



## **SUPPLIER QUALITY ASSURANCE REQUIREMENTS**

### **Scope**

As noted on the LANZEN purchase orders, compliance with the requirements of these Supplier Quality Assurance Requirements (SQAR) is necessary to meet minimum contractual requirements. The designated requirements supplement, but do not supersede, the presently existing terms and conditions of the purchase order or the Supplier Quality Manual (SQM).

### **7.0 Qualified Products List (QPL)**

Suppliers of products such as electronic components, primers, enamels, oil, welding rod, switches, regulators, etc. direct to LANZEN are responsible for furnishing these products as listed on the applicable QPL or have been approved for inclusion on such list. They shall substantiate the qualifications by listing the product, the name of the manufacturer, the QPL, and, if there is a shelf life on the product, the expiration date must be noted on the certification and the product.

### **10.0 Shelf Life**

Shelf life items are products that are effective or suitable for use for a limited time. LANZEN will only accept product with a minimum of 85% shelf life. Any percentage less than that will be considered non-conforming and will be rejected back to the supplier.

### **11.0 LANZEN Source Inspection**

Source inspection by a LANZEN representative is required prior to shipment of items from your plant. Suppliers shall notify LANZEN QA at least ten (10) days prior to availability of supplies for inspection. Performance of Source Inspection does not relieve supplier from responsibility should discrepant conditions be discovered after shipment.

### **12.1 Government Source Inspection at Vendor's Facility**

The items covered by this purchase document are subject to GSI and/or testing prior to shipment from the vendor's facility. Upon receipt of this order, promptly furnish a copy to the Government QAR who normally services your plant so that delegation can be arranged. Contact LANZEN immediately in the event the local Government QAR cannot be identified.

### **12.2 Government Source Inspection at LANZEN**

The items covered by this purchase document are subject to GSI at LANZEN. With your shipment enclose all required certification and test data as specified by the purchase order, drawing, SQAP, QAR, QAP and/or other applicable specifications.

### **13.1 First Piece**

For our suppliers, a 1st piece would be any part that meets the following criteria:



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- The first part of a production run
- Process change, i.e. – a change in material, method of manufacture, change in production location, etc.
- Revision changes
- It has been at least 1 year since the last production run

Initial, 1<sup>st</sup> piece, FAT/AS9102, PPAP, or weld samples are to be produced with a finished process and final production tools, fixtures, and gauges. These samples will be used to validate and approve the process. The number of samples may vary and will be communicated to the supplier if more than one is required. A supplier is not required to wait for verification of the 1<sup>st</sup> piece by LANZEN unless specified on the purchase order but proceeding with production before first piece has been approved is at the supplier's risk.

If there are instances where a 1<sup>st</sup> **must** be approved before continuing the production run, LANZEN reserves the right to request that a LANZEN representative be present at the supplier when a 1<sup>st</sup> piece is run and inspected.

A 1st piece shall be submitted with the following:

- The actual first part from the production run
- A tag with appropriate part number, p.o. number, and date of manufacture
- 100% inspection report that specifies actual measurement results and method of measuring. It is acceptable for "OK" or "Accepted" to be entered for variable data.

**Note: 100% inspection is required on all 1<sup>st</sup> pieces and that paperwork is to accompany the initial shipment unless it has previously been emailed to the quality department.**

### 13.2 First Article Inspection/Test

First article inspection/test is required, including performance testing and evaluation to the extent required by the Government. The supplier is responsible for scheduling inspection/tests to obtain government QAR approval and to provide a 10-day notice to allow LANZEN the option of witnessing the same. Supplier may request waiver of this requirement based upon previous approval on a government contract provided that no change has been made in facilities or methods of manufacture and there has not been for waiver must be submitted in writing to LANZEN QA and include evidence of prior first article acceptance.

### 13.3 Inspection Reports



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Inspection reports must be provided with each shipment for the parts in that shipment. The purchase order will state the expected quality plan. For example, the p.o. will specify whether 100% inspection for each feature is expected or 1 in 5 for key characteristics is required.

The inspection reports can be sent to a LANZEN quality representative by email or sent with the shipment. If sending with the shipment, please take precautions to protect them from the elements.

