



D 001

Quality Clauses for External Providers

Document History					
Revision	Date	Author	Approved By	Amendment	Major/Minor
-	04/14/2021	Dave Rulla	Dave Rulla	Initial Release	
A	10/07/2021	Dave Rulla	Dave Rulla	Added verbiage about FAI part identification in HQR 006	Minor

001 General Requirements

1. Unless otherwise specified in the Purchase Order, the following general requirements apply to all Purchase Orders.
2. **Non-Conforming Material**

The supplier does not have MRB (Material Review Board) authority to disposition non-conforming parts/material on build-to-print jobs other than to “Return To Vendor (RTV)” or “Scrap” to blueprint requirements. A request to “Repair,” “Rework,” or “Use-As-Is (UAI)” must be presented to the Ares Quality Department for approval before action is taken.
3. **Unauthorized Repairs**

Without Ares’ documented approval, the supplier may not repair by welding, brazing, soldering or adhesives, any damaged or non-conforming parts found due to faulty fabrication.
4. **Changes in Approved Processes, Materials, or Procedures**

Supplier shall not change any process, material, or procedure without prior Ares approval if Ares originally approved such process, material, or procedure. Any changes must be approved by Ares, in writing, before the change incorporation. A revised purchase order or drawing /specification revision may constitute change authorization. Materials or components received that are not as specified may be considered counterfeit and rejected.
5. **Re-submittals**

Articles rejected by Ares and subsequently re-submitted to Ares shall be clearly and adequately identified as re-submitted articles. The Suppliers shipping document shall contain, as a minimum, a statement that articles are either a replacement or reworked articles and shall also make reference to Ares’ “Nonconforming Material Report” (NCR) number.
6. **Submittal of Production Parts**

When the Purchase Order requires Ares’ acceptance of a “First Article Inspection” the supplier shall not submit parts from a production run for Ares inspection prior to Ares’ acceptance of said first article.
7. **Notification of Facility Changes**

The supplier shall not relocate any production, manufacturing, or processing facilities during the Purchase Orders performance without promptly notifying and allowing Ares to examine said facilities for compliance with Product Assurance Requirements, including any necessary approvals.

8. Responsibility for Conformance

Neither surveillance, inspection, and or tests made by Ares or its representatives at either the Supplier's or Ares' facility nor the supplier's compliance with all applicable Product Assurance Requirements shall relieve the supplier of the responsibility to furnish articles that confirm the requirements of the Purchase Order.

9. Documentation

Ares may refuse to accept items delivered under the Purchase Order if the supplier fails to submit the Bill of Lading/Shipper, Certification of Conformance (C of C), documentation, test data, or reports specified in the Purchase Order. Furthermore, no invoice shall be approved for payment without Certification of Conformance, documentation, test data, or reports specified in the Purchase Order. The supplier shall include all certification, documentation, test data, and reports when parts are submitted to Ares. Supplier shall retain all related quality records for a minimum of five years unless a longer retention period is specified on the Purchase Order or Drawing. Supplier will ensure sub-tier suppliers record retention period meets all the above requirements.

10. Certificate of Compliance Audit

Certifications furnished under the terms of the Purchase Order shall be supported by inspection, test records, data, etc., and are subject to audit by Ares.

11. Lot Sampling

Ares reserves the right to sample IAW ANSI/ASQ Z1.4 or equivalent sampling plan to accept or reject articles or parts from the supplier.

12. Corrective Action Requests

When a quality problem exists, Ares may request corrective action from the supplier. Corrective action request response time is indicated in total days to reply. It should include the following information: Analysis of the root cause of the problem, action taken to correct the root cause, and action taken to prevent any reoccurrence of the root cause.

13. Access to Facilities

The supplier must identify, without disclosing proprietary information, the intended use in the performance of the Purchase Order of an item, material, component, or process with respect to which access by Ares for quality assurance by inspection, test, or process surveillance is proposed to be restricted. Said identification shall be made in writing to Ares along with the supplier's quotation or offer to Ares prior to the Purchase Order award. The written identification shall generally state the basis for said proposed restricted access, (example would be proprietary information), and shall include a proposed method of quality/inspection by Ares that the supplier considers acceptable. The absence of such written identification represents that the

supplier agrees that all items, materials, components, and processes are subject to inspection, test, and surveillance at all places and reasonable times prior to acceptance. If said written notification is given, the supplier agrees to negotiate promptly and in good faith with Ares for arrangement for inspection, test, and surveillance.

