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	LTR	DESCRIPTION	DATE	APPROVED
	A	PRODUCTION RELEASE		
	B	EC-10940	08/29/14	Linda Kilgus
	C	EC-11202	12/02/14	Linda Kilgus
D	EC-11514	03/31/15	Linda Kilgus	



- H. A signed C-of-C shall accompany each purchase receipt and shall reference the purchase order number and if applicable, the Traveler Revisions (TR). All product identification information on the certificate of compliance must match information on the PO
- I. Component obsolescence or product changes notices received from manufacturers or distributors shall be forwarded to L3Harris T&RF.

7.0

PROCESS REQUIREMENTS

- A. Marker/flags must be removed from inductors prior to delivery of assembly.
- B. Staking of parts and/or components shall be performed at EMS Provider IAW the Assembly Drawing unless the Assembly Drawing specifically states that the task is to be performed after In-Process (IP) testing. If the Assembly Drawing states that staking is to be performed after IP test, then it shall be performed at L3Harris T&RF. All jumper wires shall be installed, routed, soldered, and staked in accordance with drawing and bill of materials requirements. Staking materials shall be in accordance with applicable bill of materials.
- C. PWB Cleaning: Cleaning methods shall be in accordance with J-STD-001, Sections 8.0 through 8.36. The process covers all boards being produced without Voltage Controlled Oscil
- D. Coil Craft Inductor Rework: If L3Harris part number 56100178-XXX needs to be reworked, use Hot Air pencil
- E. Hand Soldering of Capacitors: AL d must be installed either the Solder Paste method/Hot Air Pencil from IPC/7711/7721 or procedure 5.3.2 Point to Point method. The supplier shall check the parts list, and/or PCB silkscreen, and/or component datasheet to verify that a component is a capacitor. All c 0 0 18rW*n-7(l)5(l)5()-34(c)-5(0 0 1

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CHANGES OR DEVIATIONS

- A. Supplier shall not make any changes in design, materials or processes which may affect the acceptability (dimensional, visually, functionally, durability, etc.) of the items to be delivered to L3Harris T&RF without prior notification. For the purpose of this clause, a process is defined as any procedure, system or practice used during the manufacture or production of a deliverable item (i.e. soldering, cleaning, finishing, etc). L3Harris T&RF may require a re-qualification of the part depending on the nature of the change.
- B. Advance notification of a process change shall be communicated to L3Harris T&RF by submitting the Supplier Proposed Process Change Notification-Supplied Part Deviation Request Form FM110-F-0201.
- C. All changes to drawings, procedures and operating requirements of the items on the purchase order must be approved in writing by L3HarrisT&RF.
- D. Only L3Harris T&RF purchasing personnel have the authority to change the terms of a purchase order. No other L3Haris T&RF personnel have the authority to approve changes. All changes shall be communicated from the purchasing department and shall be confirmed in writing. A change is defined as any deviation from the purchase order quantity, price, delivery, documentation, terms and conditions, or the form, fit, or function of the item or service purchased. Any deviation from this requirement will be at the _____ result in a default of the purchase order at no cost to L3Harris T&RF.
- E. All deviations from build requirements and/or material availability shall require an approved Supplier Proposed Process Change Notification-Supplied Part Deviation Request Form FM110-F0201. This form is found at: <https://www.l3harris.com/all-capabilities/airborne-telemetry>. A copy of the approved form shall be submitted with each approved shipment. NOTE: Assembly Drawings and their respective notations will over rule any assembly conflicts with this document.

the traveler or equivalent supplier form.

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PRINTED WIRING BOARDS

- a. Printed Wiring Boards (PWBs) shall be processed in accordance with GD60059698

12.0

FOREIGN OBJECT CONTROL Supplier shall maintain a foreign object (FOD) control program with a documented and current plan assuring work is accomplished in a manner preventing foreign objects or materials from entering and remaining in deliverable items. The supplier shall identify a FOD control person responsible for implementing the FOD control program. Supplier shall provide FOD control program training to employees performing operations on L3Harris T&RF FOD sensitive products. Maintenance of the work area and control of tools, parts and material shall preclude the risk of FOD incidents. prior to closing inaccessible or obscured areas and compartments during assembly, The supplier shall inspect for foreign objects/mater