### **14.1 Certificate/Certificate of Conformance**

Certificate of Conformance is required and must accompany each shipment of material to LANZEN against this purchase document. Certificates must include the following data:

- Supplier Name
- LANZEN Purchase Document Number
- Part number and Revision level
- Quantity

Certifications must contain the signature and title of the authorized supplier representative. The certification must contain a statement that the supplier has on file and available for examination, evidence of conformance to the applicable specification. LANZEN QA reserves the right to request data supporting the Certification of Conformance. When requested, the supplier shall forward supporting data to LANZEN within five (5) working days.

### **14.2 Certification – Specific Requirements**

Same as 14.1, with the following additional requirements:

- Manufacturer's Name & Address (if different than suppliers)
- Manufacturer's Lot Number
- Inspection Date (if applicable)
- Drawing Number
- Specifications
- SQAP/QAR/QAP
- Test Results (as required).

### **15.0 SQP/QAR/QAP Applicable**

The drawings and/or specifications will list the mandatory SQAP/QAR/QAP required for minimum inspection and test control of the item being purchased.

### **16.1 Raw Material Certification**

Supplier shall include with required Certification of Conformance, a raw material certification stating type, grade and applicable specification & revision of the raw material used to manufacture the items on this purchase document. Traceability to LANZEN purchase document number is required.



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### **16.2 Chemical/Physical Test Reports**

Supplier shall furnish chemical analysis and physical test reports with each shipment. Reports must include heat or lot number, actual results of tests, and bear the company name, signature, and title of an authorized representative. Traceability to LANZEN purchase document number is required.

### **17.0 Chemical/Physical Coupons**

Supplier shall submit sufficient coupons representative of the material to the attention of LANZEN QA, in order that appropriate chemical and/or physical testing may be performed. Coupons shall be shipped prior to or with products and identified by part number, LANZEN purchase document number and applicable heat/melt number(s). Shipment of product is not to be delayed during approval process.

### **18.1 Ballistic Certification (Armor)**

Suppliers of armor must be qualified in accordance with the applicable specification. In addition to chemical and physical test reports required by the specification, supplier shall furnish evidence of ballistic qualification and the government approval letter including the final number for each heat/lot of material received for ballistic testing.

### **18.2 Ballistic Sample (Armor) – Lanzen Testing**

Supplier shall submit a specimen from the actual lot of armor material. Specimen shall be of sufficient quantity to allow ballistic testing. Supplier shall submit chemical and physical test data with the material specimen.

### **19.1 Hardness Test Certification**

Supplier shall submit results of hardness tests performed on material furnished. Hardness data must be in the appropriate scale, providing case depth data if required and bear the signature and title of an authorized representative of the organization performing the test. Traceability to LANZEN purchase document number is required.

### **19.2 Hardness Reports**

Suppliers shall submit to LANZEN QA a copy of heat treat procedures. The procedure shall bear the signature and title of an authorized representative of the organization performing the process.

### **20.0 Hardness Report Coupons**

Supplier shall submit sufficient coupons representative of the material to the attention of LANZEN QA, in order that appropriate hardness testing may be performed. Coupons shall be shipped prior to or with products and identified by part number, LANZEN



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purchase document number. Shipment of product is not to be delayed during approval process.

### **20.1 Round Part Heat Treat**

When a round part requires heat treat, Lanzen will furnish their heat treat supplier coupons from the production lot of material used to make that part. Those coupons are to accompany each lot of product being heat treated.

Coupons processed in this manner are to be sectioned to determine core hardness values. Core hardness values are to be compared with drawing or design requirements to verify compliance.

### **21.0 Tooling Approval (Castings/Forgings)**

Prior to proceeding with tooling for castings or forgings, the supplier must submit to LANZEN QA two (2) copies of a drawing marked up to show the exact size and configuration of the part to be supplied, including parting lines, draft angles, etc. The supplier may request a waiver of this requirement. Waiver approval will only be considered if all the following criteria apply:

- Part has been produced within the last twelve (12) months,
- Manufacturing methods or locations have not changed
- Design has not changed
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Request for a waiver must be forwarded to LANZEN QA.