14. Calibration Requirements

The supplier shall maintain a calibration system to assure that all inspection, measuring, and test equipment used to determine compliance with drawings and specifications are calibrated to standards traceable to national or industry-accepted standards.

15. Waivers

Any supplier that feels that an AQR may not be applicable can submit a waiver request. The waiver must include the AQR code the waiver is for, the Ares purchase order number, and a clear indication of the need for the waiver. Each part affected by the quality code must be listed individually on the waiver, including part number, description, and quantity. Only one waiver per requested AQR Code may be submitted. This waiver must be submitted to the Ares Director of Quality for approval. An approved waiver must be in force before parts can be shipped to or accepted by Ares.

16. Material Deficiencies, Shortages, and or Damage

The materials delivered by all suppliers at a minimum will be reviewed by receiving personnel to ensure correct material was delivered in accordance with Ares Purchase Order and Bill of Lading/Shipper provided by the Supplier. Additionally, all materials must be reviewed by Ares Receiving Personnel for count and damage assessment to ensure appropriate quantities have been received. In the event of material being noticeably short and or damaged at the time of delivery, the material may be refused with notification to supplier and/or shipper for action (compensation, replacement, or rework as applicable).

AQR 002 Suppliers Quality Control System

The supplier shall maintain a quality system that complies with the Purchase Order requirements and is capable of assuring conformance to documentation, inspection, tests, and or reports specified in the Purchase Order. Supplier will be certified to an accepted and recognized quality standard (example: ISO 9001:2015, AS9100) by an outside third party, listed on Ares' customers approved supplier list in good standing or listed on Ares' approved supplier list in good standing.

AQR 003 Certificates or Compliance/Conformance

A certificate of compliance/conformance is required to provide objective quality evidence of specific characteristics of the material supplied as indicated on the drawing, specification, or purchase order (e.g., test results, heat treatment, surface finish, material, standard specification). Valid certifications shall identify the manufacturer or supplier of the certified characteristic, shall contain enough information to identify the C of C with the item or material supplied, shall reference the purchase order number, model number, or Ares job number, and be signed by a supplier quality assurance representative and or company executive identified by specific titles.

AQR 004 Raw Materials, Certificates of Analysis

Suppliers of raw material directly to Ares shall provide a Certificate of Analysis to the Material Specification and heat/lot number traceable to the shipment. Traceability to the material certification shall be demonstrated on the raw material in the following manner:

- a) When possible, all material shall have the original mill stamp referencing the certificate of analysis.
- b) If the raw material shipment is separated so that each material requiring a unique certificate is bundled or palletized together, there shall be a unique number on the bundle or pallet that is referenced on the shipper and Certificate of Analysis. This number may be:
 - 1) The heat or lot number assigned by the material manufacturer.
 - 2) A unique inventory or tracking number assigned by the supplier.
- c) If the raw material shipment is not separated so that each material requiring a unique certificate is bundled or palletized together, there shall be a unique number on each piece of material that is referenced on the shipper and the Certificate of Analysis. This number may be:
 - 1) The heat or lot number assigned by the material manufacturer.
 - 2) A unique inventory or tracking number assigned by the supplier.
- d). Suppliers who fabricate parts made from raw materials not provided by Ares shall provide a Certificate of Analysis indicating conformance to the material specification and the part number(s) for which the materials were utilized for each shipment.

AQR 005 Prototype Submission / Inspection

The supplier shall provide a detailed inspection report(s) (utilizing an AS9102 type of format) containing a record of the actual conformance on 100% of all characteristics and

notes on the drawing(s) on all parts ordered. The inspection report will include an un-numbered characteristic for “final visual acceptance.”

AQR 006 First Article Inspection

On the first initial product run, subsequent to design change incorporation, the supplier shall perform, document (utilizing an AS9102 type of format), and deliver a comprehensive inspection of one component (randomly selected from the lot by the supplier at some point during production or inspection) to assure conformance with all drawing and specification requirements. This requires accountability for 100% of all characteristics and notes on the drawing(s) and any other quality requirements that are communicated. The inspection report will include an un-numbered characteristic for “final visual acceptance.” The part used in the First Article Inspection must be identified with an appropriate method: Bag, Tag, Serial Number, or other methods clearly defining the actual part used for The First Article Inspection Report.

