



August 2020

Notice of Supplier Quality Assurance Requirements Policy (SQAR)

Dear Valued Supplier:

Supplier Quality Management has emerged as a leading business practice, driven by requirements established in ISO and AS9100 Quality Management Systems (QMS) standards. Digital Systems Engineering, a registered AS9100 company, joins the ranks of world-class manufacturers making significant investments in their QMS and business processes to improve Supplier Quality, thereby effecting DSE's Finished Goods Quality.

Supplier Quality is Critical

Our business relationship is cooperative – improved Quality on products shipped positively affects our end product. Quality measurements important to us are: Supplier's Quality, meeting Purchase Order requirements, correct pull of parts, proper ESD handling and secure packaging, on-time delivery and responsiveness to our inquiries and RMA requests. In return, we pledge to continue to conduct business fairly, clearly communicate our Quality Requirements and pay within terms. We believe that when working together, both companies will benefit.

Supplier Quality Assurance Requirements (SQAR) Policy

We believe that Suppliers providing product to DSE are driven to maintain a 'Preferred Supplier' status in order to continue our business partnership. Purchased goods should continue to meet or exceed acceptable Quality thresholds as indicated in DSE's document, Supplier Quality Assurance Requirements (SQAR). Our Purchase Orders call out specific required sections of the SQAR. In addition, passing down to Suppliers our Quality Requirements is one of the AS9100 directives.

SQAR Document

In the attached Revision G, please review all sections. New is Packing Slips (215) and CoC Requirements (130) is clarified. The SQAR document is downloadable from www.digitalsys.com; Other downloadable DSE Supplier documents are: Supplier Confidentiality Agreement, Notice of Packing Slips, Test Reports and Certificate of Compliance, and Notice of RMA Policy.

DSE Purchase Orders


On DSE Purchase Orders (PO), the following SQAR sections are called out for General Suppliers: 101, 102, 110, 130, 137, 170, 172, 200, 211, 212, 215. These requirements are listed in the Notes field of a DSE PO. The Supplier is responsible for understanding the SQARs indicated; reference the SQAR section number in the SQAR document.

We are confident that you realize the importance of your contributions to Product Conformity, Product Safety, and recognizing the importance of Ethical Behavior, are all important elements that contribute to DSE's success. We look forward to a productive, evolving quality future. If there are comments or questions, please call or e-mail Purchasing@digitalsys.com.

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Rev.	Date	Nature of Changes	Approved By
F	10-9-17	Revised to remove ISO/AS9100 numbering system. Added updates from latest AS9100 standard.	Meredith Downing
G	6-24-2020	Added 215, Packing Slips; Clarified Section 130, CoC	Meredith Downing

The following applicable Digital Systems Engineering, Inc Supplier Quality Assurance Requirements (SQAR) clauses of this document are to be referenced by clause number on the Purchase Order (PO) contract and shall be considered an integral part of such. Digital Systems Engineering, Inc hereinafter is referred to as 'Buyer' and the Supplier referenced to as 'Seller'.

We are confident that you realize the importance of your contributions to product conformity, product safety, and recognizing the importance of ethical behavior, are all important elements that contribute to DSE's success. Thank you.

Definitions:

- 'Shall' and 'Must' express mandatory requirements
- 'Should' expresses a recommendation or advice on implementing said requirement. Buyer encourages these recommendations or best practices be followed
- 'May' expresses a permissible practice or action, and
- 'Will' expresses a provision or intention in connection to the requirement.

General SQAR Statement

Unless otherwise specified, all specifications and standards referenced as part of the PO through this SQAR shall be the latest issuance in effect at the time of PO placement.

Military Standard or Specification

In the event a Military Standard or Specification Is cancelled or superseded, the superseding documents should be used. If no superseding document is cited or known, the latest revision prior to cancellation should be used. Direct any questions to Buyer's Purchasing Agent placing the PO.


100 General Supplier Requirements

Requirements for documenting (forms, reports, tests) are cited within that relative section. All certificates, documents, forms and reports are to be legible, electronic or in permanent ink, and submitted in English to Buyer's Purchasing Agent identified on the Purchase Order. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

The Supplier shall be responsible for complying with Quality System requirements noted on the PO and for meeting Quality performance expectations. Failure to comply with Quality System requirements or to achieve an acceptable Quality performance level may result in an on-site audit or additional source inspection.

101 Supplier Quality System Review

Buyer shall be responsible for monitoring Supplier performance to ensure compliance to Quality Requirements. Initial and subsequent periodic review of the Supplier's Quality System may be performed

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at the option of Buyer. Objective evidence of Supplier's compliance either by submittal of objective evidence, or evidence of a third-party accreditation, may be acceptable, but will not preclude the use of an on-site evaluation or other review methods determined by Buyer. Seller's system shall be subject to audit by Buyer.

At its discretion, Buyer may honor qualified second or third-party audits, provided the scope of the performed audit correlates with the type of product service being provided to Buyer.

102 Quality System Program Requirements

Seller's Quality Systems Program for Quality Assurance in Design/Development, Production, Installation, and Services contracted by this PO shall be controlled by a documented 'Quality Systems Program' that complies with AS9100, ISO 9001 or an equivalent program accepted by Buyer. Contact Buyer's Quality Assurance Manager with questions.

Quality Program Requirement compliance with the provisions of this clause in no way relieves the Seller of the final responsibility to furnish acceptable supplies or services. Seller's system shall be subject to audit by Buyer and/or Buyer's Customer.

Supplier shall also convey the importance of their personnel's contributions to product conformity, product safety, and recognizing the importance of ethical behavior; these are flow-down requirements of the AS9100 International Quality System Standard of which the Company is registered.

