8801 QS - SUPPLIER QUALITY ASSURANCE REQUIREMENTS (SQAR)

1.0 PURPOSE

This Quality document establishes the customer's quality requirements for suppliers to ensure that information is flowed-down to the entire supply chain. It is our supplier's responsibility to ensure this information is flowed-down to their sub-tier suppliers.

2.0 DEFINITIONS

2.1 BUYER: Customer issuing the Purchase Order (physically or electronically) will invoke this document.

2.2 Supplier: The vendor/supplier/distributor performing work and/or supplying materials, parts, assemblies, subassemblies, or services pursuant to the purchase order (physically or electronically).

2.3 Q C CODE QC XX: Some Purchase Orders will show the QC Codes indicated in the Section 3.2 below. All other codes in Section 3.2 are implied.

3.0 GENERAL REQUIREMENTS

3.1 Applicability

These general requirements shall apply to Suppliers whenever Quality Assurance Requirements are invoked by Purchase Order. Applicable revision status of this document shall be the revision in effect on the date of Purchase Order, unless otherwise specified in the Purchase Order or related documents. Revision status of procured/deliverable items shall always be as specified in the Purchase Order.

3.2 Supplier's Quality Control System

3.2.1 (QC-1A, 1B, 1C) Quality System and Related Procedures

The Supplier's Quality Assurance system shall be implemented by written procedures, which adequately provide for compliance with the requirements herein. Manufacturers will either have a third party certified quality management system (AS9100, ISO9001) or have processes in place that comply with these industry specifications. NADCAP approval is required for any special processes specified in the www.eaudit.net QML / Commodities website.

3.2.2 Organization

Quality Assurance responsibility shall be clearly designated within the Supplier's organizations. Personnel having this responsibility shall have sufficient authority to assure that quality is not compromised**.**

3.2.3 Quality System

The Supplier shall immediately notify the Buyer in writing of any change to its Quality Assurance system that may affect 1) the inspection, conformity, or safety of the product, 2) quality leadership, or 3) quality system status (e.g., Supplier converts to an 1SO9000-based system or Supplier is no longer certified to AS9100).

3.3 Notification of Design Changes

Suppliers with design authority shall notify the Buyer of any changes of fit, form, function, or safety of product and obtain approval prior to manufacture and delivery. Suppliers shall submit proposed changes to the Buyer in writing. See Notice of Change (NOC) form on Buyer website. When design (or part of design) is the Buyer's responsibility, changes affecting design specifications shall not be made without written authorization from the Buyer.

3.4 Changes in Manufacturing Facility Location

The Supplier shall immediately notify the Buyer in writing of any planned change to the manufacturing facility location of the contracted part or assembly.

3.5 Drawing and Change Control

The Supplier's Quality Assurance system shall assure that the latest applicable drawings, specifications, technical requirements, Purchase Order information and changes thereto will be available at the time and place of the Supplier's acceptance of material and/or services. All changes shall be processed in a manner which will assure incorporation on the affected material and/or services at specified effectivity points. On Buyer-designed parts, the Buyer may require that the Supplier's change control system be compatible with that of the Buyer.

3.6 Procurement by the Supplier

The Supplier shall maintain a system to assure that Supplier-procured materials and/or services conform to Purchase Order drawings and specification requirements. The Supplier's Quality Assurance system shall contain controls for assuring requirements are met by sub- tier suppliers, including flow-down of the most current component revision level requirement to the approved sources. The implementation of such controls shall be subject to surveillance by the Buyer.

3.7 Supplier Subcontracting Approval

For all parts supplied per Buyer specifications, the Supplier shall notify the Buyer and receive written approval prior to subcontracting a process, part, assembly or end item prior to invoking the change.

3.8 Restriction of Process Sources

Restriction of process sources by customer or NADCAP approved sources may be invoked. When these restrictions are put in place, they must be flowed down to affected sub-tier suppliers. These processes may include, but are not limited to heat-treating, plating, and anodizing.

3.9 Preservation and Packaging

In addition to specific packaging and preservation instructions that may be invoked on Buyer part specifications, the following apply:

3.9.1 All material intended for the Buyer shall be protected against the usual hazards of electrostatic discharge (ESD), corrosion, contamination, deterioration, or other spoilage at the Supplier's facility and in transit.

