

IMSQC1: Standard IMS Quality Clauses	
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Clause Subsection Title	Description
A. L3HARRIS Supplier Quality Manual	All sections of L3HARRIS Supplier Quality Manual (QA-01.1) apply unless otherwise stated on the order.
B. Q Clause Order of Precedence	These Q clauses are part of the "General Terms and Conditions" referenced in the "Purchase of Items and Services and Order of Precedence" term of this Order. In the event of conflict in the Q Clauses, the following order of precedence applies: <ol style="list-style-type: none"> 1. Site Program Specific Q Clauses (Site) 2. Site Specific Q Clauses (Site) 3. IMS Harmonized Q Clauses (Segment) 4. Corporate Supplier Quality Manual QA-01.1 (Corporate, latest revision online)
C. Right of Entry	L3Harris, its customer, and/or their authorized inspection agency or regulatory authorities shall have the right to send representatives to the Supplier's facilities on a non-interference basis to determine order compliance. Compliance may be determined by auditing, monitoring, witnessing, and/or performing such activities as inspections, test witness, process, and/or product evaluations and verifications as necessary to determine product acceptability to contractual requirements. The type, necessity, and degree of demonstration of conformance shall be at the sole discretion of L3Harris, taking into consideration such factors as product complexity, the environment where the product is used, the ability to determine product quality after receipt, and past Supplier performance. <p>Without additional charges, the Supplier and/or their sub-tier shall make their facility and applicable records available for these activities. They will also provide all reasonable support for the safety and convenience of these representatives during their stay at the Supplier's and/or their sub-tier plants and facilities.</p> <p>Note: Verifications accomplished by L3Harris or its customer shall neither be used as evidence of effective control of quality by the Supplier nor shall they preclude subsequent rejection by L3Harris or its customer.</p>
D. L3Harris Audit	The Supplier is subject to an audit by the L3Harris in relation to the product being manufactured for this Order.
E. Counterfeit Parts Audit	The Supplier is subject to an audit of their Counterfeit Parts Mitigation Program by L3Harris.
F. Special Process Audit	The Supplier is subject to an audit of their special process(es) by the L3Harris.
G. Sub-Tier Flow-down Clause	If sub-tier suppliers are used in support of this Purchase Order, the Seller shall ensure the contract requirements, including quality requirements are flow-down in sub-tier contracts. Seller shall meet the following: <ul style="list-style-type: none"> • Sellers documented Quality System shall provide for the review of the Purchase Order to ensure applicable requirements are flowed down to sub-tiers including Quality Requirements and Terms and Conditions. • Seller shall notify the Buyer when any of their sub-tiers are found to be non-compliant to Seller's specification, disapproved by Seller and/ or a government/industry data exchange program (GIDEP) alert is required. • Seller's documented Quality System shall include procedures for determining the capability of sub-tier suppliers, prior to issuance of Seller's purchase order to any sub-tier supplier. • Seller shall define and establish a program for determining the need for periodic re-evaluation of Seller's sub-tier suppliers to ensure compliance with the Purchase Order requirements. • Seller shall include in its purchase orders to sub-tiers the applicable revision or amendment level for referenced Buyer's specification or other documents. • Seller shall maintain a documented receiving inspection function to ensure material received from Sellers's sub-tiers is inspected to and meets the requirements of the Purchase Order. Material shall be identifiable to the Purchase Order. • Seller shall ensure the content of this clause or equivalent provisions are flowed down to all suppliers and sub-tiers associated with delivery of items that will be included in or furnished as work to the Buyer.
H. Process Change Notification	The Supplier shall promptly notify L3Harris of any design or process changes. This includes changes to materials, processes, procedures, design interfaces, inspection or test equipment, software, sources of supply (products or services), or facility location (including location changes within facility), which affects the form, fit, function, safety, reliability, maintainability, testing, weight, or any other requirement or specified, implied, or advertised characteristic of the product or service. The Supplier shall submit approval requests in writing to L3Harris. A copy of approved requests shall be provided with delivered product(s).

