



Supplier Quality Requirements

Baskins Machined Products LLC
12645 N 103rd East Ave
Collinsville, OK 74021

This Supplier Quality Requirements (SQR) document describes Baskins Machined Products LLC (hereafter referred to as BMP) supplier quality requirements and expectations. **This document forms a part of BMP purchase orders.** Requirements defined in engineering specifications and purchase order takes precedence over the requirements in this document. The Supplier must adhere to the latest version of this document as it is updated at <http://www.bmp-ok.com>.

1. QUALITY MANAGEMENT SYSTEM

Supplier shall comply with a quality management system applicable to product/service being delivered: AS9100, ISO 9001, NADCAP, ISO17025, or AS9120. The supplier shall notify BMP of any change in supplier name, ownership, facility location or change in quality management system within thirty (30) days.

2. SUPPLIER SUB-TIER CONTROL

The supplier shall flow down provisions of this document to its subcontractors, but the supplier is responsible for products/services procured from its subcontractors. The Supplier **shall not** subcontract BMP products/services without BMP Quality Management approval.

3. INSPECTION SYSTEM

The supplier's quality system shall be in compliance with Mil-I-45208, ISO 9001 or AS 9100 requirements.

3.1-First Article Inspection (FAI)- First Article Inspection for new product or 2-year (Delta FAI) rule shall be performed and documented in accordance with AS9102 Aerospace Standard - First Article Inspection. The completed FAI form and supporting documents/records **must be** provided to BMP Quality prior to delivery.

3.2-First Piece Inspection & Approval Requirement- Supplier shall provide internal inspection results (Inspection check sheets, CMM reports, etc....) when a first piece is brought to Baskins Machined Products for inspection. Supplier shall obtain written notification from BMP Quality that is the product is conforming prior to machining the production lot of parts. BMP requires the Supplier to perform 100% inspection on the finished lot prior to delivery to BMP. Sampling Plan can be used for inspection of product **Only** if written acceptance of sampling plan has been provided to the supplier by BMP Quality Management designee.

3.3-Source Inspection- BMP reserves the right to perform source inspection activities at the Supplier's facility. The Supplier shall ensure product is not released to BMP if source inspection is required by BMP.

3.4-Release of Products & Services-BMP Supplier is responsible for the conformity & documentation required of products released to BMP. Supplier shall perform industry appropriate inspection activities to ensure conformity of product to the engineering requirements.

3.5-BMP Tooling Inspection Requirements- BMP Supplier shall visually inspect BMP furnished tooling upon receipt for damage, missing or loose components and notify BMP of any damaged or incomplete tooling.

4. RECORD RETENTION

Quality Records (e.g. Certifications, Inspection and Test Reports, etc.) shall be available upon request and shall be retained for a minimum of ten (10) years after completion of order.

5. RIGHTS OF ACCESS

The right of access by the organization, their customer and regulatory authorities to the applicable areas of facilities and to applicable documented information, at any level of the supply chain.



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6. CERTIFICATE OF CONFORMANCE

The supplier's Certificate of Conformance (C of C) shall contain BMP's Purchase Order Number. The supplier shall provide a (C of C) as required, assuring product or service performed in fulfillment of BMP purchase order conforms to requirements therein. The C of C shall contain the supplier's authorized representative certifying the shipment, their title, and signature or stamp and date. This requirement applies to suppliers of raw material and special process.

In addition to requirements above suppliers of metallic raw material shall also include the chemical and physical test report from the original mill with each shipment. The C of C must state heat or lot number, material type, grade, and applicable specification. The supplier must procure from an approved mill per End Customer requirements.

Special Processes: Supplier shall provide certifications for all special processes and nondestructive test results performed with each shipment. The certificate shall identify the processor, process used, specification & revision, and the test/measurement results. Supplier used shall be approved by BMP and/or End Customer approved source for identified processes. These include operations subject to process controls such as: Welding; NDT; Heat Treatment, etc. The Supplier shall be approved as per above to perform specific required Special Processes or use Special Process vendors acceptable to BMP and/or BMP end item customer.

