



# Harley & Son Quality Requirements

## MACHINED PARTS

With 4-axis machining capability and turning centers, Harley & Son can tackle some of your toughest parts. Aluminum, titanium, brass, bronze, aircraft alloys, phenolic, delrin, stainless steel, and exotic alloys – these are not a problem for Harley & Son. After machining, the Company can anodize, plate, powder coat, or paint to customer specifications.

## CUSTOM MANUFACTURING

State-of-the-art feature-based CAM software allows Harley & Son to program the toughest parts directly from customer CAD models. Supported formats include STEP, SolidWorks, CATIA, Unigraphics, Autodesk Inventor and others.

## COMMITMENT TO QUALITY

Harley & Son is committed to supplying its customers with high-quality parts. Certifications to AS9100C and ISO 9001:2008 highlight the Company's commitment to maintaining the highest quality.

For more information on any of our products or services please visit us on the Web at:

[www.harleyandson.com](http://www.harleyandson.com)

**QR 1** The supplier shall maintain a Quality System in compliance with ISO 9001 and/or AS9100. Records established by the supplier that provides evidences of conformity to requirements shall be controlled and maintain at supplier facility and be available to Harley & Son for a minimum of 10 years.

**QR 2** The supplier shall maintain a RoHS compliance program. C of C is required with each shipment for each P/N purchased component noting component is RoHS compliant.

**QR 3** MSDS required with each shipment. (Raw Materials)

**QR 4** Harley & Son Inc. Source Inspection and/ or Customer Verification is required at supplier facility prior to shipment. Harley & Son will place an Inspection Stamp on the supplier shipper to indicate Harley & Son acceptance.\*\* Contact Harley & Son 48 hours prior to shipping.

**QR 5** Government Source Inspection is required at supplier facility prior to shipment. Supplier is responsible to contact Harley & Son and the Government Representative to arrange Government inspection for acceptance of part prior to shipment.

**QR 6** Supplier to provide a Final Test Report with each shipment. Harley & Son P.O. shall be referenced on the final test report.

**QR 7** The supplier shall perform and document a complete First Article Inspection Report (FAIR AS9102) including 100% of B/P or specification requirements. A copy of FAIR will accompany first shipment on the PO/contract AS9102.

**QR 8** The supplier shall implement and maintain a Key Characteristics (KC) control program acceptable to Harley & Son.

**QR 9** The supplier shall provide an Inspection Report (IR) identifying engineering requirements and actual. Use of supplier or Harley & Son Inc inspection form is acceptable. One copy of the IR shall be furnished to Harley & Son representing each manufacturing lot. AS9102 form.

**QR 10** The supplier shall perform 100% inspection of the Harley & Son Inc. noted characteristics, a record of the inspection results shall be provided to Harley & Son , sampling inspection is not allowed.

**QR 11** The supplier shall comply with Harley & Son Vendor Quality Requirements that apply see H&S 5000 (website)  
**QR 12** Where material is shipped to an off-site supplier, the supplier shall provide notification of producing nonconforming product to Harley & Son Quality Manager- ASAP. The supplier is also required to FAX/ e-mail a nonconforming inspection report to Harley & Son Quality Manager for review to determine if additional actions are required by the supplier. A Nonconforming product is defined as: a product and/or a process not meeting a customer quality requirement, product damaged or lost during the performance of a process.

**QR 13** Sub-tier supplier or Out side processor shall always certify to latest revision of applicable process requested on PO.

**QR 14** Right of access by H & S, their customer and regulatory authorities to the applicable areas of all facilities , at any level of the supply chain, involved in the order and to all applicable records.

**QR 15** The supplier shall be aware and compliant at all times if product has ITAR requirements.

**QR 16** Supplier shall notify H & S of changes in product and/or process changes of supplier, change of manufacturing facility location and where required, obtain organizational approval and flow down to the supply chain the applicable requirements including customer requirements.

**QR 17** Supplier shall certify all documents to latest revision



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