

**IDS Terms and Conditions Guide**  
**Section Q**

**Clause Number: Q308**  
**Effective: 03/03/2008**  
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**SPACE STATION PROGRAM (SSP) OUTSIDE PRODUCTION/PURCHASED GOODS  
QUALITY REQUIREMENTS - DELIVERABLE**

1. Prior to work being performed Seller shall submit a detailed fabrication and inspection plan to Buyer's Supplier Quality Representative for review and imposition of Buyer's mandatory inspection points and shall contain the following as a minimum:
  - A. Nomenclature and identification of the goods to be provided.
  - B. Drawing and specifications required.
  - C. Tooling, jigs, fixtures and other fabrication equipment to be utilized.
  - D. Detailed instruction for fabrication, inspection, and assembly of goods.
  - E. Characteristics and tolerances.
  - F. Reference to detailed procedures for controlling processes and cleaning, preservation and packing operations.
  - G. Special conditions to be maintained such as environmental controls, specific cleanliness levels and precautions to be observed.
  - H. Applicable workmanship standards.
  - I. Specific inspections and/or test operations to be performed to provide verification of design characteristics.
  - J. Special handling equipment and protective devices. Configuration data, including parts lists, drawing changes, specifications, and identification data to ensure conformance to design requirements.
  - K. Traceability to the personnel performing each planned operation and to the inspection personnel verifying conformance.
  - L. Traceability to the critical item lists where applicable.
2. Seller Quality shall verify, prior to acceptance, the accuracy of production jigs, fixtures, tooling masters, templates, patterns and other devices used for fabrication and/or inspection. Additionally, establish a plan to periodically re-inspect those tools used as a "media of inspection" to verify the design integrity has been maintained. Records of these verifications shall be available for Boeing and/or government review.
3. Seller shall establish and maintain a system for the calibration of all measurement and test equipment and measurement standards in compliance with MIL-STD-45662A.
4. Seller's personnel performing or inspecting special processes shall be trained and certified. Evidence of personnel certification shall be available in the area where duties are being performed. Personnel shall be recertified as a result of unsatisfactory performance, changes in techniques or required skills, and/or extensive interruption of work performance. Records of training, testing and certification status of personnel shall be maintained and shall be available for review by Buyer.

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5. Seller shall document and implement a system for control of high strength threaded fasteners. High strength threaded fasteners are defined as 0.190 inch diameter or larger and 150 KSI or greater tensile strength. This system will provide for:
  - A. Seller's approved manufacturers and distributors.
  - B. Lot traceability to true manufacturers.
  - C. True manufacturers/manufactures/distributors material and test reports
  - D. Seller's certification documentation.
  - E. Physical and chemical testing at Seller's receiving inspection.
  - F. Fastener lot control and traceability through deliverable items.
  - G. Disposition of scrap and surplus fasteners.
  
6. Seller's procurement documents to subcontractors shall be approved by Seller's quality personnel prior to release, to ensure inclusion of appropriate quality requirements and associated documentation.
  - A. If Buyer has imposed Government Source Inspection (GSI) on goods and or services then Seller shall submit Seller's procurement documents for subcontracted goods and or services to the designated government quality representative for GSI requirement determination prior to procurement document release for the following purchase types: 1) purchases for products or services that are either complex or have critical application and which conformance to contract requirements cannot or should not, for economical reasons, be fully determined on receipt, or 2) purchases requiring shipment from Seller's subcontractor to the government.

However, procurement documentation for goods or services for which conformance to contractual requirements may be adequately determined by the Seller upon receipt do not require submittal to the government quality representative prior to release, but shall be available for review. Inspection performed by and for the convenience of the government shall not replace Seller or Seller's subcontractor's inspection nor relieve Seller or Seller's subcontractor's of the responsibility for ensuring product quality.
  
7. Data shall be maintained for articles identified as having characteristics of quality degradation or drift with age and/or use. The date, time or cycle at which the useful life is calculated; the date, time or cycle at which the useful life will be expended; and the incurred operating time or cycles shall be recorded.
  
8. Controls shall be established for the handling, packaging, packing and storage of articles and materials. Specific procedures shall be provided for limited life articles and materials. These controls shall be specified on control documents, such as drawings, specifications and procedures, and shall be implemented throughout all Seller operations. Controls shall be established to prevent damage, deterioration, or improper substitution of articles or materials. Cleanliness levels for articles and materials shall be maintained as provided in the contract.

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9. Seller shall prepare, maintain and deliver an acceptance data package (ADP) for each contract end item in accordance with SSP 30695, Acceptance Data Package Requirements Specification (latest revision), Additionally, all dimensions of 4 decimal places or greater must be recorded and included in the ADP. Where a specification allows for the selection of an optional or substitute part or material, or selection of a part, material, or finish from a qualified parts list or qualified products list, the ADP as-built configuration data shall detail the actual part, material, or finish used.
10. Records shall be retained in a safe, accessible location. This requirement shall apply to Seller's subcontractors. Seller shall be responsible for assuring that applicable records are not destroyed unless authorized in writing by Buyer's Authorized Procurement Representative.
11. Seller shall identify the true manufacturer's traceability number on each unit/package. Each packing slip and statement of certification shall identify the trace number as follows: "true manufacturing trace number \_\_\_\_\_". (trace number may be serial or batch numbers, dates, lot or heat codes or whatever relates the parts or materials to the manufacturing process. The type of trace number may be abbreviated, DC for date code, LC for lot code, HN for heat-treat number, etc.)
12. During first piece inspection all measurements must be recorded. Additionally, on all subsequent parts of the same configuration, critical/key characteristics must be recorded. This data shall be included in the ADP.

Authorized markings are contained in and controlled by engineering drawings. Other markings, including acceptance stamps, date stamps, build paper numbers, are not allowed to be stamped directly on deliverable goods.