A new First Article shall be required when:

- a) A significant design or process change has been made that affects the original first article configuration and applies only to those characteristics affected by the change, or;
- b) The item has not been manufactured for a period of 12 months, or;
- c) A change in facilities utilized to produce the article has taken place.

AQR 007 In-process Source Inspection

Inspection by an Ares Quality Representative is required at the supplier’s facility prior to special processing such as plating, passivation, painting, etc. The supplier shall notify Ares Quality to arrange for a mutually agreed time and date. The supplier shall provide the latest revision to the Purchase Order, amendments, blueprints, applicable inspection records and documentation, and any inspection equipment needed for the Ares Quality Representative to perform any dimensional inspections.

AQR 008 Final Acceptance Source Inspection

Final acceptance by an Ares Quality Representative is required at the supplier’s facility prior to the delivery of any product to Ares. The supplier shall notify Ares Quality to arrange for a mutually agreed date and time. The supplier shall provide the latest revision of the Purchase Order, amendments, blueprints, applicable inspection records and documentation, and any inspection equipment needed for the Ares Quality Representative to perform any dimensional inspections.

AQR 009 Special Process Supplier Approvals

The supplier shall notify Ares Quality if any particular sub-tier processors are utilized. The notification shall include the name, phone number, and location of the processor. Special Processes are considered to be, but not limited to, welding, soldering, plating, painting, etc. Suppliers will ensure all relevant Purchase Order requirements are flowed down to their sub-tier suppliers. The Suppliers sub-tier suppliers are responsible for complying with the same specifications and conditions specified on the Purchase Order. Supplier shall only use particular process suppliers approved by Ares.

AQR 010 Welding Requirements

Welding procedures, welders, and weld inspectors shall be qualified in accordance with the welding code referenced in the drawing or specification. Ares must approve the use of any welding codes or specification not referenced by the applicable drawings prior to production. The supplier shall be prepared to show, by records, that successful welds can be made for the material type, joint types, material thickness, and welding positions required while using the supplier's facility, equipment, and personnel. Ares will expect to have access to or copies of all the following documentation:

- Welding Procedure Specification (WPS)
- Procedure Qualification Record (PQR)
- Welder's Qualification
- Data on filler metal certification
- Data on shielding gas certification
- Letter of appointment and a Jaeger/Snellin Vision Test less than one-year-old for those inspectors on staff not holding a valid AWS credential for SCWI/CWI/CAWI
- A written report of visual inspection, in the contractor's format, covering all welds and meeting the applicable code requirements.

Minimum qualifications and visual inspections are as follows:

- AWS D1.1 2015 [Steel] – Section 6.1.4, 6.6.1, & C6
- AWS D1.2 2014 [Aluminum] – Section 5.1.3, 5.6.1, & C5
- AWS D1.3 2018 [Sheet Steel] – Section 6.1.1
- AWS D9.1 2018 [Sheet Metal] – Section 6
- ASW D17.1 2010 [Aerospace] – Section 6.1.2, 6.1.3, 6.3, & C5.21

AQR 011 Visual Welding Inspection

Supplier must have (on staff or under subcontract) a competent person to provide all visual welding inspection (including fit-up, in-process, and final fabrication/erection inspections) required for this work. Supplier must submit the credentials of this competent person showing qualification (to AWS QCI Standard for AWS Certification of Welding Inspectors or equivalent) along with a report of visual weld inspections conducted and the results thereof. Specifically:

- “Competent person” means a person holding an active, valid American Welding Society CWI (or SCWI/CAWI) credential.
- “or equivalent” means a valid credential-in-force from a 3rd party regulatory body or industry/trade association relevant to an alternate welding code that is accepted by Ares.

It is NOT sufficient to appoint a Contractor’s inspector meeting only the minimum AWS Code standards for qualification (by asserting a Contractor-accepted combination of education, training, and experience).

