

Supplier Quality Manual
Version 18

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1 PURPOSE, APPLICABILITY, RELATED DOCUMENTS

1.1 Purpose

1.1.1 This document specifies the general quality requirements for Suppliers who provide materials and products directly to AXON for the manufacture of AXON product. The requirements specified in this document are intended to compliment the Supplier's own Quality Management System.

1.2 Applicability

1.2.1 This document and the requirements herein apply to all components, modules, and system level products regardless of whether they are meant to be built into a final assembly or to be shipped as spare or replacement parts.

1.2.2 For any AXON contract or purchase order that invokes a North Atlantic Treaty Organization (NATO) Standardization Agreement (STANAG) or NATO Allied Quality Assurance Publication (AQAP), including but not limited to AQAP 2310, AQAP 2131, AQAP 2021, AQAP 2105, ACMP 2100, or equivalent national defense standard or quality requirements, the Supplier shall comply with this SQM together with Appendix D: NATO Requirements. AXON will identify NATO STANAG/AQAP applicability in the purchase order or other contractual documentation. See Appendix D, Section 2.21.1.

For any AXON purchase order, contract, or product designation that identifies an item as safety critical, mission critical, defense related, NATO related, high risk, obsolete, obsolescence-prone, electronic, electrical, electromechanical, software-enabled, or otherwise subject to counterfeit avoidance controls, the Supplier shall comply with the counterfeit materiel prevention, traceability, sourcing, in section, reporting, records-retention, and flow-down requirements in this SQM, Appendix D, the applicable Supplier Agreement, the applicable Purchase Order, and any incorporated counterfeit-avoidance standard(s).

Any conflict between this SQM and the contractually invoked NATO requirements shall be promptly reported to AXON in writing for resolution. The contractually invoked NATO requirements shall take precedence unless ASON provides written direction otherwise. See Appendix D, Section 2.21.1. and 2.21.3.

1.2.3 In the event of a conflict between this document and the requirements set forth in contractual documents (e.g. Supplier Agreement, Purchase Order and its Terms and Conditions) or in a product specific document (e.g. engineering drawing/specification), the order of precedence shall be as follows: Contractual documents, Product specific documents, AXON Supplier Quality Manual.

1.3 Related Documents

All documentation (FAIR/PPAP, SIR, Root Cause, Correct Action) shall be submitted to Axon in English, unless an exception is granted by Axon Quality, prior to submission

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2 REQUIREMENTS

2.1 General Requirements

This revision of the AXON Supplier Quality Manual (SQM) supersedes and replaces all previous versions.

Compliance with this document is mandatory unless a specific requirement is formally waived or modified through AXON's approved Deviation process.

No exception or deviation from these requirements is permitted without prior written authorization from AXON.

Any requested exception to a requirement in this document shall:

- Be documented in the "Exceptions to SQM Requirements Compliance Acknowledgement" section.
- Include supporting rationale.
- Be formally reviewed and approved by AXON.

Suppliers shall provide written acknowledgement of compliance to this document within thirty (30) days of initial receipt by completing and signing the "Supplier Quality Manual Compliance Acknowledgement" form.

If exceptions are identified, Suppliers shall:

- Clearly document each exception.
- Provide corrective action plans with defined timelines.
- Obtain written acceptance from AXON.

As applicable, Suppliers shall flow down the relevant requirements of this SQM to their sub-tier suppliers, including AXON-directed suppliers.

Annual Supplier Compliance Questionnaire and Certification. At least annually Supplier shall complete AXON's supplier quality, counterfeit-avoidance, obsolescence management, and supply chain compliance questionnaire. Supplier shall certify the accuracy and completeness of its responses and shall provide supporting objective evidence upon request.

Failure to complete the questionnaire, failure to provide requested evidence, or submission of materially inaccurate information may result in supplier-quality escalation, withholding of new purchase orders, source inspection, audit, corrective action, suspension, disqualification, or other remedies available to AXON under the applicable Supplier Agreement or purchase order.

Supplier shall flow down all applicable AXON quality, counterfeit-avoidance, traceability, obsolescence management, right-of-access, records retention, configuration management, GQA, inspection, test, and reporting requirements to all applicable external providers and sub-tier suppliers. Supplier remains fully responsible for the performance, conformity, authenticity, and compliance of all externally provided processes, products, services, components, materials, software, firmware, and documentation, regardless of AXON approval, AXON-directed sourcing, source inspection, or sub-tier supplier selection.

