Quality Clause Q3R
Fit Check Processing

The latest issue of this document is the version on the Lockheed Martin website:
https://www.lockheedmartin.com/en-us/suppliers/business-area-procurement/aeronautics/quality-requirements/clauses.html

1. SCOPE

1.1 The Q3R clause establishes the requirements for processing a Fit Check Item (FCI).

2. DEFINITION AND TERM USAGE

2.1 The terms "Item", "PO", "Seller" and "Buyer", as used herein, have the same meaning as the terms "Work", "Contract", "Supplier" and "Lockheed Martin", respectively.

2.2 A Fit Check Item ("FCI") is an item from the first production build which is checked to Buyer's next assembly, aircraft and/or tooling, to validate Seller's compliance to LM Aero Build-to-Print requirements.

2.3 A Critical Load Item is the first item installed into buyer's assembly fixture, jig or aircraft.
Note: The absence or tardiness of a Critical Load Item will cause major workarounds, up to and including work stoppages for the Buyer.

3. APPLICABILITY

(Ref. Appendix A)

3.1 An item meeting either of the following criteria is considered an FCI:

3.1.1 Critical Load Item – Coordinate with Buyer-Assigned SQE to determine if a part qualifies.

3.1.2 Item that is formed using tooling and/or other forming methods and that cannot be validated to dimensions on the drawing during FAI.

3.2 Seller shall initiate a fit check only when the part meets any FCI requirement detailed in 3.1 AND either of the following are true:

3.2.1 The Seller is accomplishing a First Time Build (FTB)

3.2.2 An Engineering or Tooling change occurs that affects fit, form, or function (except omission of pilot or full-size holes)

3.3 Any item that is purchased on a Spares or Sustainment Purchase Order and not intended for LM Aero Production does not require a Fit Check.

4. GENERAL REQUIREMENTS

4.1 Seller shall identify FCI by attaching a single completed, non-permanent internal tag (found in Appendix B) to the FCI.

4.2 Seller shall identify, package and ship the completed FCI in accordance with the PO.

4.3 Seller shall identify packages on all sides (excluding the bottom) with the external placards (found in Appendix C). The small external placard shall be used only on package sides that cannot accommodate the large placard's size.

