

## BDS Terms and Conditions

Clause Number: Q067

Effective: 04/04/2014

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### MAINTENANCE, REPAIR, OVERHAUL, FAA REGULATED AND CERTIFICATED REQUIREMENTS SPECIAL PROCESS DOCUMENTATION & VERIFICATION RECORDS

Seller's certificated repair station is required to keep documented objective evidence in the form of records as part of the maintenance, repair and overhaul statement of work per Buyer or other OEM repair data for the following:

1. Verifiable documented objective evidence of:
  - a) pyrometric certification and control of ovens, autoclaves and other pyrometric equipment used for processing of parts, e.g., post plate baking, stress relieving, heat blanket repair and autoclave processing
  - b) equipment being calibrated over the range of usage for the equipment
  - c) periodic tool inspection for assembly tools to assure tool fitness for use and configuration
  
2. Verifiable documented objective evidence that:
  - a) the required and actual data for chemical and temperature control requirements for chemical process solutions used during chemical processing and plating of product during repair and overhaul activities were within acceptable ranges during processing e.g., Anodizing, chemical treatment of aluminum, cadmium plating, chrome plating, nital etch, rinse tanks etc.,
  - b) the required and actual process acceptance criteria and testing that verify necessary processes were accomplished and within required repair data parameters during repair and overhaul of parts, e.g., hydrogen embrittlement testing using notched tensile specimens, plating porosity meter, adhesion testing, hardness testing, corrosion testing, appearance, etc.
  - c) specified coating thicknesses for organic and inorganic coating post process are directly measured and within acceptable ranges as defined by repair data, e.g., chrome plate thickness, cadmium plating thickness, paint thickness, etc.
  
3. Verifiable documented objective evidence of required and actual repair data for metal conditioning and machining including but not limited to:
  - a) all shot peen required and actual parameters (manual and automated) as well as demonstration of intensity and saturation curves
  - b) all alloy steel and chrome grind required and actual parameters including grinding machine identification, wheel material information (material type, grit size, hardness, bond and structure), feeds (cross, down), speeds (wheel and work), and records of required periodic wheel dressing
  - c) stress relieve, oven identification as well as records of times and temperatures
  - d) records of testing for heat damage, post machining or grinding including method used and result of inspection

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4. Verifiable documented objective evidence of required and actual repair data for non-metallic (e.g., composite & adhesive) repairs and modifications including but not limited to:
  - a) parts and materials used in repair or modification,
  - b) "out time" records for materials that demonstrate that time and temperature records from "out time" until cure are within material data requirements supplied by the repair and or material OEM,
  - c) composite ply lay-up and orientation,
  - d) documented location and size of composite repair,
  - e) pre-cure processing of composite repair (compaction and/or debulk),
  - f) cure time, temperatures, pressures and vacuum parameters and post cure inspection data including composite repairs, adhesive applications requiring room temperature or elevated cures with or without vacuum or pressure.
5. Verifiable documented objective evidence of required and actual inspection process parameters and methods for non-destructive testing (NDT) inspections and the results of those inspections.
6. Verifiable objective evidence of Seller's ability to access and review Boeing's Contract and applicable requirements. Seller shall ensure Buyer's Contract and applicable requirements are available to Seller's appropriate Quality and Manufacturing personnel.

Seller shall make such records available to regulatory authorities and Buyer's authorized representatives. Seller shall retain such records for a period of not less than the time period set forth in this Contract from the date of shipment under each applicable order for all product/part numbers unless otherwise specified on the Contract. At the expiration of such period, Buyer reserves the right to request delivery of such records. In the event Buyer chooses to exercise this right, Seller shall promptly deliver such records to Buyer at no additional cost on media agreed to by both parties.

Boeing requires that the provisions/requirements set forth above be included in Seller's direct supply contracts (contracted maintenance) as well as the obligation that they be flowed to the sub-tier supply chain.