103 Supplier Quality Program Requirement: Department of Defense Contract

Seller agrees to provide and maintain a quality assurance program which is in conformance with Military Specifications: MIL-Q-9858 entitled "Quality Program Requirements" and MIL-STD-45662 entitled "Calibration System Requirements". Any revisions or amendments to these specifications in place at the time of PO contract shall be controlling, notwithstanding the release of any revisions or amendments after the time of contract.

104 AS9003 Inspection and Test Quality System


Seller shall provide and maintain a system that complies with AS9003 Inspection and Test Quality System to ensure the inspection, conformity and airworthiness of products are maintained. The provisions of this clause in no way relieve the Seller of the final responsibility to furnish acceptable supplies or services. The system shall be subject to audit by Buyer. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

110 Right of Access

Buyer shall reserve Right of Access by Buyer, their customer, and regulatory authorities to the applicable areas of all facilities, at any level of the supply chain involved in the Purchase Order and all applicable records involved in the Purchase Order. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

111 Certificate of Government-Approved QPL Source

Seller's acceptance of this contract and subsequent shipment to Buyer shall constitute a warranty that the manufacturer of material described herein has been granted qualifications by the Defense Supply Agency (DSA) (or its successor) in accordance with applicable military specifications and accordingly shall appear on the Quality Products List (QPL) (or its equivalent if the QPL has been superseded or obviated) for that category of supplies.

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112 Buyer Source Inspection

All items covered by this PO may require inspection, by Buyer, at Supplier's facilities prior to shipment. Supplier agrees to furnish, at no cost to Buyer, acceptable facilities and equipment necessary to perform the required inspections. Evidence of Source Inspection shall accompany each shipment of goods or material.

Note: When requesting Source Inspection, notify Buyer's Purchasing Agent referenced on this PO at least five (5) business days in advance.

Supplier must obtain sign-off by Buyer Quality Representative on the shipping document prior to shipment of material. Failure to do this may result in rejection of the material by Buyer's Receiving Inspectors.

113 Buyer In-Process Inspection

All items covered by this PO are subject to surveillance by Buyer, to include but not limited to, the Supplier's procedures and facilities. Supplier also agrees: to provide acceptable facilities and equipment to allow Buyer to conduct surveillance; supply data as needed to fulfill the surveillance function and to perform testing as required by applicable documentation.

Note: When requesting In-Process Inspection, notify Buyer's Purchasing Agent referenced on this PO at least five (5) business days in advance.

114 Government Source Inspection (Department of Defense)

Government inspection shall be required prior to the shipment from the Seller's. Upon receipt of this PO, promptly notify the Government Representative who normally services the plant so appropriate planning for Government inspection can be completed.

115 Supplier Deviation or Waiver Form

All departures from drawings, specifications or other PO requirements must be recorded and reported on either the Supplier's or Buyer's deviation or waiver form or as stated on the PO.

Disposition of these departures must be approved by Buyer VP of Operations prior to shipment. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

116 Supplier's Controlled Products


The initial shipment on this PO shall be accompanied by one (1) legible and reproducible copy of applicable specifications and/or drawings. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

120 Protection of ESD-Sensitive Part Numbers

Seller shall implement an electrostatic discharge control (ESD) program in accordance with ANSI/ESD-S-20.20 or equivalent. Product shall be processed in a manner to protect from ESD damage. Product packaged for shipping shall be labeled to alert all handlers that the devices require special handling.

121 Identification of Limited-Shelf-Life Material

Seller shall identify each item, package or container of limited-shelf-life material with the cure or manufacturer date, storage temperature and special handling conditions. In addition to the normal identification requirement of name, part or code number, specification number, type, size, quality and

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manufacturing recommended shelf life. This identification, including special handling conditions, shall be recorded on the Certifications and Shipping documents for the PO material.

122 Supplier Re-Approval Process

Supplier approval shall be re-evaluated at Buyer's discretion. Approval shall be subject to Buyer's Supplier Quality Analysis regarding the Supplier's quality performance history and/or any significant changes in the Supplier's Quality System.

It is the responsibility of the Supplier to provide Buyer a written statement of any changes in the Supplier's management, ownership, location/address and/or Quality System. Any of these changes may require Buyer Quality re-approval. This notice shall be sent to the Buyer Purchasing Department (Purchasing@digitalsys.com) and a copy to the Buyer Quality Assurance Department (Quality@digitalsys.com). Upon receipt of written notification, Buyer shall determine what types of approval activities are required.

123 Supplier Performance Requirements

1) On-Time Delivery

It is expected Products shall be provided no later than dock date established on the Purchase Order. The Supplier's Performance for On-Time Delivery shall be evaluated and deliveries earlier than five (5) business days and later than one (1) business day of the established Purchase Order date may adversely affect Supplier Rating and status as an "Approved Supplier". This shall be evaluated on a three (3) month rolling platform.

All shipments earlier than five (5) business days may be refused or returned at the Supplier's Expense.

2) Product Quality


It is expected Product and/or Services provided shall be 100% free of defects and be compliant with all applicable Material and Performance Requirements. Supplier's Quality Acceptance Performance shall be evaluated (number of lots of rejected / total number of lots received) and acceptance rates of less than 98.5% could adversely affect the Supplier's rating and status as an 'Approved Supplier'.

130 Certificate of Compliance: Material Conformance

Each shipment shall be accompanied by a legible and reproducible Certificate of Compliance to Material Conformance, commonly known as a Certificate of Compliance or CoC. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

At a minimum, a CoC shall include a Statement:

1. The items being procured were produced from material which the Seller has available for examination, and/or
2. Seller has available specific data or other objective evidence that the Part Number conforms to the applicable specifications called out in the PO and that this information shall be made available for review by Buyer; examples: revision, drawings, Supplier Quality Assurance Requirements (SQAR) sections.