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2.1.1 Right of Access

In accordance with the AXON Supplier Agreement, the Supplier shall provide AXON personnel reasonable access to production facilities, systems, processes, records, and associated sub-tier suppliers within forty-eight (48) hours of notification and mutual agreement.

Right of access includes, but is not limited to:

- Production processes
- Quality management systems
- Inspection and test records
- AXON-owned property
- Work-in-process and finished goods
- Sub-tier supplier operations supporting AXON product

Approval of product by AXON does not relieve the Supplier of full responsibility for product conformity.

Supplier's purchasing documents to external providers shall include all applicable contractual and AQAP flow-down requirements and the following statement: "All requirements of this contract may be subject to Government Quality Assurance (GQA). You will be notified of any GQA activity to be performed." See Appendix D, Section 2.21.7. Right of Access

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2.2 Management Systems

2.2.1 Quality Management System (QMS)

Supplier shall establish, implement, and maintain a documented Quality Management System (QMS) that is certified to a nationally or internationally recognized standard, such as, ISO9001, AS9100, IATF16949, ISO13485, or other AXON-approved equivalent

The Supplier's QMS shall ensure consistent compliance with AXON engineering specifications, Purchase Order requirements, Applicable regulatory requirements, and this Supplier Quality Manual (SQM)

For work performed under NATO contracts, the Supplier shall maintain and apply a Quality Management System compliant with AS9100 or a demonstrably equivalent standard accepted by AXON for the applicable scope of work. The Supplier shall designate a management representative with authority to report to top management and to liaise with AXON and, where applicable, the Acquirer/GQAR on quality matters affecting NATO work. See Appendix D, Section 2.21.2.

For NATO work, the Supplier's QMS and its application to the contract shall be subject to acceptance and surveillance by the GQAR, in addition to AXON oversight. On request, the Supplier shall provide access to QMS documentation, certification status, procedures, and records supporting continued compliance. See Appendix D, Section 2.21.2.

Certification shall be maintained in good standing. Suppliers shall notify AXON within five (5) business days of any change in certification status, including suspension, withdrawal, or scope modification.

AXON reserves the right to conduct risk-based supplier audits to verify compliance with this Supplier Quality Manual, contractual requirements, and applicable regulatory standards.

2.2.2 Information Security and Data Protection

Where Supplier has access to AXON confidential information, customer data, product data, or network-connected systems, Supplier shall implement appropriate information security controls to protect such data from unauthorized access, disclosure, alteration, or loss.

Supplier shall:

- Restrict access to AXON data to authorized personnel
- Maintain documented access control procedures
- Protect data from malware, unauthorized intrusion, or cyber threats
- Promptly notify AXON of any data breach or cybersecurity incident that may impact AXON products or information
- Comply with applicable data protection and privacy regulations

Upon request, Supplier shall provide summary documentation describing its information security controls.

2.2.3 Quality Objectives and Targets

Supplier shall establish measurable quality objectives related to AXON products and performance, including but not limited to:

- First Pass Yield (FPY),
- DPPM performance,
- On-time delivery,
- Corrective action responsiveness,
- Continuous improvement initiatives.

Quality objectives shall be monitored, reviewed periodically, and supported by documented improvement plans where targets are not achieved.

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2.2.4 Quality Tools and Risk Management

Supplier shall implement appropriate quality tools and risk management methodologies to ensure process control and product conformity.

These tools may include, but are not limited to:

- Design and Process Failure Mode and Effects Analysis (D/PFMEA)
- Control Plans
- Measurement System Analysis (MSA), including GR&R
- Statistical Process Control (SPC)
- Error-proofing (Poka-Yoke)
- Production Part Approval Process (PPAP)
- Corrective and Preventive Action systems
- Statistical analysis software (e.g., Minitab or equivalent)

PFMEA and Control Plans shall be reviewed periodically and updated when:

- Process changes occur
- Engineering changes are implemented
- Corrective actions are initiated
- Significant quality issues are identified

Annual PPAP submissions, where required by AXON, shall be incorporated into the Supplier's quality planning system.

For NATO work, the Supplier shall establish, maintain, and periodically review a contract-specific Risk Management Plan aligned with ISO 31000. The plan shall begin during AXON's contract review and address contractual, technical, schedule, quality, configuration, counterfeit, obsolescence, and external-provider risks, including risk ownership, mitigation, escalation, and records. The Risk Management Plan and current risk register shall be made available to AXON and the GQAR upon request. See Appendix D, Section 2.21.6.