4.4 Seller shall provide a completed part/assembly per the PO requirements.

4.4.1 Seller's Delivery Rating will not be negatively impacted by an FCI.

4.4.2 Seller shall pause further part shipment until notified of an accepted FCI.

5. FIT CHECK RESULTS AND RECORD KEEPING

5.1 Buyer shall provide Seller with electronic notification of FCI acceptance.

5.1.1 A successfully completed FCI will remain on assembly at Buyer.

5.2 Buyer shall provide Seller with electronic notification of all FCI non-conformances.

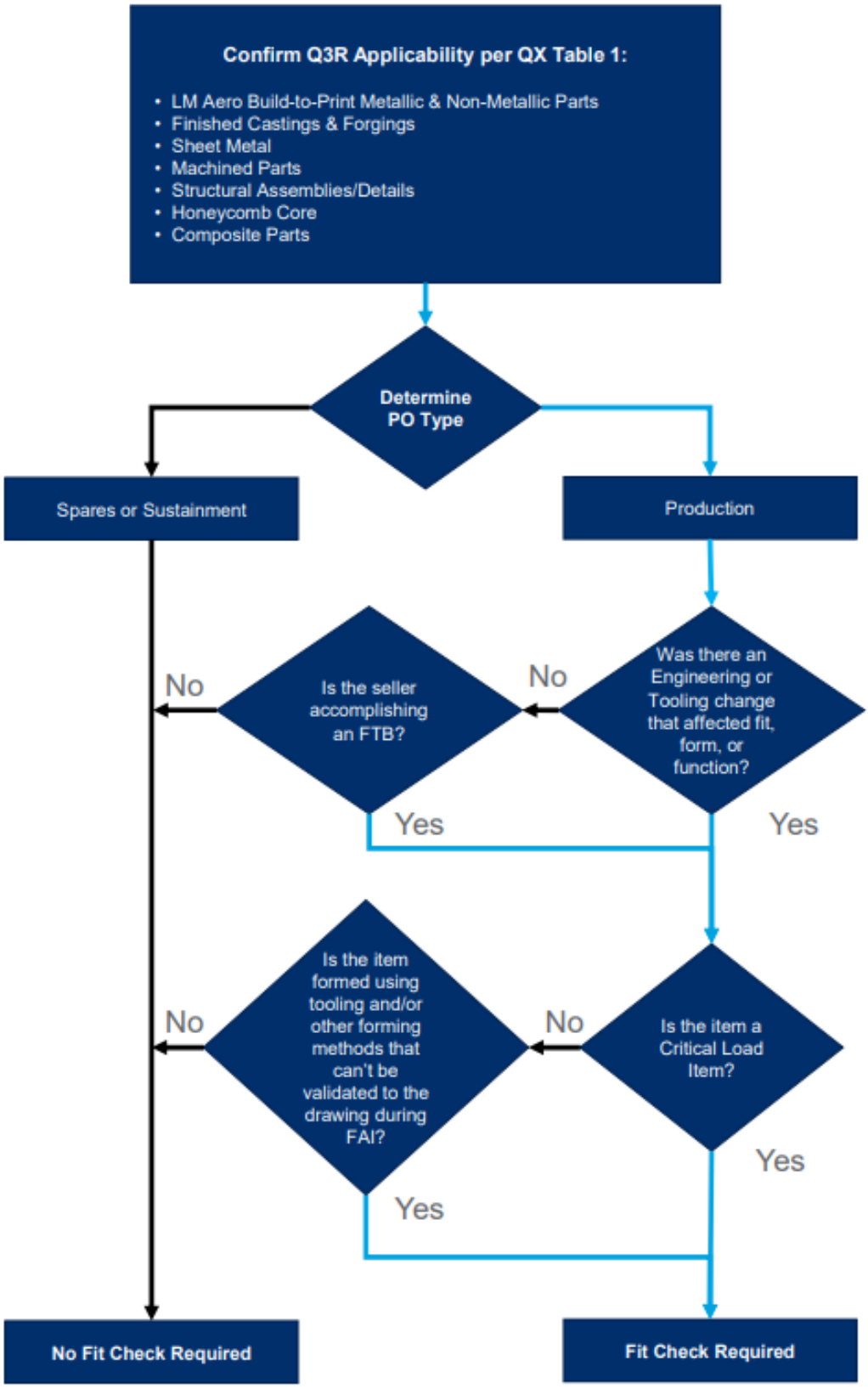
5.2.1 Seller's Quality Rating will not be negatively impacted by an FCI non-conformance.

5.2.2 Buyer will return a non-conforming FCI to the Seller for repair/rework.

5.3 Seller shall re-perform the requirements of Q3R for a failed FCI.

5.4 Seller shall retain and provide records of FCI activity in accordance with requirements of the PO.

APPENDIX A – Decision Flowchart



APPENDIX B – Internal Tag

Fit Check Item

NOTE: Parts on Spares/Sustainment POs do NOT require Fit Checks

Part Number	
Nomenclature	
Drawing Revision	
POIS Revision	
Supplier	
Supplier Number	
Purchase Order Number	
Purchase Order Line Item	
Quantity Shipped	
Date of Manufacture	
I&R (Y/N)	

Reason for Fit Check:

First Time Build ☐ Critical Load Item ☐

Tooling Change ☐ Engineering Change ☐

Detailed Comments (Tooling #, Features Affected, Notable Changes):

Fit Check Item

FCI Internal Tag (Ref 4.1)

All Destinations – FCI External Packaging Placard - Large

FIT CHECK ITEM

Box No. of

Part Number:

Nomenclature:

Supplier:

Purchase Order Number:

Purchase Order Line Item:

Internal LM Receiving Use:

Route to Quality/Production Control for Fit Check Processing

FIT CHECK ITEM

All Destinations – FCI External Packaging Placard - Small

FIT CHECK ITEM

Box No. of

Internal LM Receiving Use:

Route to Quality/Production Control

for Fit Check Processing