

Q930 Integrated Process and Product Control (IPPC) - rev 9/21/01

- (a) For hardware features deemed "critical" by Buyer, Seller shall provide documentation of the controls in place to ensure capability, manufacturability, and compliance. This information shall include reference to the Control Methods, Procedures, and Inspection Methods.

- (b) Control of the processes, manufacturing, and acceptance of the products shall comply with the following elements of the IPPC process:
 - (1) Seller shall document the Control Methods, Procedures, and Inspection Methods for the hardware on [Form MD-2634](#), Product Characteristic Accountability Worksheet (PCAW) provided by Buyer, per the instructions attached to this contract. Prior to hardware production/processing, Seller shall:
 - (A) Coordinate with Buyer's Procurement Quality Representative (PQR) for review and approval of the completed PCAW.
 - (B) Submit the completed form to Buyer's Procurement Representative for review and approval by Buyer's Quality Engineering and Responsible Engineering functions. Once approved, the PCAW shall be considered Seller's control plan for that hardware's critical features and no elements of this plan shall be revised by Seller without Buyer's approval. The approved PCAW will be acceptable for all subsequent orders of that hardware, unless changes to the control plan have been initiated by Seller.
 - (C) Ensure that critical features affected by sub-tier suppliers processes are controlled, and that information pertaining to this process is documented on the PCAW. Seller is responsible for managing sub-tier suppliers to ensure that any change made by those suppliers is communicated to Buyer.
 - (2) [Form MD-2635](#); Product Acceptance Requirements Chart (PARC) shall be completed for each part in the lot. Seller shall record the actual dimension of the critical features on the PARC document and follow up with acceptance or rejection notation and Seller's quality acceptance on the form. The form will be presented to Buyer's Procurement Quality Representative (PQR) for acceptance of the part. The PQR will review the data and has the authority to verify or request verification of the critical features.
 - (3) Concurrent with the submittal of the hardware to Buyer's PQR, Seller shall provide:
 - (A) The completed and approved PCAW document for review.

 - (B) The PARC document complete with the actuals recorded, stamped, and dated.
 - (4) The completed PARC document must be included as part of the Acceptance Data Package (ADP) and shipped with the hardware. The PCAW document is to be kept on file by Seller.