2.3 Supplier Corrective / Preventive Action Process (SCAR)

Supplier shall establish and maintain a documented, closed-loop Corrective and Preventive Action (CAPA) system to:

- Investigate product and process discrepancies
- Identify verified root cause(s)
- Implement corrective and preventive actions
- Verify effectiveness of implemented actions
- Prevent recurrence

Corrective action methodology shall follow a structured problem-solving approach (e.g., 8D or equivalent).

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2.3.1 Response Time Requirements

Supplier response to an AXON-issued SCAR shall meet the following requirements:

- ≤ 24 hours: Acknowledge receipt of SCAR using Octave notification or AXON-designated communication method.
- ≤ 48 hours: Submit documented containment plan to prevent further shipment of nonconforming product.
- ≤ 10 business days: Submit complete Root Cause Analysis (RCA) and defined corrective/preventive action plan.
- ≤ 15 business days: Submit Corrective Action Plan with timeline for implementation.
- ≤ 90 business days: Implement corrective and preventive actions unless otherwise approved in writing by AXON Supplier Quality Engineering (SQE).

Requests for timeline extensions must be submitted in writing and approved by AXON SQE prior to expiration of the original due date.

2.3.2 Supporting Documentation

Supplier shall provide objective evidence supporting corrective action closure, including but not limited to:

- Completed 8D (or equivalent) report
- Updated PFMEA and Control Plan
- Revised work instructions or procedures
- Training records (if applicable)
- Test data or validation results
- Process capability data (where applicable)

Corrective action shall not be considered closed until effectiveness has been verified and accepted by AXON.

2.3.3 Escalation and Containment

If nonconforming product is shipped to AXON or its customers, Supplier shall:

- Immediately notify AXON
- Initiate containment of all suspect material (in-house, in transit, at sub-tier suppliers)
- Provide traceability details including:
    - Purchase Order number
    - Lot number
    - Serial number (if applicable)
    - Shipment number
    - Production dates

Supplier shall cooperate fully with containment, sorting, recall, or field corrective action efforts as required.

Failure to respond or repeated recurrence of similar issues may result in supplier escalation, increased inspection, cost recovery, or removal from Approved Vendor List (AVL).

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2.3.4 Supplier Performance Escalation

When performance issues persist, corrective actions are ineffective, or required response timelines are not met, AXON may initiate supplier performance escalation measures.

Escalation actions may include, but are not limited to:

Level 1 – Increased Oversight

- Increased inspection frequency
- Mandatory containment
- Formal performance review

Level 2 – Formal Corrective Action Review

- Executive-level review meeting
- Required corrective action plan with defined milestones
- Temporary new business hold (if applicable)

Level 3 – Probationary Status

- Supplier placed on conditional approval status
- Mandatory performance monitoring
- Risk-based audit

Level 4 – Disqualification

- Removal from Approved Vendor List (AVL)
- Termination of new business awards

2.4 Nonconforming Material

2.4.1 Control of Nonconforming Material

Supplier shall establish and maintain a documented process for the identification, segregation, evaluation, disposition, and control of nonconforming material.

The process shall clearly define:

- Responsibility for review and disposition
- Authority levels for approval
- Documentation requirements
- Re-verification requirements after rework

Nonconforming material shall be:

- Clearly identified and labeled
- Physically segregated from conforming material
- Securely controlled to prevent unintended use

Material dispositioned as scrap shall be permanently marked or physically rendered unusable prior to disposal.

Records of nonconformities and resulting actions shall be maintained in accordance with Section 2.6 (Records Retention).

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2.4.2 Any proposal to use nonconforming product as-is, repair, or otherwise release product under concession/deviation for delivery to AXON shall be formally documented and submitted to AXON for disposition. AXON shall not ship NATO product under concession unless written approval has been granted by AXON and, where contractually required, by the Acquirer/GQAR. See Appendix D, Section 2.22.10.

Suspect or Confirmed Counterfeit Materiel. Supplier shall treat suspected counterfeit, confirmed counterfeit, unverifiable, or authenticity-questioned materiel as nonconforming material. Supplier shall immediately identify, segregate, quarantine, and control such materiel to prevent use, shipment, commingling, or re-entry into the supply chain.