3.9.2 All material for the Buyer shall be packed with suitable protection so as to prevent damage through handling, during storage at the Supplier, in transit, and during storage at the Buyer's facility before use.

3.9.3 Components which are identified by the manufacturer as moisture sensitive must be handled as identified in IPC-SM-786A. If the manufacturer's standards for humidity level or exposure time limit have been exceeded, the parts should be baked per IPC-SM-786A.

3.10 Manufacturing Training Requirements for Contract Manufacturers

Personnel directly involved in building the Buyer's product shall be trained and certified to the current revision of IPC-A-610 Class 2 requirements. The Supplier shall maintain training and certification records for periodic audits. The Supplier shall take additional action to assure skill proficiency of personnel who build/assemble Buyer products.

3.11 Substitution

Regarding commercial off the shelf material, the Supplier shall not substitute "equivalent" items in place of those items specified on the Purchase Order. If an equivalent item to a specified material is to be supplied, it is offered with supporting documentation prior to the shipment. All changes relating to part number, drawing specification, delivery or price must be in agreement by the Buyer and confirmed by a change to the Purchase Order.

3.12 Obsolescence

The Supplier shall notify Buyer of impending part obsolescence for all parts that are on open orders or which have been shipped by the supplier over the past 12 months. The notification shall occur at the earliest point possible and at least 6 months prior to the "end of life" order date.

3.13 Lead Finish for Components

The lead finish allow for components on this order shall be (63/37) or (60/40) tin/lead, dipped or plated and fused. The manufacturer shall guarantee solderability for a period of 15 months following receipt of the components by Buyer. Waivers to this requirement shall be obtained from Buyer Supply Management prior to shipment.

3.14 Safety Data Sheet (SDS)

As applicable, the Supplier shall provide the Buyer with a current Safety Data Sheet (SDS) in compliance with the Occupational Safety and Health Administration's (OSHA) hazard Communication Standard (29 CFR 1910.1200) and Washington Administrative Code (WAC) 296-62-054. Submittal of the SDS shall be made at the time of initial shipment or receipt. Thereafter, the Supplier shall provide the Buyer with the SDS for the material only if the formulation of the material is modified from that previously supplied. The submitted SDS shall be dated and include the name of the preparer. In the event that the Supplier's point of contact is different than the preparer, then that individual shall also be named in the SDS.

3.15 Tool and Test Equipment Control (Buyer Furnished)

All tooling and test equipment fabricated by the Supplier at the Buyer's expense, or supplied by the Buyer for Supplier use, shall be considered property of the Buyer. Such tooling and test equipment shall be inspected, calibrated, and controlled as outlined in the following paragraphs. The Supplier, with review and approval at the Buyer's option, shall establish tool and test equipment controls.

3.15.1 All tools and test equipment, unless size or use prohibits, shall be identified, as applicable, with the following information:

- 'Property of [Customer Name]'
- Part Number of Tool/Test Equipment
- Inspection Date
- Re-inspection Due Date
- Calibration Date
- Re-calibration Due Date

3.15.2 If not otherwise specified, all equipment that is used to determine acceptance of material will be subject to, as a minimum, an initial inspection and calibration, and periodic re-inspection and re-calibration thereafter.

3.15.3 The Supplier shall be responsible for maintaining adequate records of all tooling and test equipment indicating periodic inspections and calibrations. Such records shall be readily available to the Buyer's Quality Assurance Representative and/or Buyer's Customer and /or FAA representatives.

3.15.4 The Supplier shall have a system which includes written procedures for control of all tooling and test equipment. Procedures shall be in accordance with the controls specified herein.

3.15.5 Any tooling or test equipment furnished to the Supplier by the Buyer shall not be reworked or modified without prior written approval of the Buyer.

3.15.6 Tooling or test equipment shall be properly maintained and preserved.

3.16 Measuring and Test Equipment Calibration System

The Supplier shall maintain a system, including written procedures, to assure inspection and evaluation of measuring and test equipment, whether Supplier-owned or supplied by the Buyer or another agency. This system shall assure that the inherent accuracy of the equipment is comparable with the requirements of the unit being tested, and that required measurements are adequately performed. The system shall include appropriate calibration schedules and records per paragraphs 3.7.2 and 3.7.3.