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3. If Buyer-supplied material shall be used in the manufacture of the items, the CoC shall include a statement that the material supplied was used in the manufacturer of the items in the manner required by the applicable drawings and/or specification(s)
4. For Part Number(s) per shipment, not per piece
5. For partial or complete shipments
6. Between the CoC and the Packing Slip, which may be the same form or two separate forms, the following shall be included:
 - a. Supplier Name and Address
 - b. Supplier Contact Information
 - c. Supplier Reference Number
 - d. Date of Shipment
 - e. Compliance Statement
 - f. Authenticator's Title and Signature
 - g. Purchase Order
 - h. Part Number
 - i. PN Revision as applicable
 - j. Part Quantity Shipped
 - k. Part Quantity Backordered
 - l. Serial Number label data as applicable
 - m. Date/Lot Code as applicable, and
 - n. Dates of Expiration of Rubber, Consumables if not indicated on packaging

It is acceptable to reference and/or include the Packing Slip (Section 215) within the CoC.

131 Certificate of Compliance: Special Process


Each shipment shall be accompanied by a legible and reproducible Certificate of Compliance: Special Process which defines the process(es) including but not limited to: soldering, surface preparation and treatment, heat treatment, welding, non-destructive testing processes (etc); the applicable specification(s) to which the item(s) are procured or processed, and the identity of the processor(s) used.

Each process used shall be listed on the Certificate in sufficient detail to permit Buyer verification. Processed items that are serialized shall have the serial numbers listed in the Certificate. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

Buyer approval of any process source shall not relieve Seller of any obligation and liability under this PO.

132 Raw Material Certificates

Raw metallic materials (including forgings and castings) supplied shall include a copy of the original mill certificate or material test report (certification) from a test acceptable to Buyer. Raw material mill certifications may not be altered or have any markings other than the check marks from verification of physical and chemical values and/or indication of inspection acceptance, Stamps may also be applied.

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133 Traceability of Materials: General

Seller shall maintain traceability information on file of all materials, parts and assemblies used in fabricating the product. Traceability records shall be maintained by the Seller for a period of five (5) years.

Note: Titanium parts shall be clearly and permanently marked.

134 Traceability to Raw Material

All items fabricated under this PO shall be traceable to Raw Materials used. All traceability and inspection records must be identifiable upon request or audit by Buyer or their Customer Representatives. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

- 1) Raw Materials used shall be identified by lot number as well as material type, specification, heat number, etc., and shall be identifiable with lot of Raw Material used.
- 2) All material fabricated by the Seller in one lot shall be identifiable to that lot when supplied to Buyer. When the Seller is combining material fabricated in two or more lots to fulfill PO Requirements, these materials shall be segregated and identifiable to the lot in which it was fabricated.

135 Lot Control

Lot Control shall be required. Lot number/date code shall be identified on the outside of intermediate and/or unit packages. When more than one lot/date codes are shipped together, individual lot/date codes shall be segregated and identified on the outside of the intermediate packages. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

136 Preference for Domestic Specialty Metals (Military Orders)

Any specialty metals incorporated in products delivered under this PO contract shall be melted in the U.S., its outlying areas, or a qualifying country listed in DFARS 225.872-1. DFARS 252.225.7014 Alt 1 is imposed in regards to specialty metals. Exemptions to requirements of the above clauses may exist, as outlined in the clauses themselves or by operation of applicable Department of Defense Domestic Non-Availability Determinations (DNAD) posted on its public web site, for that purpose.


Suppliers must comply with DFARS 252.225.7009, restriction on acquisitions of certain articles containing specialty metals, for contracts exceeding the simplified acquisition that require delivery of an article containing specialty metals under a government contract.

137 Counterfeit Material or Parts

Definitions. The term Material, as used in this clause, includes, but is not limited to raw material, parts, components, sub-assemblies, assemblies and end product. The term New, as used in this clause, refers to Original Equipment Manufacturers (OEMs), Original Component Manufacturers (OCMs), Material previously unused or composed exclusively of previously unused Material, allowing for conventional use including, but not limited to integration, installation, assembly, test, burnin, training, troubleshooting, and rework as required. The term Counterfeit Materials means Material salvaged, produced or altered to resemble 'goods' without authority or right to do so, with the intent to mislead or defraud by presenting the goods as 'New Material'.

Unless otherwise stated, Supplier shall deliver fully warranted New Material under this clause; Supplier shall not deliver Counterfeit Material to DSE.

Supplier represents and warrants that all electrical parts delivered under any DSE Purchase Order (PO) are obtained from OEMs, OCMs, or their authorized dealers. If electronic parts cannot be obtained from

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OEMs, OCMs, or their authorized dealers and must be procured from alternative source(s), Supplier shall obtain DSE's written approval before making such procurements. In these instances, Supplier shall employ, or cause to be employed, inspection, testing and authentication processes reasonably designed to detect and avoid Counterfeit Material and shall provide written description of Seller's detection and avoidance processed to DSE on or before delivery.

Supplier shall immediately notify DSE's Buyer when Material is found or suspected to be Counterfeit Material. Notice must be in writing and must be provided to Buyer within 10 days of discovery.

Upon request, Supplier shall provide OEM/OCM documentation that enables traceability of Affected Material to the applicable OEM/OCM.

