		Form – Quality Requirements of Suppliers			
page 1 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

Record of Changes

Update	Date	Essence of Change	Auth.
01	04/03/2019	Update to IPC-A-610/620 for component assemblies subcontractor suppliers group (special quality requirements according to item/technology). Delete REV B from quality requirements of IAI Mabat (perform according to the updated version).	Eliran Gishri

1. Introduction:

1.1 A stable and strong relationship with the suppliers of Suron ACA Ltd. is essential for our success. We expect our suppliers to support and demonstrate commitment to quality by maintaining an effective quality management system as a basis for the improvement of products, services, and processes.

2. Definitions:

2.1 The Orderer – Suron ACA Ltd.

2.2 Supplier – A supplier or subcontractor supplier of products or services ordered by the customer.

3. Applicable Documents:

3.1 EN/AS 9100: 2016


3.2 AS9102 First Article Inspection (Latest Revision)

3.3 AS9103 Variation Management (Latest Revision)

4. Classification of Suppliers:

page 2 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

Group	Area of Activity
1	Subcontractor suppliers manufacturing mechanical parts, mechanical assemblies, and electronic/electromechanical assemblies in accordance with the schematics or specifications of the Orderer.
2	Manufacturers of electric circuits in accordance with the specifications of the Orderer.
3	Subcontractor suppliers of special processes (coating, painting, special adhesion, etc.) in accordance with the specifications of the Orderer.
4	Manufacturers of raw materials, metal accessories (nuts, bolts, screws, wires, etc.), and components (catalogue).
5	Distributors of components or metal accessories (nuts, bolts, screws, wires, etc.).
6	Testing, calibration, and laboratory services.

		Form – Quality Requirements of Suppliers			
page 3 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

5. General Requirements:

5.1 Quality Management System

- 5.1.1 The supplier shall be responsible for maintaining a quality management system in accordance with the requirements of ISO9001, AS9100, or AS9120 (Group 5).
- 5.1.2 The suppliers of special processes (Group 3) shall also be certified by the end customer or examined by representatives of the Orderer in accordance with the applicable requirements of Standard AS9100.
- 5.1.3 The suppliers of calibration and laboratory services (Group 6) shall be certified as an authorized laboratory according to the requirements of ISO17025 (the most recent version).

5.2 Awareness


- 5.2.1 The supplier shall confirm that workers performing the activity related to the Orderer are aware of their role in ensuring that the product meets the requirements; their role in ensuring the safety of the product; and the importance of ethical behavior.

5.3 Performance Monitoring

- 5.3.1 The Orderer carries out annual monitoring of the quality performance and timely delivery of the supplier.
- 5.3.2 A supplier with low levels of quality performance and/or timely delivery will be designated as a “supplier on probation” and will be required to submit a plan for improved performance.

5.4 Approval of Deviation and Notice of Product Nonconformity

- 5.4.1 The supplier is not authorized to make decisions regarding as-is usage or a nonconforming product standard.
- 5.4.2 A supplier seeking authorization for deviation shall submit a request in writing. The request shall be considered by the Orderer and approved to the extent possible. Authorization of deviations shall not be approved without the approval of the Orderer.
- 5.4.3 The supplier shall inform the Orderer, within 48 hours, of all nonconformities found by the supplier that could cause delay or the provision of nonconforming products.

		Form – Quality Requirements of Suppliers			
page 4 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

5.5 Corrective Action

- 5.5.1 The supplier shall initiate an investigation of the failing and take effective corrective action in each instance of nonconformity pertaining to the actions of the supplier.
- 5.5.2 Investigation of the failing shall include an analysis of the root causes of nonconformities pertaining to the human element.
- 5.5.3 The supplier shall take the immediate action necessary to prevent the negative impact of the nonconformity, including reporting the matter to the Orderer or to parties of interest.
- 5.5.4 The plan for corrective action shall be submitted to the Orderer for approval within 14 working days.

5.6 Entry onto the Premises of the Supplier

- 5.6.1 The supplier undertakes to allow employees of the Orderer who are certified to do so, and/or representatives of regulatory bodies, to enter the building and to provide information related to the Orderer's order. The Orderer undertakes to schedule visits ahead of time with the supplier.

5.7 Authentication of the Manufacturing Process (FAI) for Groups 1 and 2 Alone

- 5.7.1 Verification of the manufacturing process shall be carried out by means of FAI in accordance with the requirements of Standard AS9102.
- 5.7.2 The process shall be conducted for each new product, each change to a version of a product, or after a 24 month hiatus in the production of an item.
- 5.7.3 Fundamental changes in the manufacturing process after receipt of FAI approval shall be carried out only after informing and receiving the advance authorization of the Orderer.

5.8 Identification

- 5.8.1 Pieces shall be marked as required by the schematics or the detailed specifications and in accordance with the applicable standard.
- 5.8.2 In the case of mechanical items, marking must specify date code, manufacturer ID, schematic number, and version using a rubber stamp or another method of identification. The week/month and year of production shall also be specified.

