



MEGGITT PROCEDURE

QAP 7-4-05

Company confidential

Document	SUPPLIER QUALITY ASSURANCE PURCHASE ORDER REQUIREMENTS (Z CODES)
Version	A
Date	21 July 2016
Core function	Quality Assurance
Process owner	Group Quality Director
Approved by	Rob Crocker

REVISION RECORD SHEET

Version	Date	Description	Approval status
-	26 Jun 2015	Global procedure copied from Supplier Quality Assurance Purchase Order Requirements (Z Codes) (MABS252) Revision V Z53, Z54, Z56, Z58, Z59, Z60, Z67, Z71, Z72, Z73, Z74, Z75, Z78, Z79, Z80, Z82, Z83, Z84, Z85, Z87, Z88, Z89, Z91, Z92, Z93, Z94, Z102, Z104, Z107, Z108, Z109, Z110, Z111, Z112, Z114, Z120, Z125, Z130, Z131, Z142 deleted. Requirements thereof are now detailed in Meggitt Global Supplier Quality Requirement Document (SQRD) PRC-10.	Approved
		Z10 A added for CVR EXEMPTION	
		Z62 – Revised to detail part marking requirements in addition to drawing / specification only	
		Z66 (1) – NOTE 2 removed; (2) – NOTE 1 removed. Shelf life requirements now detailed in Meggitt Global Supplier Quality Requirement Document (SQRD) PRC-10.	
		Z70 – Reference to obsolete form removed	
		Z77 – Sub sections removed	
		Z81 – MABS® Revised to refer to industry standard only; subsections deleted	
		Z86 – Sub sections removed	
		Z105 – Revised to detail X-ray films only	
		Z106 – Revised contact details	
		Z115 – B added to state that suppliers with maintenance approval, release product in accordance with their approval.	
		Attachment B & C Deleted	
A	21 Jul 2016	Z 10A – added Note: All other requirements in QAP 7-4-01 apply.	Approved
		Z 90 – Removed MABS Organization	
		Z 100 A – Revised Z100A:	
		Z106 – Deleted the word “or” in last sentence	
		Z113 – Removed MABS	

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1.0 INTRODUCTION

The purpose of this document is to establish additional Quality Assurance requirements from those stated in Meggitt Global Supplier Quality Requirement Document (SQRD) PRC-10. This document applies to all suppliers performing work pursuant to Meggitt Aircraft Braking Systems Akron and Coventry purchase orders.

2.0 SCOPE

Akron – Only the Z codes that appear on purchase orders are applicable. When the following requirements are identified within a Meggitt Aircraft Braking Systems (MABS®) purchase order, they become a part of the contract requirements and must be satisfied by the Seller to fulfil the complete contract obligations of the purchase order. Where reference is made to specifications, standards or regulations noted in any of the requirements, the latest revision issued at the time of purchase order award shall be applicable on the Seller unless otherwise specified.

This revision only includes ACTIVE Z Codes. Any Z Codes that appear on purchase orders and are NOT on this list are INACTIVE and no longer applicable.

Coventry – Suppliers must satisfy all the requirements of this document where applicable. The requirements of this document are contractually binding on the supplier accepting a Meggitt Aircraft Braking Systems Coventry purchase order that references this procedure. If the purchase order defines requirements different from those quoted in this document, the purchase order requirements shall prevail. Where reference is made to specifications, standards or regulations noted in any of the requirements, the latest revision issued at the time of purchase order award shall be applicable on the Seller unless otherwise specified.

3.0 References

- Meggitt Global Supplier Quality Requirement Document (SQRD) PRC-10.
- MABS®QAP 7-4-01

4.0 Z Codes

Z 10: CERTIFIED SUPPLIER DOCK-TO-STOCK SHIPMENT

The seller is a Certified Supplier to MABS®. All requirements in MABS® Certified Supplier Manual QAP 7-4-01 apply. The Seller's MABS® assigned "Certified Vendor Representative" (CVR) shall stamp and affix a completed MABS® Certified Shipment Label as per QAP 7-4-01.