Should any Material delivered against a DSE PO be found to include Counterfeit Material, Supplier shall, at their expense, promptly replace such Counterfeit Material with genuine parts conforming to the PO. Notwithstanding any other provision in the PO, Supplier shall be liable for all costs relating to the removal and replacement of Counterfeit Material, including, without limitation, DSE's cost of removing Counterfeit Material, of installing replacement New Material and of any testing/corrective action necessitated by said replacement. The remedies contained in this paragraph are in addition to any remedies DSE may have by law, equity or under other provisions of the PO.

140 First Article

First Articles shall be accepted by Buyer prior to production via Buyer's established Quality Assurance procedures unless written authorization to proceed is given by Buyer. Seller agrees to provide objective evidence of conformance with all applicable requirements prior to acceptance of First Article(s) by Buyer. Refer to AS9102 Aerospace First Article Inspection.

141 Sampling

A Supplier shall use Sampling plans when historical records indicate that a reduction in inspection can be achieved without jeopardizing the level of quality. The Supplier may employ sampling inspection in accordance with nationally accepted or Customer-required standards. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

142 Configuration Data List


Seller shall furnish subassembly Configuration Data List (CDL) for each top end item assembly delivered. The CDL shall list the installed serialized assemblies by Part Number, Serial Number, and drawing Revision Level. The CDL may list multiple top end items (i.e. spreadsheet).

143 Test Reports

Each shipment must be accompanied by one (1) legible and reproducible copy of actual Test Reports, as indicated below, identifiable with the material submitted. Reports shall contain the chemical and/or physical properties of the purchased material. Reports shall also contain the signature and title of an authorized representative of the agency performing the tests and shall assure conformance to specification requirements. Records shall be maintained for a minimum of five (5) years.

144 Non-Destructive Test Reports

Each shipment shall be accompanied by one (1) legible and reproducible copy of Non-Destructive Test Reports identifiable with acceptable requirements of the material submitted. Reports shall contain the signature and title of an authorized representative of the agency performing the tests and shall assure conformance to specification requirements. Records shall be maintained for a minimum of five (5) years.

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145 Functional Test Certification

Each shipment shall be accompanied by one (1) reproducible copy of the Seller's Functional Test Certification. The Certification shall be identifiable to the delivered material (shipment) for which the test reports are on file and available for examination.

Each shipment shall be accompanied by three (3) reproducible copies of reports of actual tests with results traceable to the material shipped. These reports shall contain the signature and title of the authorized representative of the agency performing the test and must assure conformance to specification requirements. Records shall be maintained for a minimum of five (5) years.

146 Functional Test Reports

Each shipment must be accompanied by one (1) legible and reproducible copy of actual test results identifiable with test parameters defined as operational, mechanical, electrical, hydraulic inspection, etc., of material submitted. Reports shall contain the signature and title of an authorized representative of the agency performing the tests and shall assure conformance to specification requirements. Records shall be maintained for a minimum of five (5) years.

147 Pressure or Leak Tests

Each shipment must be accompanied by one (1) legible and reproducible copy of actual test results identifiable with test parameters and product submitted. Reports shall contain the signature and title of an authorized representative of the agency performing the tests and shall assure conformance to specification requirements. Records shall be maintained for a minimum of five (5) years.

148 X-Ray Reports

Material that requires radiographic inspection will be submitted to a laboratory and processed in accordance with Buyer and/or Government specifications and standards. Laboratory personnel performing radiographic inspection or interpretation shall be subject to examination and certification by Buyer. Findings shall be reported in an appropriate format and shall include the name of the reader and the signature and title of an authorized laboratory representative. The radiographic film and three (3) reproducible copies of the findings shall accompany the material shipment. Each radiographic exposure shall be traceable to the particular part and resultant report.


All items included in this PO requiring radiographic inspection shall be submitted to Buyer and processed in accordance with applicable specifications and standards. All findings shall be reported. This form shall contain the name of the individual reading the film and the signature and title of an authorized laboratory representative. The X-ray film and one (1) reproducible copy of the Report shall accompany the material. A control number shall be assigned to each part, appear on each film and be referenced on each Report for a method of cross referencing each file exposure and report. Records shall be maintained for a minimum of five (5) years.

160 Metal - General

Seller shall furnish with each shipment of Mill Work the following:

Buyer Part Number shall be stamped or engraved on the interior (inside) of the part.

In proximity to the Part Number, the Buyer Revision shall also be stamped or engraved on the interior (inside) of the part. Records shall be maintained for a minimum of five (5) years.

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161 Test Bars

Seller shall furnish with each shipment of castings the following:

- 1) One (1) test bar representative of each heat-treated lot made from the same melt as casting supplies. Specimens shall conform to Federal Test Method QQ-M-151
- 2) One (1) spectrographic disc representative of the entire heat or melt, and
- 3) Test bars and discs shall be permanently identified with the Seller's name or trademark.

162 Acceptance of Production Tooling

Acceptance of production tooling on this PO shall be contingent upon inspection and acceptance by Buyer. The tooling and dimensional samples produced by this tooling must conform to the tolerance limits of engineering drawings and specifications as stated on any applicable attachments to this contract. Seller agrees that inspection shall be conducted by Buyer's Quality Representative at a reasonable place and time as per direction of Buyer. Seller agrees that at Buyer's discretion it will produce and furnish Buyer dimensional samples which will be traceable to the tool number(s) used to produce the samples.

Note: When requesting inspection, notify Buyer's Purchasing Agent referenced on this PO at least five (5) business days in advance.

