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Quality Note HFE-NJ
HFEDCN0567 Rev A
June 9, 2021

ENGINEERING and PROCESS CHANGE MANAGEMENT

(Requiring Notification for Class II Changes)

REQUIREMENTS

1. Seller shall establish baselines:
 - 1.1. Engineering documentation (such as drawings including HFE International Technical Data Packages, and Seller sub-assembly level, Bill of Materials and specifications) and process documentation (such as work and test instructions) baselines shall be established and frozen as a result of part qualification or software Formal Qualification Test (FQT).
 - 1.2. For hardware that does not have requirements for environmental qualification, the completed First Article Inspection (FAI) shall form the baseline.
2. Class I Only- Once engineering and process baselines are established, Seller shall control changes to both the engineering and process baselines. Seller is not authorized to build hardware “at their risk” by incorporating proposed engineering and/or implementing process or tooling change(s) prior to receiving HFE International Buyer approval as defined in this document.
3. Class II changes do not require approval by the Buyer, but do require Buyer notification prior to implementation. Reference section 6.3.
4. This Q-Note does not apply to Commercial-Off-The-Shelf (COTS) component(s) within the item(s) on this purchase order, however, a change to a new COTS part number that is not included in the baseline TDP shall be considered a change. In the case of COTS components with HFE International modifications, the modifications are subject to the controls in this Q-Note.
5. Seller shall assign one of the following classifications for each proposed change:
 - a. Major/Minor Changes
 - Class I (Major)
 - Class II (Minor)
 - b. Class III Changes
 - 5.1. Class I (Major) Changes

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5.1.1. Class I (Major) Changes. The following definition of Class I change classification is modeled after EIA-649 Table 4, titled “Typical Major Change Criteria.” Class I (Major) Change Criteria:

- A change that affects specified and approved requirements for product attributes, including safety, reliability, and supportability.
- A change, after establishment of the baseline for the product design or implementation of the product design, that affects compatibility with interfacing products, including such products as test equipment, support equipment and associated software, programmable logic devices and/or firmware and products furnished by a customer or that affects one or more of the following:
 - Delivered operation or servicing instructions
 - Required calibration to the extent that product identification should be changed
 - Interchangeability or substitutability of replaceable products, assemblies, or components
 - Change to add a previously non-qualified supplier, where supplier selection is specified
 - User skills or user physical attributes; e.g., the proposed change requires the customer to impose a height or strength requirement to operate the product
 - Operator or maintenance training; e.g., the proposed change requires the customer to change how they train the Operator to use the product, or requires the customer to change how they maintain the product
 - Changes which requires retrofit of delivered products; e.g., by product recall, modification kit installation, attrition, replacement during maintenance using modified spares



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- Any change in the manufacturing process (routers, work instructions, procedures, etc.) that changes or alters the configuration, composition, or physical properties of the item produced
- Changes to material, including chemical or physical properties, from which the product is manufactured
- Adding any material to the deliverable item that is not called out in the manufacturing or engineering documentation
- Changes to Acceptance Test Procedure(s)
- Changing the functional capabilities and purpose of test equipment
- Any change to characteristics noted on the drawing or STAMP package on this purchase order
- Class I change in sub-tier supplier's process, tooling or engineering
- Changing the source of a material, sub-component or out-sourced operation

A change that does not impact the above criteria and would otherwise be classified as minor, but does result in an increase in cost/price to HFE International, including incentives and fees, guarantees, warranties, and contracted deliveries or milestones. Routine service or maintenance does not require submission of a change notice request.

5.2. Class II (Minor) Changes

5.2.1. Any change that is not a major change as defined above. Any Class II change will be determined to be Class I if it affects the form, fit, or function of the end item(s) specified on the Purchase Order. The following are examples of changes that are Class II Minor changes:

- Adding a new sub-tier supplier to produce a part
- Changing the location of the internal or external site where some or all of the work is being performed, including movement of the production line equipment
- Using different types of tools to produce the item on this purchase order (this does not include consumable tooling)

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- Changing to new or alternate production line machines or equipment
- Changing from one COTS part number to another COTS part number if the part number is not included as an allowable alternate to the baseline TDP
- Class II change in the sub-tier supplier's process, tooling, or engineering
- Changing the Sequence of an operation, method of an operation, adding or deleting an operation (minor only if applied to baseline changes)
- Changes in any machine programming (e.g.: CMM, NC machine, OI programming)
- Changes to qualified inspection techniques or equipment (as opposed to calibrated TE): reduction, change in technique, etc.
- Changing attributes of the test equipment that does not affect the functional capabilities and purpose of test equipment

5.3. Class III Changes

5.3.1. Class III changes apply to manufacturing-level documentation only and shall have no effect on processing sequence or process parameters. Class III changes are:

- Corrections to spelling
- Correcting typographical errors
- Adding or deleting non-directive (reference) photos
- Correcting grammatical errors
- Adding cautionary (personnel/hardware protection) notes
- Updating document format

6. Submitting the Change

6.1. Seller shall submit the required approval/notification documents to the HFE International Buyer and/or to sales@hfeinternational.com.

6.2. Seller to deliver the following data to HFE International for information as required by this document:

6.3. Class III changes require notification within one month after implementing change.

6.4. Seller is authorized to use/submit their own change notice request form, however, For Class I and II changes Seller shall specify whether the change is an engineering or a



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process change. If Seller has any questions about the class or subtype (process vs engineering) of change being submitted they should contact the Buyer for clarification prior to the submittal of the change request.

6.5. Requirements for the change submittal are as follows:

- **All Class I (Major) changes require HFE International Buyer approval prior to implementation.**
- **All Class II (Minor) changes shall be submitted prior to implementation.**
- All Class III changes require HFE International notification within one month after implementation.
- HFE International Purchase Order revision changes require notification prior to implementation.
- Class III changes shall contain at a minimum the following:
 - A brief statement/purpose of the identified change(s)
 - Part number
 - Document name or identifier; and
 - Before and after revision levels of affected documents listing the document page number and paragraph where the change was implemented

6.6. Seller shall submit each change separately to the HFE Buyer.

DATA SUBMISSION SUMMARY

- Seller to deliver the following data to HFE International for HFE International Approval/Notification:
 - All Engineering and Process changes as specified in this document.

NOTES

- Exceptions to this document are not allowed unless contractually authorized.
- After the establishment of the baseline, HFE International may conduct monitoring activities to verify Seller meets the configuration management requirements. These activities include but are not limited to conducting data reviews; conducting design



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review; conducting Production Readiness Review (PRR); performing configuration audits; performing a HFE International Product and Process Verification (PPV); performing a Hardware Acceptance Review (HAR) and/or Source Inspection.

- HFE International reserves the right to request any documentation associated with engineering or process change requests submitted for approval or notification.