

## Q252: Supplier Manufacturing Readiness Review (SMRR)

### Application:

You have received this Quality Clause as a result of the risk ranking of the product you are quoting or under contract for. The requirements of this Quality Clause must be planned for and complied with unless this is waived by either P.O. direction or other written approval provided by AR Quality and the responsible buyer for this hardware. **If you have not had a break in production or a performance issue in the previous two years, contact your Aerojet Rocketdyne buyer to request a written waiver of this quality clause prior to quoting or production.**

**NOTE: Based on performance – the SMRR may not be required.**

Seller shall prepare and submit documentation required to perform a Supplier Manufacturing Readiness Review (SMRR) for Buyer's approval. The SMRR shall be conducted prior to producing the First Article.

**Supplier Manufacturing Readiness Review (SMRR):** Determines the readiness of the manufacturer to proceed with manufacturing of the product.

The SMRR should represent a complete and comprehensive presentation of the entire planned production and/or assembly activity. The information prepared for the SMRR should represent the following (as applicable): Product description, business review, Quality and Engineering Notes review, released production drawings, design risk assessment, manufacturing readiness (planning, technique sheets, tooling, etc.), process capability validation, technical review, production verification testing, material certification, parts marking methods, packaging, preservation and labeling approvals, special process approvals, and nondestructive test, inspection, nonconforming product process, and documentation requirements.

The SMRR documentation will be submitted to Buyer's authorized purchasing representative and the review will be scheduled at the appropriate location. Approval by Buyer is required prior to production of the procured item(s). Buyer's approval of manufacturing plans shall not relieve Seller of Seller's requirement to comply with the terms of this contract.

Forms QMA-F-7.08.06.024 and QMA-F-7.08.06.025 will be used by Aerojet Rocketdyne (as applicable) to conduct and document the SMRR.

The following changes will require an update to the previously approved SMRR unless otherwise directed in writing by AR.

1. A change in the design characteristics affecting fit, form, or function of the part.
2. A change in manufacturing source(s), process(es), inspection method(s), location of manufacture, tooling, or materials that can potentially affect fit, form, or function.
3. A change in numerical control program or translation to another media that can potentially affect fit, form, or function.
4. A natural or man-made event, which may adversely affect the manufacturing process.
5. A lapse in production for two years. This lapse is from the completion of last production operation to the actual restart of production.



Effective Date: 2/26/2018

**Q252: Supplier Manufacturing Readiness Review (SMRR) (Continued)**

All changes to the approved SMRR plan shall be submitted to Buyer for review and/or approval prior to implementation, unless otherwise defined by Buyer engineering requirements.

All changes to the approved SMRR plan shall be submitted to Buyer for review and/or approval prior to implementation, unless otherwise defined by Buyer engineering requirements.

**Note:** Process Flow Diagram, Process failure Mode & Effects Analysis (PFMEA) and Control Plan are not invoked by this Quality Note.

This document is an integral part of the contract (purchase order) in which referenced.

**Applicable Revision:** The revision in effect at the time the purchase order is initially placed.