3.17 Measurement Standards Controls

The Supplier's working standards used for calibration of tooling, measuring, and test equipment shall be checked at established intervals against suitable higher level standards which, in turn, will be checked at established intervals by reference to National Institute of Standards Technology (NIST) or equivalent certified primary standards. The Supplier shall maintain records or other conclusive evidence that proper control is being maintained. The Buyer may conduct, in the Supplier's facility, an evaluation of the Supplier's standards, measuring/testing devices, and calibration/maintenance personnel and methods to establish correlation between the Buyer's and Supplier's measurements.

3.18 Not Verifiable Upon Receipt

The Supplier shall provide adequate controls, within the quality system, to ensure that characteristics not verifiable upon receipt are adequately controlled.

3.19 Supplier Performance Reports

Customer measures suppliers On Time Delivery and Quality performance. Expectations are for suppliers are 97% higher on On-Time-Delivery and 99% or higher on Quality. Supplier performance is reported periodically and derived from Supplier responsibilities to deliver within the agreed upon delivery window, deliver acceptable material and/or services, and provide acceptable documentation as required by the Purchase Order. Performance expectations and additional information regarding performance reports can be found on Buyer website. Customer will supply On-Time-Delivery and Quality performance scores for any supplier upon request from the supplier.

3.20 Corrective Action

The Supplier's Quality Assurance system shall provide means for ready detection of discrepancies and for prompt and effective corrective action. Corrective action must prevent reoccurrence, including firm effectivity points by serial number, part number, date, or other agreed methods. Corrective action records and information, such as pertinent data on defects and failures, shall be available. The Supplier is responsible for initiation of prompt replies to the Buyer's Corrective Action Requests, and implementation of required corrective action.

3.21 Surveys and Surveillance

The Buyer may conduct a survey and/or perform surveillance of the Supplier's Quality Assurance system to evaluate the degree of ability to comply with these and other applicable requirements, or assist in the resolution of quality problems. As necessary, a representative of the Buyer's Customer may accompany the Buyer's Quality Assurance representative. The Supplier shall grant right of access and all reasonable assistance to the Buyer, the Buyer's customer, and regulatory authorities, such as the Federal Aviation Administration, to all facilities involved in the order and all applicable records.

3.22 The Buyer's Quality Assurance Representative

The Buyer and/or Buyer's customers may, at their discretion, provide resident or itinerant Quality Assurance personnel whose function shall be to survey Supplier operations, assist the Supplier in the resolution of quality problems, and witness at any stage (subject to proprietary considerations) the manufacture, processing, test, and inspection of items being manufactured for the Buyer. Copies of applicable specifications and documents shall be made available to the Buyer's Quality Assurance representative

3.23 Supplier Assistance

In the event those requirements are not completely clear, or where special assistance is needed, the Buyer will provide qualified personnel to consult with the Supplier. Requests for assistance shall be made via the Buyer's Supply Chain Management department. If inquiries pertain to quality aspects of supplies or services being procured, the Buyer's Quality Assurance organization may be contacted.

3.24 Sampling by the Buyer

The Buyer reserves the right to use sampling plans for the acceptance or rejection of material and/or services. If a lot is rejected by the sampling procedure the entire lot may be returned to the Supplier or the Buyer may screen the rejected lot at the Supplier's expense.

3.25 Final Acceptance

Inspection/test acceptance at the Supplier's facilities by the Buyer does not guarantee final acceptance. Final acceptance shall be at the Buyer's facility unless otherwise specified on the Purchase Order.

3.26 Conformance Responsibility

Surveillance, inspection and/or test conducted by the Buyer or representatives of any customer or government agency at the Supplier's or the Buyer's facility shall not relieve the Supplier of their responsibility in meeting the quality requirements of the Purchase Order.

3.27 Evidence of Effective Control

Verification of product by the Buyer's Customer shall not be used by the Supplier as evidence of effective control of quality and shall not absolve the Supplier of the responsibility to provide acceptable product, nor shall it preclude subsequent rejection by the Buyer or the Buyer's Customer.

3.28 Records

The Supplier shall maintain adequate records of inspections, tests, and other Quality Assurance activities. Records shall provide objective evidence of the Quality Assurance operations performed, the results obtained and corrective actions taken. Such records shall be available to the Buyer. Where such records are traceable by serial or lot designation to material supplied to the Buyer, they shall be retained for a period of at least ten (10) years from the date of shipment to the Buyer. At the expiration of this period, Buyer reserves the right to request delivery of such records. In the event that Buyer chooses to exercise this right, Supplier shall promptly deliver such records to Buyer at no

additional cost on media agreed to by both parties. If suppler retains quality records by electronic data, the supplier shall have adequate procedures to describe (1) the media, (2) the back-up method and frequency, and (3) the method of security.