Z 10A: CERTIFIED SUPPLIER DOCK-TO-STOCK SHIPMENT – CVR EXEMPTION

The seller is a MABS Certified Supplier, however the use of MABS® Certified Shipment Labels and "Certified Vendor Representative" (CVR) stamps are not required on product or documentation.

Note: All other requirements in QAP 7-4-01 apply.

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Z 55: GOVERNMENT SOURCE INSPECTION (MABS® Akron Only)

All items on this purchase order to subject to Government inspection at the Seller's plant prior to shipment. Seller shall provide the Government Representative ten (10) days, advance notification of the event. Upon receipt of this purchase order, Seller shall promptly notify the Government Representative who normally services your plant and provide the representative with a copy of the purchase order so that the appropriate planning for Government inspection can be accomplished. If no Government Representative services Seller's plant, Seller shall notify the nearest Defence Contract Administration Service Office or other appropriate Government contract office. In the event a representative or office cannot be located, Seller shall notify the Purchaser's Procurement office immediately.

Z 57: SOURCE SURVEILLANCE ACCEPTANCE BY PURCHASER (MABS® Akron Only)

Prior to shipment, surveillance acceptance shall be performed by the Purchaser at the Seller's facility. The Seller shall notify the Purchaser at least three (3) working days in advance of the intent to ship and withhold each shipment pending necessary action by the Purchaser's Quality Assurance Representative (PQAR). The Seller shall provide all the necessary inspection/test data, facilities, equipment and personnel required by the Purchaser's PQAR. Final acceptance of the product will be at either the Purchaser's facility, or a site designated by the Purchaser. A copy of the Purchaser's Meggitt Sourced Shipment label (see Attachment B) shall be affixed to the relevant container (if applicable, this should be adjacent to the bar code label).

The Supplier Material Release form, completed by the PQAR, to show evidence the source surveillance was completed, must also accompany each shipment.


All inspection and/or test results documenting the item(s) compliance to the purchase order shall be retained by the supplier and made available for examination by the Purchaser upon request. This includes all supporting subcontractor documentation.

Note: sample inspection when performed by the seller shall be in accordance with the MABS® C=0 sampling plan using, as a minimum, 1.0 AQL. (Reference Attachment "A")

Z 62: PART IDENTIFICATION MARKING (MABS® Akron Only)

In addition to the "part identification marking" as specified by either the MABS® drawing, specification or supplement code Z62-, the supplier is required to apply their MABS® supplier acceptance stamp if they have been issued one by MABS®.

When a supplier acceptance stamp has been issued to the supplier by MABS®, it shall be applied as follows:

Example = 

- 1) Directly to the part on a non-functional surface near the part number.
- 2) Using the same method as specified for the marking of the part number. If the MABS® drawing or specification does not specify the method, then the supplier is permitted to

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use a permanent method that will not degrade the surface, such as vibro-etch or permanent ink.

- 3) In a size appropriate to the size of the part. The size of the MABS® supplied stamp may be altered to accomplish this, provided the stamp remains legible.

Z 66 (1): “O” RINGS, PREFORMED PACKING, AND SYNTHETIC RUBBER MATERIALS (ARP5316)

The identification, packaging, and age control conditions that apply to the age sensitive materials supplied on this purchase order shall be in accordance with SAE ARP 5316, with the following exceptions noted:

- Maximum batch number length, MABS® prefers 10 digits maximum, however will accept up to 15 digits.
- Requirement that same part number / batch number combination may NOT have the SAME cure date quarter. Permissible to add letter or -1, -2, etc. after basic batch to make number unique as long as total batch length less than 15 characters.
- “O” Rings and preformed packing shall be marked and packaged individually
- Synthetic rubber parts with suitable surfaces shall be marked individually.
- When suitable surfaces do not exist, identification marking may be accomplished by tagging the parts or marking the individual part container(s).
- The Seller shall identify (mark) these items with the following information:
 - Item part number, as defined by purchase order
 - Governing material specification number
 - Manufacturer’s compound number
 - Supplier/Manufactures batch control Number
 - Material cure date – preferred format: Quarter and Year of cure of the rubber component (e.g. July to Sept 2011= 3Q11)
 - Expiration date – preferred format: Quarter and Year of expiration for the rubber component (e.g. July to Sept 2012= 3Q12)

Note: When the Shelf Life is unlimited per SAE ARP 5316, then identify the package as “Unlimited” or “Unl.”