7. CALIBRATION SYSTEM

Supplier shall maintain the National Institute of Standards and Technology (NIST) traceable calibration system capable of ensuring the accuracy of all measuring equipment utilized in the inspection and acceptance. Supplier shall notify BMP QM of Nonconforming condition prior to shipment.

8. NONCONFORMING PRODUCT

The supplier's system shall provide for timely notification to BMP of nonconformities that may affect already delivered product. Notification shall include a clear description of the discrepancy, part numbers, part description, quantity, batch numbers and ship dates. All Nonconforming material, if furnished by BMP, shall be red-tagged & Included in the shipment.

9. CORRECTIVE AND PREVENTIVE ACTION

The supplier shall respond to all requests for corrective action on or before the requested response due date.

10. TECHNICAL DOCUMENTATION AND CHANGE CONTROL/CONFIGURATION MANAGEMENT

The supplier shall maintain control of technical data e.g. drawings/ digital datasets/ specifications. When digital datasets are furnished by BMP the supplier's quality system shall comply with end customer requirements, but not limited to: Boeing-D6-51991; Spirit Aerosystems-MAA1-10009-1 & Gulfstream-GER-8216.

11. FOREIGN OBJECT DAMAGE (FOD) PROGRAM

The supplier shall maintain a FOD prevention program to identify and eliminate foreign objects or material in deliverable products.

12. PACKAGING AND HANDLING

As a minimum, the Supplier shall package all material in a manner that will ensure protection against corrosion, oxidation, deterioration, and physical damage during shipment. If required, oil must be placed on certain material to prevent corrosion. In addition, when materials delivered are lot-controlled and multiple material lots are shipped, each lot shall be separately packaged and identified.



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13. COUNTERFEIT PARTS

The supplier shall consider training of appropriate persons in the awareness and prevention of counterfeit parts; the application of parts obsolescence monitoring program; controls for acquiring externally provided product from original or authorized manufactures, distributors, or other approved sources; the requirement for assuring traceability of parts and components to their original or authorized manufactures; verification and test methodologies to detect counterfeit parts; and quarantine and reporting of suspect or detected counterfeit parts, notifying BMP of any counterfeit parts.

14. WORKMANSHIP QUALITY

Manufactured product shall be free from burrs, and sharp edges. Cosmetic issues caused by manufacturing or special processes must be identified. Supplier is responsible for the cost of product damaged due to mishandling by the supplier.

15. INTEGRITY & CONFIDENTIALITY

Suppliers shall hold all information received from BMP in confidence and no third-party request for information will be authorized unless approved, in writing, by BMP. The Supplier shall communicate with their personnel their contribution to product or service conformity, their contribution to product safety and the importance of ethical behavior.

16. ITAR & EAR

Supplier is responsible for compliance with any applicable export control laws and regulations with respect to any defense articles, defense services, or EAR-controlled items provided by it to BMP. In particular, the release of ITAR- or EAR-controlled technology, technical data, or software source code by the supplier to a Foreign Person (including a Foreign Person employee or another Foreign Person for the purpose of Off-Shore Procurement) is defined as an export under the ITAR (22 C.F.R. §§ 120.17 and 124.13) and EAR (15 C.F.R. § 734.2(b)) and is subject to the licensing requirements of the ITAR and EAR, as applicable. Supplier will obtain any authorizations required for the export of any defense articles, defense services, or EAR-controlled items provided by BMP, including for the release of any ITAR- or EAR-controlled technology, technical data, or software source code to any Foreign Person in or outside of the United States.

