

PURCHASE ORDER ATTACHMENT Q-16

X-Ray Forwarding

A. X-rays and associated non-destructive inspection (NDI) reports shall:

B.

1. Accompany their respective part shipments
2. Be documented on supplier's packing sheet
3. Be packaged together with x-ray sample parts
4. Be conspicuously marked on package and easily retrieved from the shipment

Note: Buyer's source engineer has the option to select and identify the samples to be x-rayed.

B. For parts shipped to suppliers (other than Boeing Satellite Systems), all x-rays and associated NCD reports shall:

1. Be sent to Receiving Inspection to the address as indicated on the purchase order.
2. Be pre-approved in writing by Boeing Satellite Systems prior to part shipment to other supplier (drop shipment of parts to other suppliers is prohibited without written approval from Boeing Satellite Systems).

Note: Boeing Satellite Systems source engineer shall be notified for acceptance inspection of parts until supplier has received written x-ray approval from Buyer.

A. DIE CASTING FOUNDRY CONTROL. Foundry control qualification lot shall consist of examinations and tests by visual, destructive and non-destructive inspections, as applicable, to establish gating, pouring and other foundry practices. The following requirements are applicable:

Visual Examination

Non-destructive Inspections

Penetrant Inspection Radiographic Inspection

Chemical Analysis

The foundry control qualification lot shall consist of ten castings from each die cavity. When more than one die cavity is used, all casting from each cavity must be identified with the die cavity location. For each lot of ten castings, nine of the castings shall be completely processed and one casting shall be processed to remove extraneous protrusions such as gates, risers, runners, spurs and parting lines, buy only to the degree that evidence of these features retained on the casting.

All x-rays, associated reports/documentation and qualification castings shall:

1. Be sent to Buyer.
2. Be pre-approved in writing by Boeing Satellite Systems prior to part shipment. Shipment of parts is prohibited without written approval from Buyer's Quality.

Note: Buyer's source engineer shall not be notified for acceptance inspection of parts until supplier has received written approval from Buyer.

END OF DOCUMENT

THE TEXT OF THIS DOCUMENT SHALL NOT BE CHANGED EXCEPT BY WRITTEN AGREEMENT BETWEEN BUYER AND SELLER