



SQA-95-10
Supplier Quality Assurance Requirements

An initial Purchase Order review is important to assure a sound understanding of the order and to make sure contract requirements are met.

This Purchase Order Supplemental is provided in support of the Technical Data Package and Purchase Order requirements. Please refer to the Technical Data Package for any special instructions, processing, or test requirements.

Special attention is required for all Defense Federal Acquisition Regulations Supplements (DFARS) set forth within the purchase order requirements.

Flow down of purchase order requirements must occur to all sub-tier suppliers of product and processes.

Documentation and Inspection Results shall be retained by the supplier for a minimum of seven (7) years and available to AMBAC International upon request.

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Section 1 – Purchase Order and Drawing Revisions

1. All parts shall be produced to the current revision level noted on the Purchase Order.
2. Notify AMBAC Purchasing Department of any discrepancies noted between the revision level on the P.O. and the revision level of the Engineering Print provided to the supplier.

Section 2 – Certificate of Conformance

1. A Certificate of Conformance (C of C) is required with each shipment.
2. The document shall include the supplier's name, purchase order number, part number, and quantity shipped.
3. The C of C shall state that the product has been produced to all purchase order requirements and applicable specifications.
4. The C of C must explicitly state compliance to any and all DFAR requirements as stated or referenced to on the AMBAC purchase order.
5. The C of C shall certify that process certifications, chemical and physical test reports, and inspection reports are on file and available for review upon request by AMBAC International.
6. The C of C shall be signed by the supplier's Quality Assurance Representative.

Section 3 – Material Certification

1. Material Certifications, including chemical and physical property inspection results, shall be supplied with each shipment of castings, forgings, bar stock, o-rings and gaskets.
2. The Certification must be traceable to the material or item by lot, production run or heat number, production date, cure date and/or item serial number if applicable.
3. All other supplied items must have Material Certifications available upon request.
4. All material certifications must include the country of origin.

Section 4 – Nondestructive Testing

1. Parts which have post heat treatment grinding operations performed must be inspected by Magnetic Particle Inspection for indications prior to delivery to AMBAC.
2. The Magnetic Particle Inspection shall be performed in accordance with ASTM E1444.
No indications permissible.
3. MPI operators must be trained in accordance with ASNT SNT-TC-1A Recommended Practices. Training records shall be made available to AMBAC upon request.

4. Inspection is required and must be documented and made available to AMBAC upon request.

Section 5 – Special Processes

1. Section 5 applies to special processes contracted directly by AMBAC and to suppliers providing parts and components with special processes as part of the Technical Data Package requirements.
2. Certifications for special processes are required from the primary supplier whether the process is performed by the primary or a sub-tier supplier.
3. If the process is performed by a sub-tier supplier, the certificate must be completed by that sub-tier supplier.
4. Special processes including, but not limited to, heat treatment, coatings, plating, weldments, and surface finishes require a certificate to be provided with the shipment.
5. The certificate shall include a statement that the process has been conducted per all purchase order requirements, related drawings and specifications.
6. The actual results of testing and inspections required by the standard or specification shall be stated on the Certificate.
7. Certs must be traceable to AMBAC purchase order number, part number, and quantity.

Section 6 – Specification Deviation

1. Exceptions or deviations to any Technical Data Package specifications or requirements must be submitted in writing to AMBAC Supplier Quality prior to shipment.
2. Request for deviation shall be submitted using AMBAC form# SQA-95-30.
3. No deviation or exception will be processed without the cause and corrective action section of SQA-95-30 completed at time of request.
4. Once the request has been processed by AMBAC, the supplier will be notified of the final disposition.
5. Product that has been approved for deviation shall include a copy of the signed Specification Deviation with each shipment.

Section 7 – Product Protection

1. All products shall be packaged to prevent rust, contamination, and handling damage during storage and shipment in order to prevent rejection at AMBAC receiving inspection.

Section 8 – First Article Inspection / No Change Clause

1. First time suppliers of product and current suppliers providing a new product must perform a First Article Inspection (FAI) conforming to AS9102 requirements.
2. The FAI documentation is to be submitted no less than 10 days prior to the purchase order due date.
3. The FAI must be approved by AMBAC before production parts can be shipped to AMBAC.
4. After approval of the FAI, all process changes shall be submitted in writing and approved by AMBAC International before implementation.
5. A process change is defined as any change in machine hardware design, coolant type, tooling package, heat treating, assembly process, routing or source change.

Section 9 – Fastener Requirements

1. Suppliers of Grade 5 or Grade 8 fasteners must comply with all engineering requirements on AMBAC's part number drawing and all referenced specifications.
2. With each shipment the Supplier shall provide documentation conforming to requirements found within AMBAC document SQA-95-10, Section 9.
3. Product must be traceable to a known North American manufacturing source by the fastener head logo marking and written documentation.
4. Supplier's laboratory test sampling size shall be performed in accordance with section 7.3 of SAE J-429.
5. Chemical and Physical properties shall meet all applicable engineering requirements.
6. Chemical and Physical Certifications – The certificate shall include actual material and chemistry elements, core hardness, tensile strength where length permits, and heat number.
7. The Cert shall be traceable to the purchase order number and part number.
8. Cap Fasteners – Must be identified with the proper grade symbol marking and manufacturer's identification logo.
9. Plating Certification – This document must include type of plating and associated specifications, AMBAC part number, supplier lot number, and quantity.
10. The document must also include the method used to prevent Hydrogen Embrittlement and be traceable to the AMBAC purchase order.

11. All other fasteners shall be supplied with a Material Test Report traceable to the supplied fasteners and AMBAC's purchase order number.
12. All certificates must be signed by an authorized supplier representative.

Section 10 – Shelf Life Items

1. Suppliers of product with rubber or synthetic rubber content shall provide a certificate indicating the part number, purchase order number, cure date, and expiration date.
2. Shipments shall not have multiple certifications indicating different cure dates.
3. Each shipment shall be accompanied by one certificate indicating one cure date and one purchase order number covering the entire quantity within the shipment.
4. Product must have a minimum of 90% shelf life remaining upon receipt at AMBAC.

Note: Contact your AMBAC buyer if you have questions or concerns.

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Record of Changes

Revision Level	Revision Date	Nature of Revision	Reviewed and Approved By
M	11/1/2017	Added requirements concerning DFARS and FAI	J. Smith
N	11/30/17	Revised Section 4 - IAW ASTM E1444. Section 8 - FAI Requirements.	J. Smith
P	02/11/2019	Revised Section 5 – Changed “Outsourced” to “Special” Process. Clarified who needs to provide a cert. Clarified requirements for testing and inspection results.	J. Smith

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