3.29 English Language Requirement

The Supplier shall submit all required quality data (e.g., supplier quality procedures, certificates, reports, or other similar data required by the Buyer), correspondence and corrective actions responses in the English language (U.S.).

3.30 To Obtain Specifications

When required, the Supplier may obtain copies of pertinent specifications through the Buyer's Supply Chain Management Department or the applicable government agency, if a government specification. Any use of Customer drawings or specifications other than for manufacture of the ordered items is expressly prohibited.

3.31 Prohibited Practices

The following acts or practices are typical of those prohibited:

3.31.1 Unauthorized Repair

Repairs (by welding, soldering, or the use of adhesives) of parts damaged or found faulty in the fabrication process: repairing holes in castings, forging or other materials by plugging or bushing without authorization from the Buyer Quality Assurance organization.

3.31.2 Unauthorized Processing

Addition, revision, or deletion of processes in manufacturing when those processes are subject to specification control by the Buyer.

3.31.3 Disregard of Approvals

Change in any process of quality control procedure that is subject to specific approval by the Buyer without proper notification and re-approval.

3.31.4 Improper Material Submittal

Submission of material having known defects/problems to the Buyer without notification.

3.31.5 Improper Material Re-submittal

Resubmission of material to the Buyer without material being clearly identified as resubmitted material.

3.31.6 Unauthorized Material and Information Transfer

Buying, selling, or transferring Buyer related material, parts, devices, assemblies or end equipment for purposes other than the performance of the Buyer's business, without prior written approval, or disclosing Buyer part numbers, or information related to those part numbers, to entities other than the Buyer, without prior written approval.

3.31.7 Reclaimed Material

Supplier using reclaimed material without prior written approval from the Buyer.

3.31.8 Part Condition

Shipping product that is not new product. In no circumstance will parts which have been used, screened, repaired or otherwise refurbished be accepted.

3.32 Counterfeit Parts Prevention

All Suppliers are subject to the requirements defined in Customer Procedure 0701QS Counterfeit Parts Prevention, including parts purchased by contract manufacturers on a turnkey basis for use on buyer products. Customer has notified their supplier about zero tolerance for supplying counterfeit parts and the legal implications if doing so.

3.33 REACH (Registration, Evaluation and Authorization of Chemicals)

If raw materials, parts, or assemblies supplied contain substances of very high concern (SVHCs) as prescribed by EU No. 1907/2006, Registration, Evaluation and Authorization of Chemicals, identification shall be included in the shipment. This identification should list the SVHC- designated chemicals present in the purchased article and the conditions under which handling precautions should be taken.

3.34 Foreign Object Detection

The supplier shall develop and maintain a Foreign Object Debris/Damage (FOD) program for manufacturing areas to prevent introduction of foreign objects into any item delivered under purchase orders to Buyer. The Supplier shall employ appropriate housekeeping practices to assure timely removal of residue/debris generated, if any, during manufacturing operations and /or normal daily tasks. The supplier shall determine if sensitive areas that may have a high probability for introduction of foreign objects should have special emphasis controls in place for the manufacturing environment. The supplier shall determine the need for and implement FOD prevention and awareness training programs.

3.35 (QC-01) Inspections and Tests

The Supplier shall provide and maintain suitable gauges, instruments and test equipment to measure and test all material for conformance to the Buyer's requirements. The Supplier shall perform inspection and/or test on end items covered by the Purchase Order prior to submission to the Buyer or prior to delivery.

Inspection/test of material, which cannot be readily examined in the end items, must be performed at the appropriate in- process stages of manufacturing. The Supplier must maintain records of inspection/tests.

3.36 (QC-02) Certification Requirements

The Supplier is responsible for compliance with all certification requirements referenced on the Purchase Order and for the maintenance of quality control records evidencing compliance with such requirements, regardless of whether work was performed by the Supplier or their sub-tier suppliers.

