-tier suppliers are compliant to all Quality Codes and specifications on the PO.

## E. Inspection/Nonconformances

Any product/service failing inspection is to be labeled nonconforming and placed on hold until a written authorization/disposition is obtained.

## F. Record Retention

The Supplier must retain all product/service documentation/records for 5 years unless otherwise specified in PO.

## G. Right of Entry

All work performed is subject to inspection, surveillance and/or test, including the period of performance, at the Supplier's facility and/or any of the supplier's sub-tiers.

## H. Notification of Changes

The Supplier must notify Beehive within (2) business days of any changes that would impact the Supplier's ability to meet PO requirements which include, but are not limited to change in certification, process capabilities, etc. The Supplier must notify Beehive within (5) business days of any organizational changes which include but are not limited to, changes in management, location, company name, special processes, etc.

## I. Communicating Language

The Supplier must communicate in English and all documentation must be in English.

## J. Competence

The Supplier must ensure that personnel providing Beehive with product/service are deemed competent based on education, training, experience, and/or certification.

## K. Counterfeit Prevention

The supplier's Certification of Conformance represents that the shipment does not contain any "suspect" or "known" Counterfeit Part, Material, or Work\* and ensures that parts, material, or work are procured only through Original Equipment Manufacturers (OEMs)/Original Component Manufacturers (OCMs) or their Franchised Distributors or Authorized Supplier. Any use of other than an Authorized Supplier\* requires Beehive Industries written approval prior to procurement and use, which shall be contained within the deliverable data package.

The supplier shall verify the procurement source and associated certifying documentation.

Supplier's receiving inspection process shall utilize incoming inspection or test methods, or both, to detect potential counterfeit parts, material, or work.

The supplier shall flow this clause in its entirety or equivalent (replacing "Beehive Industries" with "supplier") down to all lower tier subcontracts to prevent the inadvertent use of Counterfeit Parts, Material or Work. When an Authorized Supplier is not utilized by the supplier's lower tier, the supplier shall provide a copy of the risk assessment and their written approval within the deliverable data package.

## L. Ethical Behavior

The Seller must set forth the shared accountability of each of its employees to conduct business with honesty and integrity. Example: Code of Ethics or equivalent.

## M. Performance Monitoring

The Supplier may be issued a Supplier Corrective Action Request (SCAR) for performance issues and will be required to identify root cause(s) and implement corrective action(s) for any SCAR. The corrective action(s) must be approved by Beehive before the SCAR can be closed.

## N. Product Safety

The Supplier must have control of the processes needed to assure product safety during the entire product life cycle, as appropriate to its organization and that it provides no risk or minimum acceptable level of risk, considering the normal or reasonably foreseeable use of the product.

\*Review PUR-REC-003 Counterfeit Definitions for clarification.

## QC 2

# First Article Review/ Approval

The Supplier must submit one part for First Article Inspection (FAI) in accordance with the latest revision of AS9102 to [PropulsionQuality@beehiveind.com](mailto:PropulsionQuality@beehiveind.com) ahead of first parts shipping.

## QC 3

# In-Process Controls

The Seller must have a system for controlling the hardware throughout the manufacturing process. This may be accomplished using a manufacturing outline, part traveler, shop routing or other suitable method which details the planned step by step operation sequence, inspection points and provisions for controlling the drawing/specification revision status during the manufacturing process.

## QC 4

# Material Certification

The Supplier is required to retain material certification(s) in accordance with the specifications specified on this order. If no specification is provided on PO, industry standard specifications must be used. Raw material must have an MTR and no raw material can contain conflict material/minerals. Materials must be in accordance with DFARS 252.225-7009.

## QC 5

# Beehive Supplied Material

The supplier must maintain traceability on materials furnished by Beehive. If a serialization schedule is provided on the purchase order or if components have been individually tagged, serialization must be maintained throughout the product realization process.

## QC 6

# Calibration

The Supplier must implement and maintain a system for control and use of inspection and/or processing equipment in accordance with MIL-STD-45662. All inspection and/or processing equipment must be calibrated against certified standards which have known valid relationships traceable to National Standards. Calibration reports must be available upon request.

## QC 7

# Nonconforming Material

The Supplier must use a system to promptly identify and contain nonconforming material to prevent outflow to the customer as well as a system for assuring prompt action to correct the cause of nonconformance.

## QC 8

# Final Inspection

The Supplier must verify/validate the purchase order requirements/acceptance criteria has been met before the product leaves their facility.