163 Certificate of Calibration

When deliverable inspection and/or test equipment shall be part of this PO, the Seller shall furnish a Certificate of Calibration (traceable to NIST) for each piece of inspection and/or test equipment. When the inspection and/or test equipment shall be part of a system, then the Seller may furnish one Certificate of Calibration covering the total system, including indication of compliance to applicable requirements as defined in ISO 10012-1, Quality Assurance Requirements for Measuring Equipment. Records shall be maintained for a minimum of five (5) years.

164 Welder's Stamp

Certified Welder's Stamp must appear on all items welded in accordance with Government Specifications MIL-W-8604 and/or MIL-W-8611. Also show certified welder's stamp on the Shipping Documents.


170 Standard Inspection System

Seller agrees to maintain an inspection system adequate to ensure that goods shipped under this contract meet all of the applicable requirements. Seller agrees that this system will also provide for the maintenance of records and data of all inspections and tests performed and agrees to make such records available for examination and verification by Buyer upon request. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

1. General

Seller shall provide and maintain an inspection system acceptable to Buyer. Seller's system shall be subject to an audit by Buyer. The procedures shall be clear, concise and adequate to fulfill the requirements of this PO. The system shall provide sufficient controls, records and inspections to assure compliance to Contract or PO requirements. The System shall have a method to obtain and provide written (documented) Corrective Action. Records shall be maintained for a minimum of five (5) years.

2. Non-Conforming Material

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Material Review Board authority shall not be granted for items designed by Buyer. The system shall provide for identification and control of Non-Conforming hardware or materials and for a method of obtaining Corrective Action. Seller shall provide immediate notification, in writing, of suspected problems with previously delivered product. This notification shall be sent to Buyer's VP of Operations and Purchasing Agent. Records shall be maintained for a minimum of five (5) years.

3. Notification of Changes

Seller shall notify Buyer whenever there has been a change in ownership, top management, head of quality department, facility location, major Supplier or process used on the item being delivered on the Purchase Order. Records shall be maintained for a minimum of five (5) years.

4. SQAR Incorporated by Reference

In addition to this SQAR 170, SQAR 203, 204 and 205 are incorporated into this Purchase Order, without specifically being called out.

5. Calibration

The system shall provide for Calibration and control of gauges and test equipment to the National Institute of Standards (NIST). Calibration-related procedures shall be clear, concise and adequate for PO requirements. Evidence of Calibration and the Seller's maintenance schedule shall be made available upon a Buyer audit visit. Records shall be maintained for a minimum of five (5) years.

6. Failure Review and Corrective Action

When requested by Buyer, via the issuance of a Supplier Corrective Action Request (SCAR), the Seller shall conduct investigations to determine root cause associated with the non-compliant condition or Failure trend identified in the SCAR. Positive Corrective Actions shall be implemented to ensure the Root Cause conditions are eliminated. Seller shall provide written response to Buyer's SCARs within 30 days and, when requested, provide status reports every seven (7) days until the Root Cause has been identified and associated Corrective Actions have been implemented to Buyer's satisfaction. Records shall be maintained for a minimum of five (5) years.

7. Flow Down of Requirements

Seller shall flow down to sub-tier Suppliers the applicable requirements of the Purchasing Order documents, including any key characteristics (when identified) and required Quality Provisions. Advise that Records shall be maintained for a minimum of five (5) years.


Revision Control

For all POs, unless otherwise specified, the Seller must use the latest Revision level of all applicable specifications to drawings that are in effect at the time the PO is issued.

171 Inspection and Test Plan Certification

Seller shall prepare and maintain objective evidence of inspection and test. The type of inspection or test at each point of inspection must be identifiable to the item being fabricated on this PO. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

- 1) Each shipment must be accompanied by one (1) legible and reproducible copy of the Seller's certification, identifiable with the materials submitted, that the inspection and test plan are on file and available upon request., and
- 2) The Certification shall contain the signature and title of a known representative of the Seller and assure conformance to the drawing or specification(s) requirements.

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172 General Inspection

Seller shall provide and maintain an inspection system. Seller's system shall be subject to an audit by Buyer. The procedures shall be clear, concise and adequate to fulfill the requirements of this PO. The system shall provide sufficient controls, records and inspections to assure compliance to Contract or PO requirements. Records shall be maintained for a minimum of five (5) years.

180 Cable Assembly Continuity and Shorts Test

Cable Assembly shall be 100% tested for electrical continuity. Continuity tests may be conducted by manual or automatic testing. Only Cable Assemblies that pass electrical continuity test shall be delivered to Buyer. Continuity testing shall be performed from point to point.

Short testing shall be performed from each point to all other points that do not share a common circuit. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

181 Deliverable Documentation for In-Circuit Testing of Circuit Card Assemblies

Test reports and certifications shall be submitted to Buyer with each lot of circuit cards assemblies (CCAs). Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

The test reports shall specify:


1. CCA Part Number, Serial Number and Revision
2. Power source and voltage per PO specifications; contact Buyer if in question.
3. Indication of test results, pass or fail
4. For items that fail initial test:
 - a. Indication of failure mode
 - b. Listing of Failed Components
 - c. Indication that rework was performed, and
 - d. Indication that CCA passed retest.
5. Indication of the test document number and the revision used to test the CCAs, and
6. Certificate of Conformance (CoC) as required by this document.

182 Printed Wiring Boards Test Requirements

Unloaded (bare) Printed Wiring Boards procured under this PO shall be tested in accordance with the requirements of IPC-6012 Section 3.9. Each lot shipped shall be accompanied with a Test Certification which shall include the name and address of any third party tester, if used. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

183 Printed Wiring Board Coupons

Printed Wiring Board (PWBs) manufactured under this PO shall have Quality Conformance Circuitry (Coupons) as designed by the Seller. Coupons shall be micro-sectioned and inspected to establish circuit board integrity (plating thickness, registration, hole wall quality, laminate condition, etc). A minimum of one micro-sectioned coupon shall be shipped with each lot of PWBs delivered.