Supplier shall not return suspect or confirmed counterfeit materiel to the supplier, broker, independent distributor, or any other source except under AXON-approved controlled conditions solely for investigation, validation, law-enforcement support, or authorized disposition. Confirmed counterfeit materiel shall not be returned to the commercial supply chain.

Supplier shall notify AXON without delay of any suspected or confirmed counterfeit materiel associated with AXON product, AXON purchase orders, AXON tooling, AXON-supplied material, or any item intended for delivery to AXON. Notification shall include, to the extent known, affected part numbers, lot numbers, serial numbers, purchase orders, source of supply, quantity affected, containment actions, investigation status, test results, and proposed corrective actions. See Appendix D, Sections 2.22.10 and 2.22.12.

2.4.3 Nonconforming Material Discovered After Shipment

If nonconforming material is identified after shipment to AXON or AXON's customer, Supplier shall:

- Immediately notify AXON
- Initiate containment activities
- Provide traceability information
- Cooperate in determining impact

Supplier shall be responsible for all costs associated with nonconforming product determined to be the Supplier's responsibility, including but not limited to:

- Sorting
- Rework
- Repair
- Replacement
- Freight
- Field containment
- Administrative processing

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2.4.4 Supplier Response to Nonconforming Material Reports (NCMR) and RMA

Supplier shall respond to AXON-issued Nonconforming Material Reports (NCMRs) in accordance with the following Turnaround Time (TAT) requirements:

- ≤ 24 hours: Acknowledge receipt of the NCMR.
- ≤ 48 hours: Provide initial containment plan and disposition instruction.
- ≤ 5 business days: Provide RMA number (if return is required) or written authorization for scrap, rework, or alternate disposition.
- ≤ 10 business days: Arrange return shipment, replacement material, or credit issuance unless otherwise agreed in writing by AXON.

Failure to respond within the defined timelines may result in AXON dispositioning material at the Supplier's expense.

Supplier shall provide clear RMA instructions, including Carrier, Billing method, and Packaging requirements

Repeated failure to meet response timelines may result in escalation, chargeback, increased inspection, or AVL impact.

2.4.5 Product Rework

Supplier shall establish documented procedures for controlled rework activities, including:

- Detailed work instructions or rework process flow
- Updated Control Plan and PFMEA, where applicable
- Identification and marking of reworked product
- Inclusion of applicable Deviation, NCMR, or SCAR reference number on packaging

Reworked product shall undergo complete inspection and verification to ensure compliance with all applicable requirements.

Rework procedures and disposition authority shall be clearly defined.

Rework shall not be performed without prior AXON approval where required.

2.4.6 Service and Warranty Material

Returned service and warranty material shall be controlled in accordance with the same requirements as production nonconforming material.

Returned material shall:

- Not be mixed with new production
- Not be reintroduced into production without written AXON authorization
- Be processed only by trained and qualified personnel

All applicable controls including ESD protection, calibration, preventive maintenance, operator training, and documented procedures shall apply.

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2.5 Quality Performance Reporting

Supplier shall provide periodic performance reports to AXON, as defined by AXON Supplier Quality Engineering, demonstrating compliance with product, process, and management system requirements.

Reports shall be submitted in the format and frequency defined by AXON.

2.5.1 Performance Metrics

Performance reporting shall include, but is not limited to:

- First Pass Yield (FPY) performance
- Defective Parts Per Million (DPPM) performance
- Customer complaints and corrective action status
- CTQ capability (Cpk) summary and improvement plans
- Production volume
- On-time delivery performance (if requested)

Where performance targets are not achieved, Supplier shall provide:

- Pareto analysis of top issues
- Root cause analysis (if applicable)
- Defined corrective and preventive action plan
- Timeline for improvement

2.5.2 Continuous Improvement

Supplier shall demonstrate ongoing continuous improvement initiatives, which may include:

- Six Sigma projects
- Error-proofing (Poka-Yoke) implementation
- Process optimization initiatives
- Yield improvement projects
- Scrap reduction programs

Improvement initiatives shall be supported by measurable results.

2.5.3 Change Implementation Tracking

Supplier shall maintain and provide, upon request:

- ECO implementation tracking
- Deviation tracking
- Open corrective action status
- Supplier scorecard results and improvement plans
- Sub-tier supplier performance monitoring

Supplier shall proactively address identified performance gaps and provide documented improvement plans when requested by AXON.