## QC 9

# Certificate of Conformance

Before each shipment a CoC shall be submitted to [PropulsionQuality@beehiveind.com](mailto:PropulsionQuality@beehiveind.com). CoC shall include dated Certificate of Conformance stating the product/service provided is in accordance with all specified purchase order requirements.

## QC 10

# Source Inspection

Beehive, or its customers, reserve the right to inspect products/services at the supplier's location.

## QC 11

# Protection of Materials in Transit

Product must be packaged in a manner to prevent any damage in shipment and storage and must be identified with purchase order number, part number, and date. Any special packaging requirements on the purchase order will take precedence.

## QC 12

# Inspection Gaging

The Supplier is responsible for the protection and care of Beehive provided gaging. Gaging must be returned in acceptable condition upon completion of this order or upon Beehive's request.

#### QC 13

## Tooling

Beehive tooling must be used exclusively for this PO. Unauthorized alteration of tooling is prohibited. The Supplier is responsible for the protection and care of the tooling. Tooling must be returned in acceptable condition upon completion of this order or upon Beehive's request.

#### QC 14

## Special Process Procedure Approval

The Supplier is required to submit a written procedure, manufacturing outline, or shop routing detailing the planned step-by-step operation sequence, inspection points and provisions intended for processing for approval. No material processing is permitted until Beehive has provided written approval/authorization for those processes.

#### QC 15

## NADCAP Certification

This purchase order has special process requirements where the supplier and/or sub-tier suppliers must be NADCAP certified.

#### QC 16

## Statistical Process Control

The Supplier must implement and maintain a system for Statistical Process Control (SPC). The Supplier's control plan and procedures must be submitted to the Beehive for review and approval. All control plans, control charts, capability studies and any corrective actions taken on the process must be provided with each shipment.

#### QC 17

## Critical Items/Key Characteristics

The Product contains feature(s) identified as a "Critical Item" or "Key Characteristic". The Supplier must take additional actions as called out in the PO requirements to address these.

#### QC 18

## Special Handling Requirements

The product has stringent dimensional and cosmetic requirements. If there are no specific packaging requirements listed on the purchase order, then extreme care and handling must be exercised by the Supplier to prevent any damage.

#### QC 19

## Calibration Services

Supplier must use equipment that has been calibrated and maintained using standards which are traceable to the National Institute of Standards and Technology (NIST).

Calibration certifications for equipment must contain the following information:

- A. Supplier name.
- B. Supplier's Certification number.
- C. Equipment description.
- D. Equipment ID (model no., serial no.).
- E. Date calibration performed.
- F. Description of standard(s) and method(s) used for calibration.
- G. NIST traceability information.
- H. Date of standard(s) calibration.
- I. Due date of standard(s) next calibration.
- J. Identification of personnel performing calibration services.
- K. Measured values.
- L. Applicable environment conditions.

Measuring, test, and processing equipment must be packaged to prevent damage in shipment or storage. All product found to be out of manufacturer's specified tolerances must be reported to Beehive.

## QC 20

# ITAR and/or EAR

## ITAR Warning Statement

The export of documentation or files sent that contain technical data is, or may be, restricted by the Arms Export Control Act and the International Traffic in Arms Regulations (ITAR). Diversion contrary to U.S. law is prohibited. The export, re-export, transfer, or re-transfer of this technical data to any other company, entity, person, or destination, or for any use or purpose other than that for which the technical data was originally provided by the customer is prohibited without prior written approval from the customer and authorization under applicable export control laws.

## EAR Warning Statement

The export of documentation or files sent that contain technical data is, or may be, restricted by the Arms Export Control Act and the Export Administration Regulations (EAR). Diversion contrary to U.S. law is prohibited. The export, re-export, transfer, or re-transfer of this technical data to any other company, entity, person, or destination, or for any use or purpose other than that for which the technical data was originally provided by the customer is prohibited without prior written approval from the customer and authorization under applicable export control laws.

## QC 21

# Dimensional Inspection

Supplier must perform 100%-dimensional inspection to the provided print/requirements. Inspection equipment used must meet requirements of QC 6.

## QC 22

# FOD Prevention

Supplier must ensure work is accomplished in a manner preventing foreign objects or material in deliverable Items. Seller must maintain work areas and control tools, parts, and materials in a manner sufficient to preclude the risk of foreign object damage (FOD) incidents.

## QC 23

# Lot Control

A unique identifier assigned to products provided to Beehive Industries. This unique identifier will enable the ability to track an item's historic origin, production date and movement through the manufacturing cycle to Beehive Industries PO number. If serialization is required per the PO a unique serial number will be assigned and marked per drawing requirements.