### **22.1 Welding Certification**

Supplier shall furnish a Certification of Compliance for welding/joining processes used in the fabrication of purchase order line item. Certification shall state specification and revision, bear the signature and title of an authorized representative of the manufacturer performing the process and include a statement that evidence of compliance is on file and available to LANZEN upon request. Traceability to LANZEN purchase document number is required.

### **22.2 Welding Procedures**

Supplier shall prepare and submit to LANZEN QA, a procedure in accordance with the applicable welding/joining specification. When required by the specification, a workmanship specimen shall be prepared for approval through the suppliers DCMA QA Representative. If supplier's facility is not normally serviced by DCMA the specimen may be submitted to LANZEN for DCMA submittal.

### **23.0 Workmanship Specimen**



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Supplier shall submit a workmanship specimen representative of the procedure (when required by clause number 22.2) to the attention of LANZEN QA for the required inspection tests. Workmanship specimens shall be shipped prior to, or with the products and identified with part and purchase order number. Shipment of products shall not be delayed while awaiting approval of workmanship specimen.

### **24.0 Welding Equipment Approval**

Supplier shall provide certification for equipment used in the performance of spot, seam or other resistance welding processes as required by the applicable specification(s).

### **25.0 Nondestructive Testing (NDT)**

Suppliers performing nondestructive testing processes shall provide certifications, and/or test reports stating the applicable specification and revision and bear the signature and title of an authorized representative of the organization performing the test(s). In the case of radiographic examination, films must be submitted to LANZEN upon request. Traceability to LANZEN purchase document number is required.

### **25.0 Nondestructive Testing (NDT) Facility**

Prior to production of parts, supplier's NDT facility and applicable procedure must be approved by LANZEN.

### **27.0 Surface Preparation Procedure**

When the drawing specifies "Type I, spec TT-C490" or "MIL-DTL-16232", the supplier of the detail parts or assembly shall submit to LANZEN a copy of the plating source government approval letter for each process. When plating source approval letter is not available, the plating source shall prepare and submit through the supplier for approval by LANZEN, two (2) copies of their written procedure prepared in accordance with the applicable military specification prior to start of production. Furthermore, approval of the procedure will not require resubmission for any other drawing showing these surface preparations unless the procedure is revised.

### **28.0 Standard Processes - Finish**

When a drawing makes a reference to final, finish surface processes such as cadmium, zinc, chrome, anodizing, etc., the material must be processed in accordance with the applicable government or commercial specification. Supplier shall furnish with each shipment to LANZEN, certification signed by an authorized representative of actual facility performing the process, stating that process meets applicable specifications (including specification revision) in accordance with the requirements of this purchase order, and that specific data or other evidence of conformance to the applicable specifications is available for examination. Traceability to LANZEN purchase document number is required.



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### **29.1 Painting and Finishing**

Supplier furnishing materials, component parts or assemblies that require protective coatings such as primers and topcoats, must accomplish all cleaning and surface preparations as outlined on the drawing prior to the application of the finish coatings. The primer and/or topcoat applications must be accomplished using products that are procured in accordance with the applicable QPL.

Unless otherwise specified, all uncoated or unprotected ferrous and nonferrous metal surfaces (internal and/or external) must be protected for a minimum of thirty (30) days against rust and corrosion and be suitably packed to prevent damage from handling or shipping.

Supplier shall furnish with each shipment to LANZEN, certification signed by an authorized representative of actual facility performing the process, stating that process meets applicable specifications (including specification revision) in accordance with the requirements of this purchase order, and that specific data or other evidence of conformance to the applicable specifications is available for examination. Traceability to LANZEN purchase document number is required.

### **29.2 Painting and Finishing – Special Requirements**

Special paint and/or finishing requirements are required to facilitate subsequent operations. Please refer to the LANZEN purchase order which will define special requirements regarding paint and/or finish applications. Supplier should immediately notify the LANZEN buyer if any clarification and/or assistance is required in maintaining compliance. Supplier shall furnish with each shipment to LANZEN, certification signed by an authorized representative of actual facility performing the process, stating that process meets applicable specifications (including specification revision) in accordance with the requirements of this purchase document, and that specific data or other evidence of conformance to the applicable specifications is available for examination. Traceability to LANZEN purchase document number is required.