Z 66 (2): “O” RINGS, PREFORMED PACKING, AND SYNTHETIC RUBBER MATERIALS (BS 4F 68)

The identification, packaging, and age control conditions that apply to the age sensitive materials supplied on this purchase order shall be in accordance with BS 4F 68, with the following exceptions noted:

- Maximum batch number length, MABS prefers 10 digits maximum, however will accept up to 15 digits.

- Requirement that same part number / batch number combination may NOT have the SAME cure date quarter. Permissible to add letter or -1, -2, etc. after basic batch to make number unique as long as total batch length less than 15 characters.
- “O” Rings and preformed packing shall be marked and packaged individually
- Synthetic rubber parts with suitable surfaces shall be marked individually.
- When suitable surfaces do not exist, identification marking may be accomplished by tagging the parts or marking the individual part container(s).
- The Seller shall identify (mark) these items per the requirements of BS 3F 69

Z 70: LIMITED LIFE MATERIAL (SHELF LIFE) (MABS® Akron Only)

(Adhesives, epoxy, paint, solvent, fluxed solder, etc.) Each container must be identified with the manufacturer’s lot/batch number and shelf life expiration date.

Z 77: ACCEPTANCE TEST REPORTS (F.T. DATA ATTACHED) (MABS® Akron Only)

The Seller shall submit with each shipment one copy of the detailed results of all tests that verify and document the item’s compliance with purchase order requirements. Unless otherwise specified by MABS® Functional Test Instructions (FTI) the reports shall reference the purchase order number, item part number, serial number, part drawing revision level, item material number (if applicable), recorded test results (electrical, mechanical, performance, etc.), accept/reject criteria, signature of the tester, and date of test. The applicable A.Q.L. and sample size used must be shown. The methods of reporting shall be as follows: The method of reporting the data may be in the form of “variables” data (actual recorded values) or “attributes” data (evidence of test values are not recorded), or a combination thereof.

Note: All functional test data items shall be attached to or included with each individual unit. If a unit is boxed individually the functional test data shall be included in the same box.

Z 81: FIRST ARTICLE INSPECTION REPORT (FAIR) (MABS® Akron Only)

MABS® requires a First Article Inspection Report to be reviewed and approved by MABS® QA **PRIOR** to shipment of the initial lot of product. The MABS® QA signed AS9102 form 1 or the PPAP Product Submittal Warrant (PSW) is the MABS® approval of the FAI. The FAIR shall be submitted electronically.

Z 86: FAILURE ANALYSIS REPORTING

The Seller shall perform and report the results of a failure analysis on all failed items that were procured on this purchase order or that were returned under warranty. The completed report shall be submitted by Seller through the Purchaser’s Quality Organisation and must, as a minimum, provide the following information.

- Seller’s name, address, and date of report
- Purchaser’s Purchase Order and Rejection numbers

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- Part name, number, revision level, serial/lot number
- Specific failure mechanism
- Specific root cause of failure mechanism
- Impact of failure mechanism on parts previously delivered
- Corrective action taken to preclude recurrence and the effectively by date or serial/lot number
- List of materials required to repair any item(s) to be returned to the purchaser (if applicable)
- Signature and title of the Seller's Quality Representative approving the failure analysis report.