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184 Printed Wiring Boards Coupons – MIL-STD

Printed Wiring Boards manufactured under this PO shall have quality conformance circuitry (coupons), conforming to the requirements of MIL-STD-275, paragraph 5.9, as part of every panel. These coupons shall be utilized to perform Group “A” and Group “B” inspection as specified in MIL-P-55110. Coupons shall be maintained at the Seller’s facility for a period of five (5) years.

185 Printed Wiring Board Assembly Component Verification Inspection

Printed Wiring Board Assembly Component Verification Inspection shall be conducted on one Printed Wiring Board Assembly (PWBA) of each lot. The component verification inspection shall consist of verifying the parts are in accordance with the drawing and parts list. When a Component Control Number (CCN) shall be used instead of the primary part number called out on the parts list, the Seller shall verify the CCN Part meets the requirements of the Drawing Number. Results of this inspection shall be recorded on a copy of the parts list. Seller shall clearly indicate parts verified and not verified using a legend of the Seller’s choice. The purpose of this inspection shall be to assure the correct components have been installed on the printed wiring board assembly. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

186 Tape and Reel

Parts shall be shipped on reels or taped; lead tape shall be six (6) inches. Pitch shall be .200 + 0.015 inch for parts with body diameter up to .2000 inch. Pitch shall be .375 + 0.015 inch for parts with body diameter from .200 to .375 inch. Leads shall be straight within 1/32 of an inch between the body and tape. Component bodies must be in line within 1/32 inch. Polarized components shall be oriented all in one direction. No more than three (3) consecutive components, both proceeding and following. The center-to-center distance between tapes shall be two (2) inches minimum for parts with a body length of .600 or less.

190 Soldering

Electrical Soldering shall be in accordance with ANSI/IPC J-STD-001 and Printed Circuit Board Assembly Inspection shall be in accordance with IPC-A-610 Class 2. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

191 Pre-Tinning

Component leads or the like shall be tinned with SN63PB37 or SN60PB40 solder per J-STD-006 and properly cleaned to remove flux residue. Leads shall meet the solderability requirements of IPC-J-STD-002, Category 3, MIL-STD-202, Method 208, or Buyer acceptable equivalent. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.


192 Solderability Test Samples

To assure the solderability of plated parts are acceptable, Seller shall furnish with each shipment a minimum of three (3) samples from the same lot, which have been subjected to the solderability test of MIL-STD-202, Method 208 or Buyer acceptable equivalent.

193 Fluxes, Solder and Solder Paste

Fluxes, Solder alloys and Solder Pastes shall meet IPC J-STD-requirements:

- o ANSI/ IPC J-STD-004A for Fluxes

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- o ANSI/ IPC J-STD-005 for Solder Pastes
- o IPC J-STD-006B for Solder Alloys, or
- o Buyer acceptable equivalent.

194 Under Plating and Solder Coating Test Coupons

Unless otherwise authorized in writing by Buyer, the tin content of any solder used shall not exceed 97%, and shall be alloyed with a minimum 3% lead.

Test coupons shall be furnished by the Seller for under plating (qty 4) and soldering coating (qty 4) with each lot supplied as specified on the drawing(s) and/or specification(s) cited on the PO. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

200 Nonconforming Material

Suppliers shall begin containment action immediately upon discovery/notification of nonconformance. If product may have escaped the facility and shipped to Buyer, the Supplier shall immediately notify their respective Buyer's Purchasing Agent.

For product that has been found or suspected discrepant prior to shipment, all requests for approval for repair or to be 'used-as-is' must be submitted to Buyer's Purchasing Agent for approval and held at Supplier's location pending receipt of documented Buyer-approval prior to further processing of or shipping of the nonconforming product.

Nonconforming products identified at a Supplier's facility or returned from Buyer's facility shall be analyzed to determine the cause(s) of the nonconformance.

For all nonconformances returned from Buyer, the Supplier shall submit a formal Corrective Action Report within five (5) business days from receipt of the Buyer Supplier Corrective Action Request (SCAR). Failure to respond to a SCAR may result in punitive action up to and including removal and/or suspension from Buyer's Approved Supplier List (ASL). Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

201 Material Review Board Authority

Seller shall not be an authorized Material Review Board Authority.


202 Resubmittal of Rejected Material

All material rejected by Buyer's Purchasing Agent and subsequently resubmitted by the Seller shall bear adequate identification of such resubmission either with the material or the Seller's shipping document. Reference shall be made to Buyer's rejection document and evidence given at the time of shipment or at Final Source Inspection that the causes for rejection have been corrected.

Government source inspected material shall have evidence that the resubmission has also been inspected by a Government Representative. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

203 Failure Review and Corrective Action

When requested by Buyer by the issuance of a Seller Corrective Action Request (SCAR), the Seller shall conduct investigations to determine Root Cause associated with non-compliant conditions or Failure trends identified in the SCAR. Positive Corrective Actions shall be implemented to ensure the Root Cause conditions are eliminated. Seller shall provide written response to Buyer's SCARs within 30 days and, when requested, provide status reports every seven (7) days until the Root Cause has been identified

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and associated Corrective Actions have been implemented to Buyer's satisfaction. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

204 Notification of Non-Compliant Product

Seller shall notify Buyer Purchasing within 10 days when nonconformity is discovered in the Seller's processes or products that may affect product already delivered. Notification shall include a clear description of the discrepancy, parts affected including Buyer's part number (serial numbers, lot numbers or manufacturing date) quantity delivered and Corrective Action for the discrepancy. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

