



REVISION HISTORY

<u>REV</u>	<u>DATE</u>	<u>ORIGIN</u>	<u>REASON FOR CHANGE(S)</u>
A	09/28/04	Scott Ubl	New
B	08/08/05	Scott Ubl	Added additional cross section and coupon requirements
C	5/04/18	Daniel Crouse	Added PCN language

Q-CODE Q25 QUALITY REQUIREMENTS

The following are the quality requirements for product purchased under Q-code Q25. Unless a written waiver is received from Plexus, the supplier agrees to abide by the quality requirements listed below.

First production run/Pre 1st Shipment - Before a product can be released for production the supplier will be required to meet the documentation and quality requirements as follows:

- A. First Article Inspection Requirement – Supplier will execute the Aerospace First Article Inspection requirements of the SAE standard, AS9102 and provide the results to Plexus with each shipment in which the requirement is to be executed. With acceptance of, or receipt of product against this order the supplier agrees to allow Plexus, their customer and regulatory authorities the right of access to their facility and all applicable records.
- B. Additional First Article Inspection Requirements
 - Only one part or assembly will be selected and inspected as part of the First Article Inspection Requirement.
 - Only one part or assembly should accompany the FAIR unless otherwise requested.
 - Raw materials must have direct traceability with the chemical and physical properties submitted to Plexus.
 - Special processes utilized by the supplier will require a certificate of compliance at a minimum.
- C. Quality Code 21 Requirements – For all shipments of Programmed parts also complete the requirements of Q21.
- D. Quality Code 22 Requirements – For all shipments of PCBs also complete the requirements of Q22 with the following additions
 - A cross section (Q22 bullet B) must be supplied from every manufacturing panel regardless of layer count.
 - A coupon must be supplied from every manufacturing panel.
- E. All cartons, packing slips and C.O.C.'s must have part number, EC level or revision, quantity and P.O. number listed on them.

Subsequent Shipments- The documentation and quality requirements for all subsequent shipments will be as follows:

- A. First Article Inspection Requirement – Supplier will execute **First Production Run requirements** and provide the results to Plexus with each shipment following any subsequent change that invalidates the previous first article inspection result per AS9102. In addition, parts held in inventory by the supplier for 2 or more years or not received by Plexus in 2 or more years must have the **First Production Run requirements** performed to assure no revision change or part deterioration during storage. With acceptance of, or receipt of product against this order the supplier agrees to allow Plexus, their customer and regulatory authorities the right of access to their facility and all applicable records.
- B. Quality Code 21 Requirements – For all shipments of Programmed parts also complete the requirements of Q21.
- C. Quality Code 22 Requirements – For all shipments of PCBs also complete the requirements of Q22 with the following additions
 - A cross section (Q22 bullet B) must be supplied from every manufacturing panel regardless of layer count.
 - A coupon must be supplied from every manufacturing panel.
- D. All cartons, packing slips and C.O.C.'s must have part number, EC level or revision, quantity and P.O. number listed on them.

*Material received without the completion and proper execution of the Quality Requirement allows Plexus the right to return the material. For material that has been previously provided to Plexus, the requirements under subsequent shipments will be followed. When the revision of the part changes, **First Production Run requirements** must be completed as a new part*

*Notice: This document is considered “UNCONTROLLED” when it exists in any printed form. See the Partner - Supplier section of the Plexus Web page for the current master of this Q-code.



before the shipment of product to Plexus.

Product change notification

Upon acceptance of conforming product, documentation, and the requirements of this Q-code, the supplier's manufacturing process shall be considered "qualified". All changes require written approval from Plexus prior to implementation. Product or Process change notification requests (PCNs) shall be submitted to pcns@plexus.com.