Z 90: LOT INSPECTION PLAN AND RECORD (L.I.P.R.) (C=0 reference Attachment "A") (MABS® Akron Only)

The Seller shall furnish, with each shipment, objective evidence of product compliance to the purchase order requirements in the form of a Lot Inspection Plan and Record as required by AS9100 and ISO 9001. When Code Z 57 and/or Z 10 are also a PO requirement the L.I.P.R. is NOT required to be delivered to MABS®. This record shall be filed at the supplier and made available to MABS® upon request. Sample inspection is acceptable, provided the inspection is performed in accordance with the MABS® C=0 sampling plan at 1.0 AQL or less. (Reference Attachment "A")

The L.I.P.R. shall document the following as a minimum:

- Purchase Order Number
- Part Number and Revision Level
- Part Name
- Inspection Lot Size
- AQL Level
- Characteristics inspected
- Inspection device used/ characteristic
- Serial Number when applicable
- Quantity accepted/rejected per characteristic
- Lot Identification, P.O. # Heat#, etc.
- Total quantity accepted and rejected
- Inspector's identification/signature/title
- Inspection date
- Variable (actual) data reporting is not required but accepted

Note: The L.I.P.R. is subject to acceptance by MABS® Quality Organisation.

Z 95: WELD REPAIR AUTHORIZATION POLICY (CASTINGS/FORGINGS) (MABS® Akron Only)

Weld repairs, which are not permitted by design drawings or specifications, require written approval of the Seller's weld repair process and procedures by the Purchaser (and Government procuring activity when required). The procedures for, and the performance of, weld repair shall be in accordance with the Purchaser's Process Specification. Weld procedures must be prepared and approved for each drawing part number (although the same procedures must be completed and concise in defining exactly how the repairs will be performed, qualified and documented). The Seller shall request Process Specification(s) from the Purchaser's Procurement Organisation for their use in preparing the procedures. All procedures shall be signed by the Seller's Quality Assurance Engineering representative. Unless otherwise specified, the seller in accordance with the record retention requirements of the Purchase Order shall retain any acceptance radiographs of weld repairs.

Z 96: MATERIAL SAFETY DATA SHEET (MABS® Akron Only)

Material Safety Data Sheet must accompany or precede shipment of material. Package must be labelled in accordance with MIL-STD-129 or recognized equivalent.

Z 100: PATTERN, MOLD, AND/OR DIE CONTROL REQUIREMENTS (MABS® Akron Only)

The Seller shall inspect one (1) sample, prior to initiating production, for the Purchaser's approval. The sample must be representative of the intended manufacturing procedures, process and equipment to be utilized during production. This sample shall be sent to MABS® when specifically requested. No changes in material, processes, tooling or site of manufacturing may be made after approval of Patterns, Die, Mold, etc. without written notification to the Purchaser. Unless otherwise specified in the Purchase Order, the Seller shall furnish the following reports along with the sample. All reports must be identified to the submitted samples.

- 1) Dimensional - listing all drawing characteristics (from each tool and/or tool cavity)
- 2) Chemical Analysis - actual composition (except ranges are acceptable for aluminium forgings and compound data for rubber products)
- 3) Mechanical Properties - the actual test result values
- 4) Grain Flow (Forgings Only) - photographs showing actual grain flow (show full cross sectional view)
- 5) Non-destructive Testing (NDT) - supporting documentation, and X-rays if applicable
- 6) Quality Lot Inspection plan - submitted for MABS® review.
- 7) Pre-production tests - as required by drawing and/or applicable material specifications.

Note: If die approval has been previously granted by MABS®, enclose a copy of die approval documentation to satisfy the above requirement.

Z 101: CONTROL OF ENGINEERING EVALUATION MATERIAL (MABS® Akron Only)

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The material supplied on this purchase order is intended for engineering evaluation of the product, process, and material (etc.) and not for production use. All items procured under this purchase order shall be conspicuously identified by permanent marking in accordance with 5D1-5156 with the following "Engineering Use Only". Where items do not have sufficient area to be permanently identified, 5D1-2885 shall apply.

Z 105: QUALITY RECORD'S RETENTION

The Seller shall maintain X-Ray film on file for a minimum period of Three (3) years, unless otherwise specified by Purchase Order Contract or referenced specification. This film shall also be made available to the purchaser's personnel upon request at no additional charge to the Purchaser.