205 Configuration Management – Design Change Authorization

After Buyer has approved the Product Design, changes to the design shall be made in accordance with the following requirements:


1. Definitions:
 - a. Minor Change: no applicable change to fit, form or function.
 - b. Major Change: affects fit, form or function.
2. Requirements:
 - a. Change Evaluation: Seller shall evaluate proposed design changes to determine if change requires approval by Buyer before implementation.
 - b. The criteria to identify design changes that require Buyer approval are as follows:

All Major Design Changes

DESIGN APPROVAL REQUIRED	DESIGN APPROVAL NOT REQUIRED
Addition, deletion, changes in value and characteristics due to electrical circuit changes	Drawing corrections due to typos and general drawing updates (except outline drawings)
Overall lesser reliability due to electrical circuit changes	Non-complex component replacements with equal or better reliability
Component changes with lesser reliability.	Changes to board level testing
Line Replaceable Unit (LRU) modification-levels (hardware and software)	Nut, blot, screw, washer, etc., changes that do not affect <i>fit, form or function</i>
All revisions to the effected Outline Drawing	
Any change or addition of a new source of any complex or significant component involved in a significant functional part of the product	

Submitting Design Change for Approval

Supplier agrees to notify Buyer of any change to the product, precursor material, process, finish, dimension or tolerance. Such notification shall be made in writing and prior to product manufacturer.

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All proposed design changes shall be submitted to Buyer's Purchasing Agent along with the following information:

- Identification number of Change
- Reason for Change
- Description of Change
- What conditions/problems will be fixed by the Change?
- Under what circumstances was the condition/problem discovered?
- What caused the condition/problem to occur?
- Are delivered units affected; if so, how will they be corrected; if not, why are the OK as is?
- What is the expected frequency of the condition/problem occurrence?
- What conditions are necessary for recovery of normal operations when condition/problem occurs?
- What testing has been done to verify the proposed Change will correct the condition/problem?

Change Approval/Denial

Buyer shall provide written response that will either approve or deny the Change. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

206 Final Inspection

Seller shall not use a sample inspection plan when performing Final Inspection on items designed by Buyer. If a Seller plans to use sample inspection during the final inspection process, the Seller shall obtain written authorization from Buyer's Purchasing Agent prior to delivery of the product. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.

210 Inspection-Required Product

Buyer's Receiving Inspection shall process item(s) procured on this PO as an Inspection-required item. The person(s) performing the Receiving Inspection function shall go to the item's data file and perform the inspections called out. Records associated with PO deliverables shall be maintained for a minimum of five (5) years.


211 Standard Package Requirements: General

Seller agrees to package all items to be supplied under this contract utilizing best commercial practice unless specifically requested otherwise per any other clause of this contract.

Recommendation dependent on Product type: Product must be individually packaged in non-static plastic, bubble wrap, or similar protective material and arranged in orderly layer(s), a divided container or individual boxes in a larger container are preferred. Layers must be separated by cardboard or plastic dividers. Individual part foam immobilization is also acceptable.

Each shipment shall have a Packing Slip on the outside of the box for each PO inside the box. See Section 215 for Packing Slip requirements. Test Reports (Section 143) shall be included as applicable.

Inspection data and certifications as required by the indication on the PO order and any documents referenced therein, shall accompany each shipment.

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Seller shall control all preservation, packing, storage, shipping and handling to assure all materials are adequately protected during all phases of procurement and assure compliance with any special handling and shipping requirements as may be specified.

212 Standard Package Requirements: Specific

All items listed on this PO shall be packaged in accordance with the following indicated specifications and/or procedures.

Tape and Reel Packaging Requirements

Surface mount components shall be packaged in accordance with EIA-481, taping of surface mount components for automatic placement. All surface mount component Purchase Order quantities shall be taped.

Chip resistors with solderable wrap-around terminations shall be packaged with the resist material facing the top cover tape.

Should the Supplier not be able to meet the reel quantity requirements, the Supplier shall contact the Buyer's Purchasing Agent for notation to the PO and approval for alternate packaging.

Connector Protection

- All unmated connectors shall be protected at all times during assembly, storage, and test.
- Individually assembled connectors shall have their contacts or sockets protected with protective caps or other suitable packaging prior to shipment.
- Prior to placing caps on connectors, assure that the connectors are free of foreign objects. All connectors shall use connector protection which is ESD compliant to class 1, MIL-STD-1686, for ESD Model (HBM).


ESD-Sensitive Components

- No loose packaging materials, foam pellets, popcorn or shrink wrap allowed. A-A-59135 Packaging Material ESD protective foam between parts and in containers is acceptable.
- Electrostatic protective packaging, when specified, shall comply to MIL-STD-1686.
- Charge decay is < 2 seconds.
- Surface resistance 10⁶ - 10¹² ohms/sq.
- Shielding packaging, when specified, shall conform to MIL-B-81705 types I of III.
- Alternative packaging and/or materials must be approved by Buyer prior to shipment.
- Materials shall be non-corrosive if used in direct contact with item (MIL-81705).
- Recommended tray material for items listed as ESDS is 'Static Intercept polyethylene, A-A-59136 closed cell foam or protective bubble pack between parts is acceptable

213 Material Safety Standard

Seller shall include manufacturer's product safety information with each shipment. These are commonly known as Material Safety Data Sheets – MSDS.

This information shall contain at a minimum applicable product handling precautions and procedures, disposal information and emergency procedures for contact and contamination.