5.9 Packaging, Shipping, and the Prevention of Foreign Articles

- 5.9.1 The supplier shall plan and execute the measures required for preventing damage to the product during the stages of production, shipping, and storage.

page 5 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

5.9.2 Pieces shall be packaged in a manner that enables certain and speedy verification of the number of pieces on the part of the Orderer.

5.9.3 A sticker indicating the nature of the product, the name of the supplier, and the exact number of pieces in the package shall be adhered to each packaging.

5.9.4 Each shipment shall include inspection reports and an invoice containing at least order number, serial number, and version number.

5.9.5 Prior to the packaging of products or the performance of a process, the products shall be inspected in order to identify and prevent the presence of foreign objects (FOD).

5.9.6 In the event that packaging specifications are specified by the Orderer or the customer, pieces shall be packaged in accordance with the specifications of the Orderer or the customer.

5.10 Traceability

5.10.1 Unless otherwise specified, pieces/materials shall be marked with the batch/lot number and shall include traceability to the lot of raw material.

5.10.2 Products or materials shall be supplied from a single lot of raw material. In the event that materials/products are supplied from different lots, the packaging and accompanying documentation shall be separated accordingly.

5.11 Records

5.11.1 Records shall be preserved for 10 years, unless a different requirement is specified within the order or by the end customer.

5.12 Certification of Workers

5.12.1 The manufacturing and inspection activity carried out by the supplier will be performed by workers who have been certified in accordance with the applicable standard requirements.

5.12.2 Quality inspectors and production workers, for whose work visual quality is important (for example, painters or coating workers), shall possess proper vision, including visual sharpness, visual depth, and proper color distinction. Assessment of the fulfillment of this requirement shall be performed by a certified party (optometrist/ophthalmologist) at the frequency of at least once every two years (unless otherwise specified by an applicable standard).


page 6 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

5.13 Making the Requirements Applicable to Subcontractor Suppliers

5.13.1 Work ordered shall be performed by the supplier. Work shall not be transferred to a subcontractor without the advance authorization of the Orderer's quality manager or a party operating on his or her behalf.

5.13.2 The supplier shall be responsible for implementing the relevant quality requirements of the end customers and making them applicable to the subcontractor:

Name of End Customer	Applicable Requirements
Rafael	Quality Addendum 93.00.63 (from Rafael's suppliers' portal: https://slp.storenext.co.il/my.policy).
IAI	Quality requirements according to factory (Lahav, Malat, Bedek) can be found on the IAI website at the following link (see requirements documents on the right hand side): http://www.iai.co.il/2013/10143-en/Suppliers_Net.aspx
IAI - MABAT	Quality requirements MG-T1001-0041
Elbit – UAV and Aircraft	OP301-D030-AERO-C.
Elbit – Land and Teleprocessing	Q906-C001-LAND-D.
Elisra	Specifications for quality requirements for mechanical production subcontractors – NH89D30003.
Elop	Quality requirements for purchasing – Q900-F002-ELOP-E.
Kinetics	Addendum for purchase orders – Quality requirements for mechanical items – Quality Instruction 07-04.2.
Ministry of Defense	Quality requirements for suppliers of the Ministry of Defense.
SCD	General purchasing quality requirements QPI160-GEN01.

		Form – Quality Requirements of Suppliers			
page 7 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

6. Special Quality Requirements according to Item/Technology

6.1 Group 1: Subcontractor Suppliers (metalworking/assemblies):

6.1.1 Metalworking:

- Upon supply, materials meant for one of the companies listed in the table in Section 5.13.2 shall be accompanied by an original validation certificate (STS/COC Shipper). In the event that validated material is not required, materials must only be acquired from a Western source (the US or Western Europe).
- Materials for flight customers that lack an original validation certificate shall be approved by the Orderer and the customer prior to being supplied to the Orderer.
- In the case of materials that the Orderer classifies as “critical,” the raw material shall undergo validation in an authorized laboratory operating under the responsibility of the supplier.
- Processes shall be performed only by subcontractors approved by the Orderer and the customer from a list of special process suppliers approved by the Orderer or the customer.
- During the production, examination, packaging, and shipping processes, the supplier shall ensure the conditions and actions necessary to prevent the presence of foreign objects.
- Unless otherwise specified, the sampling method used for final inspection shall be in accordance with Squeglia, AQL 2.5%.
- Key characteristics (KC) shall be managed in accordance with the requirements of Standard AS9103.

6.1.2 Component Assemblies:

- Work will be performed in accordance with the requirements of IPC-A-610 Class 3.
- LF production processes shall not be employed by the supplier without the authorization of the Orderer.
- Moisture-sensitive components shall be treated in accordance with standards JSTD-033 and JSTD-020.

page 8 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

- A 100% AOI inspection shall be carried out for all complex circuits or if otherwise specified by the Orderer or the customer.
- In the event of a recurring failure or the repair of more than 10% of the circuits in a batch, a repeat 100% Automated Optical Inspection (AOI) shall be performed.
- In the event that the quality of the work cannot be verified using an AOI, an X-Ray inspection shall be performed.
- The assembled cards shall be identified by a sticker containing MNF WW YYYY S/N (name of manufacturer, week produced, year produced, and serial number).
- The inspection status shall be distinguishable on the card (X-Ray, AOI).