Z 106: MABS® ASSIGNED SERIAL NUMBERS: (MABS® Akron Only)

Serial numbers (S/N) provided on this order shall be sequential with no gaps. Serial numbers shall be in the following format (unless otherwise specified by a drawing or specification) MMMYY-XXXX where M= Month, Y= Year and X= 4 digit number. (Example: SEP09-0001) The Seller is required to contact their assigned Buyer for serial numbers to be used for this Purchase order.

Z 113: MAINTENANCE/REPAIR & OVERHAUL PURCHASE ORDERS (MRO)

This source inspection shall be performed by a MABS® Procured Quality Assurance Representative (PQAR) or a "Designated Maintenance Quality Representative" (DMQR). When a MABS® PQAR is to perform source inspection, Code Z57 applies and source inspection will take place per Z57.

The DMQR is required to assure that the maintenance has been completed to the MABS® Service Order. Once satisfied that the required maintenance is complete and correct, apply their stamp to all inspection and test documentation in addition to stamping of the MABS® Service Order.

Note: The DMQR stamp impression is not to be applied to the part, subassembly or assembly.

Z 115: AIRWORTHINESS RELEASE CERTIFICATE

- 1) Suppliers with EASA Production Organisation Approval or FAA Production Approval Holders. The Supplier shall prepare and supply an EASA Form 1 (or foreign equivalent) or a FAA 8130-3 Form with each shipment. Contact the assigned Buyer for further details.
- 2) Suppliers with EASA Maintenance Organisation Approval, CAAC Maintenance Organisation Certificate or FAA Repair Station Approval Holders.

The Supplier shall prepare and supply an EASA Form 1 (or foreign equivalent), AAC-038 or a FAA 8130-3 Form with each shipment. Contact the assigned Buyer for further details.

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Z 135A: CONTROL OF COUNTERFEIT AND FRAUDULENT PARTS - (Electronics)

Electronic Parts / Components

Electronic parts / components must be purchased to the requirements stated below, and reference should also be made to Aerospace Standard (AS) 5553 Counterfeit Electronic Parts; Avoidance, Detection, Mitigation, and Disposition:

Electronic parts must be purchased, whenever possible, directly from Original Component Manufacturers (OCM's) or from authorized suppliers (i.e. Franchised Distributor or MABS Approved).

Original Component Manufacturers (OCM's) franchise agreements typically include provisions that protect the user by ensuring product integrity and traceability, such as:

- Original manufacturer warranty.
- Proper handling, storage and shipping procedures.
- Failure analysis and corrective action support.
- Certificates of conformance and acquisition traceability.

Franchised distributors should provide product acquired through franchise agreements with OCMs.

Documentation and Packaging Inspection:

The supplier should provide an unbroken chain of documentation (certifications, packing slips, etc.) tracing the movement of the parts back to the OCM, and certification that the parts have not been salvaged, reclaimed, otherwise used, or previously rejected for any reason.

Any Certificates of Conformance or other documentation should be examined for originality and applicability to the delivered material, including:

- Lot and/or date codes on the packaging do not match the lot and/or date codes on the parts.
- Manufacturer's logo or label is absent, or does not match that shown on their website or on previous shipments.
- Poor use of English, misspelled words, alterations, or changes to the documentation.
- Bar coding does not match the printed part number.
- Package materials are inconsistent with the description on the datasheet.
- An unbroken chain of documentation should include links between both paperwork and product with reference to C of C number and/or lot/batch number and/or date code, etc.

Visual Inspection:

Visual examinations should be performed on incoming parts at a magnification appropriate to the attribute under examination (Note: Some indicators of counterfeiting may not be detectable below 40X magnification).

Notifying MABS® when purchasing parts from Non-approved sources:

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When procurement from Original Component Manufacturers (OCM's) or from authorized suppliers is not possible then MABS® Form QAMABS0016 "Non-Approved Distributor Procurement Worksheet" must be completed and submitted to MABS® Procurement department. The form will then be circulated to the relevant areas for initial approval subject to inspection upon receipt.

Parts may then be required to be electrically evaluated by an approved test facility prior to formal acceptance.

Form QAMABS0016 is available from MABS Procurement or Quality upon request

Note: Independent distributors do not have warranty or product support agreements with the OCM and, therefore, have limited means to ensure product integrity and traceability. Broker distributors, in particular, may only act as scouting agencies for hard-to-find parts and may not maintain quality assured inventories.