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Supplier should reference OSHA Title 8, CCR5194 (g) Hazardous Communications for Employees using and/or exposed to chemicals for exact specifics.

214 Minimum Shelf Life at Time of Delivery

The product procured under this PO shall have a minimum remaining shelf life of 80% of the initial shelf life at the time of manufacture or, if greater, a minimum of two years.

215 Packing Slip

Each shipment shall have a Packing Slip (PS) on the outside of the box for each Part Number on the PO inside the box. If there are multiple POs, included a PS for each PO or clearly specify on PS each PO and its Part Numbers associated with that PO.

Between the CoC and the Packing Slip, which may be the same form or two separate forms, the following shall be included:

- a. Supplier Name and Address
- b. Supplier Contact Information
- c. Supplier Reference Number
- d. Date of Shipment
- e. Compliance Statement
- f. Authenticator's Title and Signature (CoC)
- g. Purchase Order
- h. Part Number
- i. PN Revision as applicable
- j. Part Quantity Shipped
- k. Part Quantity Backordered
- l. Serial Number label data as applicable
- m. Date/Lot Code as applicable, and
- n. Dates of Expiration of Rubber, Consumables if not indicated on packaging

It is acceptable to reference and/or include the Packing Slip (Section 215) within the CoC.


Exceptions to a Packing Slip would include Internet resellers; contact Purchasing@digitalsys.com.

220 Declaration of an ITAR Item (Controlled Product)

If the product procured against this PO shall be subjected to the U. S. Export Control under the International Traffic in Arms Regulations (ITAR), then Buyer's Purchasing Agent must be notified immediately. Specific written approval must be provided by Buyer prior to delivering an ITAR item to Buyer.

If after authority to deliver an ITAR Item, the following statement must accompany the product on delivery to Buyer.

'This product is subject to U. S. Export Control under the International Traffic in Arms Regulations (ITAR). The export, re-export, transfer or other disposition of t his product outside the United States, either in its

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original form or other incorporation into an end-item, requires an export license or approval from the U.S. Department of State.'

221 Prohibited Substances

Use of materials containing magnesium or magnesium alloys with high content of magnesium, rilsan, mercury, cadmium, hexavalent chromium, polybrominated biphenyls (PBB) or polybrominated diphenyl ethers (PBDE) shall be prohibited. If item(s) delivered under this PO contain one or more of the prohibited materials, contact Buyer's Purchasing Agent immediately for directions and disposition.

222 WEEE and RoHS Prohibited Substances

Product procured on this PO shall be in compliance with the requirements of the below listed European Directives.

- RoHS (2002/95/EC): Restriction of certain Hazardous Substances
 - Prohibit, restrict, and or limit the use of six chemical substances including such materials as lead, mercury, cadmium, hexavalent chromium, polybrominated biphenyls (PBB) or polybrominated diphenyl ethers (PBDE) sold into European Union (EU) countries.
- WEEE (2002/96/EC): Waste from Electrical and Electronic Equipment
 - Products are appropriately recycled or disposed of at the end of their lifespan.
- Brominated Fire Retardant (2003/11/EC)
 - Restricts presence of chemicals pentabromodiphenyl ether and octabromodiphenyl ether

223 WEEE and RoHS Prohibited Substances – Certificate of Compliance

Product procured on this PO shall be in compliance with the requirements of the below listed European Directives.

Product procured on this PO shall be accompanied by a Statement of conformity, or a Certificate of Compliance. If Seller can not comply with the following requirements, notify Buyer's Purchasing Agent immediately.

This document shall contain the following elements:


Title:

Certificate of Compliance – Prohibited Substances
Supplier's Name / Purchase Order / Product Part Number / Product Name

Statement of Conformance:

The material contained in the products procured against this PO shall be compliant with the following European Directives:

- RoHS (2002/95/EC): Restriction of certain Hazardous Substances
 - Prohibit, restrict, and or limit the use of six chemical substances including such materials as lead, mercury, cadmium, hexavalent chromium, polybrominated biphenyls (PBB) or polybrominated diphenyl ethers (PBDE) sold into European Union (EU) countries.
- WEEE (2002/96/EC): Waste from Electrical and Electronic Equipment
 - Products are appropriately recycled or disposed of at the end of their lifespan.

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- Brominated Fire Retardant (2003/11/EC)
 - Restricts presence of chemicals pentabromodiphenyl ether and octabromodiphenyl ether

Company Representative:

- Name/ Title/ Signature/ Date

If Supplier cannot comply with above, notify Buyer's Purchasing Agent immediately.

224 Conflict-Free Minerals versus 'Conflict Minerals'

Widely used in today's electronic industry are the minerals tantalum, tin, tungsten and gold (hereafter referred to as the 3 Ts and G), which may have originated from 'Conflict Minerals' operations, inferring these are mined in the 'Conflict Region', the eastern portion of the Democratic Republic of the Congo (DRC) and surrounding countries.

Through SQAR #224, DSE specifically requests 'Conflict-Free' metals be utilized in the manufacturing of DSE product. 'Conflict-Free' refers to metals originating outside the conflict region or if from within, mines or smelters that are certified as 'conflict-free' by an independent third party.

When not possible to source 'Conflict-Free' labeled minerals, DSE requests all Suppliers to monitor current suppliers on the origin of 'Conflict Minerals' used in the manufacturing of DSE product.

When requested by DSE, Suppliers are to provide top-level source/smelter information using the standardized EICC/GeSI Conflict Minerals Reporting Template. Using the link provided, Suppliers should visit to access the most recent reporting template: <http://www.responsiblemineralsinitiative.org/reporting-templates/cmrt/>

This ends the Supplier Quality Assurance Requirements.