BMP Purchase Order Quality Codes (QC)

- **QC01-** Chemical/Physical material test reports is required with this purchase order. The test report shall contain the chemical physical properties of the material provided as required by the specification noted on the purchase order along with Batch/Heat Lot number. Traceability of the material shall be maintained from the mill to delivery to BMP. Substitutions regarding size, alloy, temper, etc. are ONLY allowed as called out on the Baskins Machined Products Purchase order. ANY other substitutions are UNAUTHORIZED without written consent from BMP Engineering/Quality Organization.
 - **Note:** If the Material provided is a casting or a forging, then the supplier shall also include a certificate for the following as required by the procurement specification:
 - Ultrasonic inspection
 - Magnetic particle Inspection
 - Radiographic Inspection
 - Penetrant Inspection
 - Pressure Test
 - Grain Flow
- **QC02-** A certificate of conformance (C of C) is required with this purchase order. The C of C shall contain the lot/batch number and a statement of conformance to the procurement specification(s). Full Test Reports shall be available to BMP if required by customer.
- **QC03-** A First Piece inspection must be performed at BMP, for each manufacturing operation or on a completed part once First Article Inspection has been accepted by BMP (whichever is applicable), during the initial run of



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each line item provided on the purchase order. The supplier's inspection results shall be made available at the time the part is provided to BMP for inspection.

- **QC04-** Source Inspection is required at the supplier's facility prior to shipment. Contact BMP Quality Management 48 hours in advance to schedule.
- **QC05-** The supplier shall ensure that products/material are handled and packaged in a way so as to prevent damage in process and during delivery of the finished product. Failure to do so, could result in the supplier being charged for rework, scrapping of product and/or subject to supplier corrective action issuance.
- **QC06-** A pack-list is required to be sent with the finished products. The pack-list shall be signed an approved company representative indicating the products were manufactured, inspected & conform to the requirements of the BMP purchase order.
- **QC07-** Special processing is called out on this purchase order. Special processing includes, but is not limited to: NDT (Non-Destructive Testing), Chemical processing, surface enhancement, heat treating, welding and coating application. Upon completion of the BMP purchase order, the supplier shall provide a signed certificate of conformance (C of C) including:
 - **Process Specification Number**
 - **Process Specification Revision**
 - **Part number**
 - **Processing Dates**
 - **BMP Purchase Order Number**
 - **Any Required Variable Information:**
 - **i.e., Coating Thickness, etch rate, etc.**

The supplier shall not subcontract work without written authorization from BMP. The supplier shall be NADCAP approved for processes that require it (I.E. NDT, Chemical processing, Surface enhancement, etc.)

- **QC08-** A certificate of conformance is required for this purchase order. Ensure certificates contain the gage number, calibration dates, a conformity statement listing the required specifications, an approval signature/stamp, and as found and final readings for each gage. All gages shall be calibrated in accordance with the latest revision of ANSI Z540-1, ISO 17025, A2LA, and ISO 10012 unless otherwise noted on the purchase order.
 - **Ensure standards used for calibration are traceable to NIST. Calibrate gages to OEM requirements unless noted otherwise.**
- **QC09-** First Article Inspections (FAI): On first product (NEW PRODUCT) Or Delta First Article product (2-year rule and/or process modifications) orders, a detailed first article inspection report and FAI supporting documents (material certs, processing certs, work order, bubbled/redlined information, etc...) are required and shall be compliant to AS9102 requirements. The report must be furnished with first shipment of product to BMP for verification, unless otherwise specified. The first article report and the product used should be identified & packaged separately, clearly identified and shipped with the production parts on the first delivery of new product. BMP reserves the right to witness the actual inspection or to require spot checks to verify data.



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Revision	Date	Revision Record
IR	01/01/2013	Initial Issue
07/18/2017	07/18/2017	Re-labeled and added 5. Right of access
07/27/2017	07/27/2017	Added #12, 13 employee awareness and counterfeit part prevention
A	12/21/2022	Updated Special Processes for clarity Updated 12 as Packaging & Handling Added: #14;15 & 16
B	3/29/2023	Added Supplier Calibration notification instructions for out of tolerance conditions found during calibration
C	5/22/2024	Updated Inspection Systems to Include subsections 3.1 through 3.5. Added BMP Purchase Order Quality Codes Section in its entirety.