Z 135B: CONTROL OF COUNTERFEIT AND FRAUDULENT PARTS – (Non-Electronic)

In the case of any orders being placed with distributors / stockists / agents, then the supplier is responsible for ensuring that:

Raw material / Standard Parts

- Raw material and standard parts are demonstrably traceable to the original source of manufacture.
- Raw material manufacturer's mill certification is available to MABS® upon request.
- Standard parts release documentation must make direct reference to the original source of manufacture and provide unbroken traceability to the original source.
- Proprietary parts shall be accompanied by the original manufacturers release documentation.
- Distributors / stockist must submit the OCM/ OEM certification along with all shipments

Distributors and Stockist

Visual examinations should be performed on incoming parts at a magnification appropriate to the attribute under examination (Note: Some indicators of counterfeiting may not be detectable below 40X magnification).

When procurement from authorized sources is not possible the supplier must notify MABS® to get authorization for the use of the alternate source. Parts may then be required to receive additional inspection and formal acceptance.

General

Franchised distributors should provide product acquired through franchise agreements with OCMs. All suppliers should provide an unbroken chain of documentation (certifications, packing slips, etc.) tracing the movement of the parts back to the OCM, and certification that the parts have not been salvaged, reclaimed, otherwise used, or previously rejected for any reason. Distributors and stockist must submit these documents along with shipments.

Any Certificates of Conformance or other documentation should be examined for originality and applicability to the delivered material. Inspections should include checks for the following:

- Lot and/or date codes on the packaging do not match the lot and/or date codes on the parts.
- Manufacturer's logo or label is absent, or does not match that shown on their website or on previous shipments.
- Poor use of English, misspelled words, alterations, or changes to the documentation.
- Bar coding does not match the printed part number.
- Package materials are inconsistent with the description on the datasheet.
- An unbroken chain of documentation should include links between both paperwork and product with reference to C of C number and/or lot/batch number and/or date code, etc.

Z 140: SURFACE TREATMENT SPECIFICATIONS (MABS® Coventry Only)

PRO000 contain lists of process specifications used for the manufacture of MABS® components. This document is intended to establish links between current and obsolete specifications, and to provide a reference guide to illustrate compatibility of MABS process documents (PRO's) and international specifications.

A copy of this document can be obtained from MABS® purchasing department.

Z 141: ENGINEERING MATERIALS SPECIFICATION (MABS® Coventry Only)

DMS000 contain lists of material specifications used for the manufacture of MABS® components. This document is intended to establish links between current and obsolete specifications, and to provide a reference guide to illustrate compatibility between current and obsolete material specifications.

A copy of this document can be obtained from MABS® purchasing department.

5.0 APPENDICES

ATTACHMENT "A"

MEGGITT AIRCRAFT BRAKING SYSTEMS

SAMPLE SIZES FOR "C=0" SAMPLING PLANS
 NOTE: The Acceptance Number in All Cases Is ZERO

LOT SIZE	"ASSOCIATED" Acceptable Quality Level (AQL)						
	.65	1.0	1.5	2.5	4.0	6.5	10.0
2 to 8	All	All	All	5	5	5	5
9 to 15	All	13	8	5	5	5	5
16 to 25	20	13	8	6	6	6	6
26 to 50	20	13	8	6	6	6	6
51 to 90	20	13	8	7	6	6	6
91 to 150	20	13	12	11	7	6	6
151 to 280	20	20	19	13	10	7	7
281 to 500	47	29	21	16	11	9	7
501 to 1,200	47	34	27	19	15	11	8
1,201 to 3,200	53	42	35	23	18	13	9
3,201 to 10,000	68	50	38	29	22	15	9
10,001 to 35,000	77	60	46	35	29	15	9
35,001 to 150,000	96	74	56	40	29	15	9
150,001 to 500,000	119	90	64	40	29	15	9
500,001 and Over	143	102	64	40	29	15	9

(C=0 Revision 06/29/2001)

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