3.36.1 Certification of Compliance

The Supplier provides, with each shipment, a Certificate of Compliance traceable to the responsible Supplier contact by signature or printed name, which shows customer’s Purchase Order, customer’s part number and as applicable, the Supplier reference number. This document certifies that material or parts furnished have been manufactured and verified in accordance with all applicable specifications as stated in customer’s Purchase Order. This document also certifies that objective evidence of inspection and testing verifications is on file and available for review.

3.36.2 Records and Traceability Documentation

When Certification of Compliance from the Supplier is based on Certifications of Tests and Inspections received from the manufacturer or another supplier, the Supplier ensures that these Certifications are received and retained, and that adequate traceability exists to the manufacturer of the products.

3.37 (QC-03) Shelf Life Control

The Supplier shall maintain a documented system for shelf life control items where acceptability is limited by maximum age. The system shall include a method of identifying and controlling such items. When environment is a factor in determining useful life, the identification shall include the storage conditions required to achieve the stated life (i.e., temperature, humidity, etc.). A minimum of 80% of the applicable material/article shelf life remains upon receipt of the material, or the material is subject to rejection and returned to the Supplier, unless the material is part of a catalyst family, then the minimum shelf life remaining must be at least 50% upon receipt at Buyer. As applicable, the cure date and/or temperature limitation must appear on each container. Any other exceptions to this standard will be communicated through individual purchase orders.

3.38 (QC-04) First Article Inspections

For all parts supplied per Buyer specifications, first article inspection shall consist of 100% verification of compliance to the customer's drawing, including dimensional and functional data per AS9102 requirements, and supplied with the first shipment of a new or delta production lot. Buyer disclaims responsibility for any parts shipped prior to approval of first articles and related documentation. The Supplier shall flow down this obligation to its sub-tier chain.

3.39 (QC-0S) Source Inspection

Source inspection is required by customer's quality. Supplier must contact the customer's Quality Manager prior to all shipments to customer.

3.40 (QC-06) Inspections and Test Status

The Supplier shall maintain a system for identifying inspection and test status of material. Identification may be accomplished by means of stamps, tags, routing cards, labels, bar codes, electronic databases, or other control devices. Final acceptance stamps must provide the Supplier with identification unless identification is provided on the product by other acceptable means.

The Supplier shall be responsible for maintaining procedures for governing the control of inspection authority and shall, upon request, forward a record of such authority to the Buyer. If (QC-6) is indicated on Purchase Order, then 100% visual inspection is required with documented evidence presented with each shipment. This evidence will be shown through an inspection check or equivalent with the method stated as "visual".

3.41 (QC-07) Sampling by the Supplier

Any statistical sampling procedures used for inspection/test may be subject to approval by the Buyer. Acceptance sampling shall meet the requirements of ARP9013, Statistical Product Acceptance Requirements" with minimum protection levels meeting ARP9013 Figure B1. In all cases, inspection requirements identified by engineering drawings and specification take precedence.

If (QC-7) is indicated in Purchase order, Statistical process control is required and shall be implemented on this order as defined by the Customer. The supplier shall contact the customer prior to manufacturing to define the required key or special characteristics affected.

3.42 (QC-08) In-Process Inspections

In process inspection is required by the Customer. When this is required, the specific inspection point in the process will be specified on the purchase order. The supplier will contact the customer and hold the material for in-process inspection by the customer's quality inspector.

3.43 (QC-09) Frozen Planning

Upon acceptance of the first article, the supplier shall make no changes to the method of manufacture, equipment used, materials, or processes which may affect interchangeability, function, dimensions, performance, or finishes. All changes must be approved by customer's Quality Engineering.

3.44 (QC-10) Production Parts Approval

Prior to production start-up, the supplier shall produce limited quantity (as specified on the purchase order) of pieces to confirm consistency of quality and performance. This information will be flowed to the supplier either through a drawing or will be noted on the purchase order. No revision to the tooling, programming or inspection can be done without customer's consent.

3.45 (QC-11) Procedures and Approval

The supplier must submit for review and approval, detailed test and inspection method, which will be used to ensure that the requirements of this order have been satisfied. This information shall include the procedures and identification of the description of the equipment to be used.

3.46 (QC-12) Product Identification and Traceability

The Supplier shall maintain documented procedures for identification of product from receipt and during processes of production and delivery. The procedures shall address unique identification of individual product or batches; this identification shall be recorded. All parts must be identified with the drawing number and vendor number. The manner and location of this identification shall be agreed upon by customer's Engineering and or Quality Engineering.