### **30.0 Validation Approval**

Suppliers of surface finishing, organic and chemical coatings must obtain validation approval of spectral reflectance characteristics and composition on each production lot/batch from the organic and chemical coating research group. A copy of the actual validation approval must be forwarded for each batch of coating utilized in the performance of this purchase order.

### **31.1 Age Control - Certification**





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Suppliers of items requiring identification of manufacture and expiration dates (age control) shall be identified in accordance with the applicable specification. Supplier shall provide Certification of Conformance to actual specification, and revisions: including batch identification, manufacture date, and expiration date as required. Certificate shall bear the signature and title of suppliers authorized representative and state that evidence of compliance is on file and available to LANZEN upon request.

### **31.2 Age Control – Specific Data**

Supplier of adhesives, rubber, gaskets, packings, hoses, etc. shall mark the parts and exterior shipping container in accordance with applicable military specification. The date of manufacture and expiration date (quarter/year) is required as applicable.

Products shall not exceed two (2) quarters (six months), from the date of manufacturer to ship date and acceptance at LANZEN or half of shelf life, whichever is less.

Test data (composition of rubber and applicable physical test results), including applicable batch numbers and date of manufacture and expiration date (as applicable) must be forwarded to LANZEN upon request.

### **32.0 Samples**

Supplier shall submit sufficient material samples to the attention of LANZEN QA (see clauses 31.1 and 32.2) from each applicable batch number for the required inspection tests. Samples shall be shipped prior to or with products and identified with part and purchase order number, batch number and date of manufacture. Shipment of products shall not be delayed awaiting approval of samples.

### **33.0 Assembly Control**

Supplier shall maintain dated control in accordance to applicable military specifications or standards (Re: clauses 31.1 and 31.2). All assemblies shipped to LANZEN shall be appropriately identified (on the nameplate, when applicable) to reflect applicable assembly date.

### **34.0 Test Reports**

Supplier shall furnish, with each shipment to LANZEN, performance test data for tests conducted on and identifiable to the product submitted (linked by serial number, when applicable). Performance test data reports must contain the signature and title of the person (or traceable inspector stamp) responsible for the tests. Traceability to LANZEN purchase document number is required.

### **35.0 Material Identification**





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In accordance with drawing requirements, product is required to be identified in accordance to MIL- STD-130. In addition to drawing requirements, material shall be identified by LANZEN Federal Supply Code for Manufacturer (FSCM-1A424). Example of preferred application is shown below.

CAGE Code - Part Number – Revision Level – “MFR” LANZEN CAG Code

Example: 19207-10911091-E MFR 1A424

Contact LANZEN representative when clarification on part marking requirements are required.

### 36.0 Packaging/Identification Requirements

Supplier shall accomplish identification, cleaning, preservation, packaging and packing in accordance with the applicable drawings, specifications and instructions as referenced on the purchase document. Furthermore, the supplier shall assure supplies are packaged using materials of grade size and weight which will provide adequate protection from damage, corrosion, and/or contamination during handling and transport to point of deliver. Packaged parts shall be identified with Part No. and LANZEN PO. A preferred Identification label is described below.

NSN #####-##-###-####  
Quantity  
CAGE - Part Number – Rev  
Description  
PO Number/Contract Number

Contact LANZEN representative when clarification on package marking requirements are required.

### 37.0 Return All Drawings and Changes

All drawings and/or changes shall be returned to LANZEN upon completion of this order. Supplier shall be held responsible for checking drawings and/or changes and implementation of this clause against change call out on the LANZEN purchase order.

### 39.0 Special Requirements

Supplier is to refer to the LANZEN purchase document and/or attachment(s) for special requirements concerning this item(s)

### 40.0 Government/Customer Right of Access

During performance on this order, your quality control or inspection and manufacturing processes are subject to review, verification, and analysis by authorized government or



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LANZEN customer representatives. Government QAR release of products prior to shipment is not required unless you are otherwise notified. A copy of this order will be furnished to your representative upon request.