AQR 012 Domestic Sources Only

The parts supplied on this purchase order shall be procured only from domestic sources located in the United States of America to provide complete traceability. The vendor may supply parts made in their factories located in North American Free Trade Association (NAFTA) nations, as long as complete, traceable product data is established, maintained, and accurate for certification of all materials and processes and the location of manufacture is identified at the quoting stage or prior.

AQR 013 Sole Source Required for OEM

The part numbers for items supplied on this purchase order contain identifying information for a particular Original Equipment Manufacturer (OEM). Suppliers may obtain the parts from any authorized distributor of that OEM, but no source substitutions are allowed. Identical part numbers are necessary but are not sufficient evidence to prove the OEM source.

AQR 014 Irradiating (Chromate Conversion Coating) Requirements

Ares considers chromate conversion to be a “special process” that requires the use of approved suppliers. Confirm you are an approved supplier before beginning or accepting any purchase order with this requirement. Ares approved supplier is satisfied by one of the following:

- Ares will audit your or your sub-tier supplier's facility for compliance with Military Standard.
- Use a NADCAP approved supplier in good standing.
- Documentation received must identify the time and date, and type of application used on the parts as this is a time-sensitive component within the coating process.
- Parts must not be handled without latex or nitrile gloves to prevent any contamination to the parts.
- Receiving must inform quality immediately upon receipt of such parts to ensure timely processing through the paint departments Receiving Inspection process.

AQR 015 Part Specific Quality Plan Applies

The supplier shall follow the provisions of the part-specific Quality Plan that shall accompany the purchase order. The Quality Plan will include those characteristics that will require extra attention, monitoring, and or reporting during your manufacturing process and verification/assurance processes.

AQR 016 Testing data required

The supplier shall provide a copy of the acceptance test and or performance test results for each unit purchased on the purchase order.

AQR 017-Dimensional Inspection Reporting (Lot Inspection)

The supplier shall provide a detailed inspection report(s) utilizing an AS9102 type of format, containing a record of the range of measurements, according to an industry-accepted sampling plan. The report will account for all characteristics and notes on the drawing(s). The supplier's Sampling plan should be indicated on the report and a narrative about how the supplier determines the minor/major/critical features, how that affects sample sizes, and when it will be utilizing 100% verifications. The inspection report will include an un-numbered characteristic for "final visual acceptance."

AQR 018 Special Process Certification

Suppliers shall provide a Certificate of Analysis indicating conformance to all special process specifications/requirements identified on the drawing or Purchase Order (e.g., heat treat, MPI, anodizing, plating, coating, etc.) and the part number(s) for which the materials were utilized for each shipment.

AQR 019 Counterfeit Electronic Parts Detection and Prevention Certification

Suppliers shall provide a Certificate or Certifying statement for all electronics and or electronic assemblies that they only utilize approved suppliers or manufacturers with established codes as specified under 48 CFR 252.246.7007 paragraph for each shipment:

- Parts provided were procured from an authorized aftermarket manufacturer that fabricates a part under a contract with or with the original component manufacturer's express written authority based on the original component manufacturer's designs, formulas, and specifications.
- It is an authorized supplier defined as a supplier, distributor, or an aftermarket manufacturer with a contractual arrangement with or the original manufacturer's express written authority or current design activity to buy, stock, repackage, sell or distribute the part.
- It is a contract manufacturer meaning that it is a company that produces goods under contract for another company under that company's label or brand name.

It is a contractor-approved supplier that does not have a contractual agreement with the original component manufacturer for a transaction but has been identified as trustworthy by a contractor or subcontractor.

AQR 020 Safety Data Sheet Required

Suppliers shall provide a Safety Data Sheet (SDS) for any chemical, solvent, solution, cleaning agent, or coating in the following conditions:

- First time delivery of new material
- Change in formulation
- Change in manufacturer
- Any regulatory change within the industry
- At the convenience of Ares

All SDS documents are to be collected at the time of receipt by Receiving and placed into the central SDS Document Folder

AQR 021 Safety Data Sheet Required

Acceptance Quality Limit (AQL) shall be defined specifically by Ares Technology on the purchase order. These will be defined as to the requirements of Ares Technology, to assure a level of confidence in compliance, based on rationale derived from but not limited to, performance history, customer requirements, and Key characteristics. When AQR 021 is imposed the responsibility to define the AQL level resides solely with Ares Technology.