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I. Serialization	Serial numbers are assigned to individual units within a Configuration Item (CI) family. Once assigned, serial numbers provide the audit trail for an item's complete life cycle. Serial numbers shall be unique, consecutive, and non-duplicating for all items within a specific configuration item family's root number. Serial numbers shall be assigned to specific units at the start of their manufacturing cycle. Once assigned to a unit, the serial number shall not be changed, and shall not be re-used. Where L3Harris defines serial number format it shall be specified in the contracting documentation.
J. Electrostatic Discharge (ESD) Control Program	The Supplier shall implement an Electrostatic Discharge Control (ESD) program in accordance with the current revision of ANSI/ESD S20.20. Electrostatic Sensitive Devices shall be packaged and handled to preclude damage to devices. The device packaging must also be clearly marked with ESD caution symbols that comply with ANSI/ESD S8.1.201, Symbols – ESD Awareness.
K. Calibration Control Program	<p>Calibration of inspection equipment shall be in accordance with a nationally or internationally recognized standard (i.e. ISO/IEC 17025, ANSI NCSL Z540 or ISO 10012) to the extent necessary to maintain required levels of accuracy. This as well is subject to L3HARRIS approval. If production tooling such as jigs, fixtures, templates, and patterns are used as a media of inspection, a calibration plan shall also be established. When required, the Supplier's measuring and test equipment shall be made available for use by the L3Harris representative to determine conformance of product(s) with order requirements. In addition, if conditions warrant, Supplier's personnel shall be made available for operation of such devices and for verification of their accuracy and condition. Supplier must notify L3Harris of any out of tolerance calibration. A risk/impact assessment will be delivered in a form of a quality notification.</p> <p>Traceability of calibration of equipment and gauges shall be performed in accordance with an industry recognized calibration standard, unless stated otherwise in the Order.</p>
L. Special Processes (L3Harris Approved)	Special processes performed either by the Supplier or their Sub-tiers shall be approved by the L3Harris. Special processes are defined as processes where resulting output cannot be verified by use of visual or common measuring techniques. L3Harris considers the following to be special processes: chemical processing (anodizing, painting, etc...), heat treating, soldering, welding, composites, gasketing, coatings, non-destructive testing, material testing laboratories, castings, additive manufacturing, non-conventional machining and surface enhancements.
M. Product Safety & Ethics	Suppliers shall have a process in place to ensure that persons are aware of: <ol style="list-style-type: none"> 1. Their contribution to product or service conformity 2. Their contribution to product safety 3. The importance of ethical behavior
N. Notification of Potential Safety Issues	The product provided to L3Harris is defined as a Critical Safety Item (CSI), and the Supplier shall report nonconformance(s) in full compliance with Defense Federal Acquisition Regulation Supplement (DFARS) 252.246-7003.

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O. Prohibited Materials	<p>O1 - Metals Unless otherwise specified on the drawing or Order, the use of zinc, cadmium, beryllium, magnesium, mercury, or pure tin (>97% Sn) is expressly prohibited. The Supplier shall communicate these restrictions to their Sub-tiers as required.</p> <p>O2 - Prohibited Materials - Plating Piece parts, hardware, and assemblies (including internal hardware) shall have NEITHER internal nor external surfaces plated with pure Cadmium, Cadmium alloys containing greater than 5% Cadmium by weight, pure Zinc, Zinc alloys containing greater than 10% Zinc by weight, or tin, without being over-plated by an approved material. Electronic part terminals and leads coated with a tin alloy shall contain a minimum of 3 percent (3%) lead (Pb) or silver (Ag). The Supplier shall provide a C of C with each shipment, along with a copy of the OEM certificate, which attests that the products contained therein meet the specified minimum 3% lead/silver requirement and the requirements of the Order.</p> <p>O3 - Prohibited Materials – Pink Poly This Pink Polyethylene material is prohibited from use in any form (e.g., bags, bubble, wraps, trays, bottles, foam, connector caps, etc...) on all products delivered to the L3Harris.</p>
P. Electrical/Electronic (CCA/PCB, WHA, etc...) Design & Manufacturing Standards	<p>The following IPC Standards apply, as required, when designing and manufacturing components, parts and/or assemblies. In the event there is a conflict between the following requirements and requirements contained within the drawing or statement of work the order of precedence is as follows:</p> <ol style="list-style-type: none"> 1. Drawing 2. Statement of Work. 3. Purchase Order <p>P1 - IPC Standards for Printed Circuit Board Design and CAD (IPC-2220) Electrical design requirements for Printed Board Design shall meet the requirements of IPC-2220.</p> <p>P2 - Requirements for Surface Mount Design and Land Pattern Standard (IPC-7351B) Electrical design requirements for Surface Mount and Land Pattern shall meet the requirements of IPC-7351B.</p> <p>P3 - Specification for Base Materials for Rigid and Multilayer Printed Boards (IPC-4101) Printed Circuit Cards shall meet the Class 3 requirements of IPC-4101. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p> <p>P4 - Specification for High Density Interconnect (HDI) and Microvia Materials (IPC-4104) Printed Circuit Cards that include High Density Interconnects and Microvia Materials shall meet the Class 3 requirements of IPC-4104. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p> <p>P5 - Cover and Bonding Material for Flexible Printed Circuitry (IPC-4203) Printed Circuit Cards that include Flexible Printed Circuitry shall meet the Class 3 requirements of IPC-4203. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p> <p>P6 - Generic Performance Specification for Printed Boards (IPC-6011) Printed Circuit Cards shall meet the Class 3 requirements of IPC-6011. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p>