3.47 (QC-13) Protection of Parts against Contamination or Damage

The parts must be boxed, banded, or shipped in a manner that will ensure that no damage will occur. External threads must have special protection against damage.

3.48 (QC-14) Right of Entry

The customer, its customer, or regulatory agencies, shall be afforded the right to verify that subcontracted product conforms to specified requirements. Verification by the customer, its customer or regulatory agency does not absolve the supplier of the responsibility to provide acceptable product, nor does it preclude subsequent rejection by the customer or its customer.

3.49 (QC-15) Subcontracting without Written Approval

Subcontracting all or substantially all of the order without written consent of the customer's Quality Engineering and Engineering is prohibited.

3.50 (QC-16) Material Review

The Supplier shall not exercise Material Review authority to use-as-is or repair completed product without written approval by the Buyer's MRB Organization. (This applies only to material that is Buyer-designed and/or design controlled to the Buyer's specifications.)

3.50.1 When **QC-16** is indicated on the Purchase Order, parts dispositioned by a customer's supplier as scrap will be sorted 100% for the defect that is discrepant. Also, all parts that have been dispositioned as scrap must be identified with a discrepant part tag or other means of identification.

3.50.2 When **QC-16A** is indicated on the Purchase Order and any nonconforming parts or processes found during inspection at the Customer, the supplier will be contacted and will have 48 hrs. to respond to the discrepancy. The customer can decide to return the parts to the supplier for inspection. The customer also has the option to not return the parts to the supplier and debit the supplier for the costs associated with the discrepancy.

3.51 (QC-16B) Notification of Nonconforming or Unsafe Product

The Supplier shall notify the Buyer if there may be a form, fit, function, usability, or reliability problem with material that has already been delivered. The Supplier shall not knowingly ship non-conforming material without written authorization from the Buyer.

3.51.1 Notice of Escapement | Disclosures

Customer's supplier shall provide a written notification of nonconformities that may have affected parts or services delivered to the customer within 48 hours of the realization of the escapement. The customer's buyer / purchasing agent will be notified and the discrepancy documentation must include a clear and concise description of the discrepancy which includes as a minimum; part number, purchase order number, quantity and the date the parts were delivered to the customer's. Also, immediate corrective action / containment as well as the root cause and corrective action must accompany the discrepancy documentation submitted to the customer.

3.52 (QC-16C) Processing

The Supplier shall establish a system to assure that all processes, even including those which cannot be readily verified by inspection, will conform to specification requirements. When critical or special processes are performed outside the Supplier's facility, it shall be the Supplier's responsibility to assure proper performance of all such processes. Those processes to which Government specifications apply are subject to the applicable requirements regarding certifications or approval by Government agencies.

3.52.1 Customer Approved Processors

All Heat Treat, NDT and Coatings subcontracted by the customer must be performed by a Customer Approved Processor. The customer's supplier is responsible for verifying their approval status prior to any processing being performed. The customer's name and PO number is referenced on all customer processing purchase orders for this approved process verification.

3.53 (QC-17) Delegated Source Program

The Customer's Delegated Source Program must follow the requirements stated in WI-6.4A Verification of Purchase Product Delegated Quality Activities. No deviation to this procedure is allowed unless agreed upon by the customer's quality representative.

3.54 (QC-18) Suppliers of Electronic Components

Suppliers of electronic components to the customer must submit a certificate of conformance showing configuration with actual values obtained during testing referenced by serial number with each shipment.

3.55 (QC-21) Preference for Domestic Specialty Metals

When a line item on the customer's purchase order has the part number identified as XXX- DFARS the supplier agrees to comply with Defense Federal Acquisition Regulation Supplement DFAR 252.225-7014 (Alt. I). Preference for Domestic Specialty metals when this clause is specified in the purchase order. Use of foreign specialty metals may only be made with the written authorization from the customer. Country of melt must be identified on certification.

3.56 (QC-22) Approved Raw Material Suppliers per 299-100-837

Raw materials supplied per this quality code must be approved by Bell Helicopter document 299-100-837 for use in customer manufactured parts. (Contact the customer if you need current revision of 299-100-837 document).

3.57 (QC-23) Material Substitutions

The supplier shall not deviate from the Bill-of-Material requirement on the purchase order without prior approval from the customer's Engineering and Quality Engineering departments.