6.1.3 Harnesses/Wiring:

- Work shall be performed in accordance with the standards of IPC/WHAMA-A-620 Class 3.
- For each new production batch, a prototype shall be produced and approved by the Orderer before the production of the batch.
- The supplier shall add COC and TR to the electrical inspections.
- Every braid and harness shall be marked with a sticker containing the catalogue number and version number.

6.2 Group 2: Electric Circuits

- 6.2.1 Work shall be performed in accordance with IPC-A-600 Class 3 requirements.
- 6.2.2 Coupons and inspection reports shall be provided for every batch.
- 6.2.3 Electronic cards shall be marked with P/N, D/C, REV, S/N, and manufacturer identification.
- 6.2.4 Circuits shall be packaged according by quantity using antistatic lamination and packaging that ensures protection of the intact pieces until their arrival at the Orderer's storage site.

6.3 Group 3: Special Processes

- 6.3.1 If required by the end customer or the Orderer, the items shall be supplied along with accompanying inspection samples.
- 6.3.2 If required and in accordance with the requirements of the Orderer, the schematics, the applicable specifications, or the end customer, a thermal treatment process or a

page 9 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

process for the release of Hydrogen embrittlement shall be performed. A report and graph of the treatment shall be provided along with the pieces.

6.3.3 Inspection reports for special processes shall include the requirements of the applicable schematics and specifications, their version and the results of the inspections, and the type of measurement tools used to perform the inspection.

6.3.4 Special processes shall be validated in accordance with the requirements of the applicable standards. Evidence of validation will be maintained by the supplier and presented to the Orderer upon request and as required.

6.4 Groups 4 & 5: Manufacturers/Distributors of Catalogue Materials and Items

6.4.1 Metal accessories (nuts, bolts, screws, wires, etc.):

- Metal accessories shall be supplied along with a conformity certificate that meets the requirements of the order. The report shall include the identifying information of the manufacturer and the batch number of the metal accessories.
- Metal accessories shall be supplied from a single production batch from a single manufacturer.

6.4.2 Components, cards, or products that are sensitive to electrostatic discharge (ESD)

- In the event that the components and/or cards and/or products in the order are sensitive to electrostatic discharge, the supplier will take all necessary protective measures and will ensure that the products are identifiable and packaged in protective packaging accordingly.

6.4.2.1 Adhesives / Paints/ Chemicals:

- The following information shall be indicated on each individual packaging: date of manufacture, recommended shelf life, and recommended conditions regarding storage, temperature, and moisture (and any other relevant conditions) for all items/materials with a limited shelf life supplied in accordance with the order. When it leaves the facility of the supplier, an item's remaining shelf life shall be no less than 80% of its total shelf life.

6.4.3 Electronic components:

- Electronic and electromechanical components shall arrive in bin-boxes or in whole original anti-static packaging of the manufacturer.

page 10 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

- Components with long limbs extending out of the bottom of the component (such as cables, transistors, etc.) shall be packaged in packaging that protects the limbs of the component.
- In the event that the items in question underwent re-rolling or re-packaging, this shall be indicated on the roll.
- It shall be confirmed that the components in the bin-boxes are not loose and do not do damage to one another.
- Every shipment must be accompanied by the manufacturer's COC.
- The components shall be identified according to their production batch using an ID sticker.

7. Prevention of the Purchase and Supply of Non-Genuine Components and Items

7.1.1 To reduce the risk of provision of non-genuine items, materials, or electronic components, the supplier shall meet the following requirements:

- The supplier shall meet the applicable requirements of standards AS5553 (for electronic items) and AS6174 (for materials and metal accessories).
- The items shall be purchased from the original manufacturer or an authorized distributor. In the event that it is not possible to purchase the items or materials from the manufacturer or an authorized distributor, the Orderer shall be contacted and its authorization requested.
- The supplier shall maintain a system that insures the traceability of the supply chain of the components and the items supplied, from the manufacturer to the Orderer.
- The supplier shall include with the order all the documents establishing the traceability of the purchase.

Traceability of the purchase shall include the identifying information of the parties involved in the supply chain, from the original manufacturer through the direct source from which the supplier purchased the item.

- In every shipment, the supplier shall include the original Certificate of Conformity (COC) issued by the component's manufacturer or authorized distributor, including the date code and the supplier's declaration of conformity, which shall include the identifying information of the Orderer's order.

page 11 out of 11	Rev 01	Doc. No.	F-03-03	Date of Implementation	20/03/18
		Edited by	Denis Mintz	Date Updated	4/3/2019
		Authorization of Dept. Man.	Lior Aram	Authorization of Qual. Man.	Eliran Gishri

- The first products/packaging shall be identified by a date code matching the certificate of conformity.
- The supplier must maintain records, including date code, batch and lot numbers, and all other documentation appended to the purchase order and the tax invoice.
- For MS/NAS items, the supplier shall add an original Certification of Test (COT) from the manufacturer.