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	<p>P7 - Qualification and Performance Specification for Rigid Printed Boards (IPC-6012) Rigid Printed Boards shall meet the Class 3 requirements of IPC-6012. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p> <p>P8 - Qualification and Performance Specification for Flexible Printed Boards (IPC-6013) Flexible Printed Boards shall meet the Class 3 requirements of IPC-6013. Coupons shall be captured for each run and analyzed prior to commencing work on the CCA. Suppliers and sub-tier Suppliers shall have inspectors certified to IPC-A-600 and the ability to validate PCB compliance including micro section evaluation.</p> <p>P9 - Acceptability of Printed Boards (IPC-A-600) Suppliers of printed boards' design and workmanship criteria shall be in compliance with IPC-A-600 Class 3 acceptability requirements, unless otherwise stated on the Order.</p> <p>P10 - Acceptability of Electronics Assemblies (IPC-A-610) Suppliers of electronic assemblies' design and workmanship criteria shall be in compliance with IPC-A-610 Class 3 acceptability requirements, unless otherwise stated on the Order.</p> <p>P11 - Requirements and Acceptance for Cable and Wire Harness Assemblies (IPC/WHMA-A-620) Suppliers of cables and harnesses' design and workmanship criteria shall be in compliance with IPC/WHMA-A-620, Class 3 acceptability requirements unless otherwise stated on the Order.</p> <p>P12 - Requirements for Soldered Electrical and Electronic Assemblies (IPC J-STD-001) Suppliers of soldered electrical and electronic assemblies' design and workmanship criteria shall be in compliance with J-STD-001 Class 3 acceptability requirements, unless otherwise stated on the Order. NOTE: Where IPC J-STD-001 & IPC-A-610 "Class 3" conflict, use IPC-A-610 "Class 3"</p> <p>P13 - Solderability for Leads and Terminations Solderability of leads and terminations shall comply with the requirements of J-STD-002, Typical Coating Durability for Tin and Tin-Lead Finish Electronic Component Leads, Terminations, Solid Wire, Lugs and Tabs. Any parts delivered that are over 2 years old from date of manufacture shall be accompanied by a CofC that documents that parts have been re-certified to meet above requirements. Solderability of Printed Wiring Boards shall be performed and evaluated to the requirement of J-STD-003, Solderability Tests for Printed Boards. The shelf life of products meeting the requirement of J-STD-003 will be 1 year from date of manufacture for tin/lead fused finished and 6 months for hot air leveled products. Material delivered will have a minimum of 80% of the shelf life remaining. Residual materials with less than 80% of the designated shelf life remaining will not be acceptable for delivery.</p>
Q. Barcoding	Seller shall provide barcoded product identification on the packaging and associated documentation for contract-identified deliverables. The labels shall be interpretable/readable by a barcode scanner and placed in a manner to prevent folds, creases, or damage. If there is a conflict between this requirement and the marking requirements on the item drawing, the drawing takes precedence.
R. Government Industry Data Exchange Program (GIDEP) Participation	The Supplier shall participate in the Government Industry Data Exchange Program (GIDEP) program in accordance with the requirements of the GIDEP S0300-BT-PRO-010 and S0300-BU-GYD-010. The Supplier shall be responsible for monitoring and reporting GIDEP Alerts for impact to items delivered to L3Harris, and shall take action to eliminate or mitigate any negative effect to an acceptable level. The Supplier shall generate the appropriate failure experience data report(s) (GIDEP ALERT, GIDEP SAFE-ALERT, GIDEP Problem Advisory) whenever failed or nonconforming items are discovered.

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S. Independent Distributor Buys	The Supplier shall only purchase or acquire all Parts directly from Authorized Sources, such as Original Equipment Manufacturers (OEM), Original Contract Manufacturers (OCM) or Authorized Distributor. The Supplier SHALL NOT purchase part from or use Independent Distributors to supply parts without the prior written consent from L3Harris.
T. Test Lab Order Clause – Mechanical Part and Materials	<p>Manufacturer specifications and parameters shall be used as applicable for part and material requirements. Recorded evidence of all testing performed shall be included with each shipment.</p> <p>The following inspections and tests are required for mechanical parts and materials by an accredited third party testing facility:</p> <ol style="list-style-type: none"> 1. Packaging inspection (part number, evidence of tampering, etc...) 2. Part/Packaging marking inspection for evidence of remarking or alterations (part number, mfg. name, trademark or logo, lot or date code, grade, etc...) - sample of 3 pieces per lot for part markings. 3. Mechanical parts external visual inspection (100%) for damage, wear, contamination, or use. 4. Mechanical parts dimensional inspection – selected critical dimensions shall be verified per manufacturer specifications on a sample of 3 pieces per lot. 5. Plating Verification (e.g. XRF) - sample of 3 pieces per lot. 6. Base material verification (certification of composition/chemical analysis, heat treatment, hardness testing, tensile strength, torque testing, magnetic particle, etc... as applicable per material specification) - sample of 1 piece per lot. 7. Mechanical Item Test Verification (if required by the item specification) - sample of 1 piece per lot. <p>Seller shall report all occurrences of Counterfeit parts to GIDEP and ERAI.</p>