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2.6 Records Retention

Supplier shall maintain production and quality records for a minimum of three (3) years beyond the life of the product, unless otherwise specified by contractual or regulatory requirements. Supplier shall retain objective evidence sufficient to demonstrate authenticity, conformity, traceability, and supply-chain control. Such records include, as applicable, OEM/OCM or authorized-distributor documentation, certificates of conformity, certificates of analysis, test reports, receiving-inspection records, authentication records, chain-of-custody records, lot/date-code records, serial-number records, distributor risk assessments, independent-distributor approvals, counterfeit-risk assessments, obsolescence assessments, training records, investigation files, quarantine records, and reporting records.

The retention period begins upon formal notification of product obsolescence by AXON.

Records shall be legible, readily retrievable, protected against loss, damage, or deterioration, and all records shall be maintained in a controlled environment (electronic or hard copy)

Electronic records shall be backed up and protected from unauthorized modification.

For NATO work, retention of applicable quality records shall be the longer of the contractual requirement, the applicable regulatory requirement, or the life of the product plus ten (10) years, unless otherwise directed to retain for a longer period. See Appendix D, Section 2.21.14.

2.6.1 Types of Records

The following records shall be maintained, at a minimum:

Procurement Records
- Purchase Orders
- Receiving documentation
- Supplier qualification and monitoring records
- Incoming Quality Control (IQC) inspection records
- Supplier corrective action records

Production Records
- Configuration and traceability records
- Training records
- Preventive maintenance records
- Rework and repair records
- AXON customer property logs

Quality Records
- Inspection data
- Test results
- Process control data (SPC)
- Calibration records
- Nonconforming material records
- Defect and yield data
- Customer complaint records
- Corrective action records

Returned Product Records such as Return Material Authorizations (RMA), Repair history, and Warranty investigation records

Supplier shall make applicable records available to AXON upon request within a reasonable timeframe. Disposal of records at the end of the retention period shall be performed in a manner that protects AXON proprietary and confidential information.

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2.7 Document Management Requirements

Supplier shall establish and maintain a documented document control system to ensure that only current and approved technical data is available at the point of use.

The document control system shall include controls for:

- Document approval prior to release
- Periodic review and update
- Revision identification and traceability
- Controlled distribution
- Prevention of unintended use of obsolete documents

Obsolete documents shall be promptly removed from points of use or clearly identified to prevent misuse.

For NATO work, the Supplier shall conduct and document a formal contract review prior to commencing work. The review shall identify all invoked STANAG/AQAP clauses, customer and statutory/regulatory requirements, special requirements, critical items, right-of-access provisions, and the need for contract-specific Quality Plan, Configuration Management Plan, Risk Management Plan, and anti-counterfeit/obsolescence controls. Any contradictions, ambiguities, or omissions shall be promptly escalated to AXON for resolution. See Appendix D, Sections 2.21.3 through 2.21.6.

2.7.1 Revision Control

Supplier shall be responsible for obtaining and using the correct revision level of technical data as specified on the AXON Purchase Order.

Manufacturing to an older revision than specified on the Purchase Order is prohibited unless:

- Authorized in writing by AXON
- Approved through an ECO or Deviation process

Supplier shall have a defined process to:

- Review engineering changes
- Assess impact to process, tooling, and documentation
- Implement approved revisions in a controlled manner

Upon implementation of engineering changes, Supplier shall notify AXON when required.

2.7.2 Document Control Audit

Supplier shall conduct periodic internal audits (minimum annually) to verify adequate control of:

- Drawings
- Specifications
- Datasets
- Software revisions (where applicable)
- Work instructions
- Engineering change implementation

Audit records shall be maintained and made available to AXON upon request.

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2.8 Engineering Data (Drawings, BOMs, Specifications, Software, and Data)

Supplier shall manufacture and supply product that conforms to all applicable AXON engineering data, including but not limited to, Bills of Material (BOM), 2D drawings, CAD models, Part Specifications, Software requirements (where applicable), other associated engineering documentation. Supplier shall not substitute, redesign, re-identify, re-mark, repackage, uprate, refurbish, repair, reclaim, alter, or use alternate parts, components, materials, software, firmware, or sources of supply without prior written AXON approval through the applicable change control or deviation process. Supplier shall assess any proposed alternate source, alternate part, last-time buy, life-extension strategy, or obsolescence mitigation for counterfeit risk, configuration impact, qualification impact, traceability impact, and contractual compliance before requesting AXON approval.

Supplier's internal engineering documentation shall not conflict with AXON product specifications.

2.8.1 Control of AXON Engineering Data

All AXON-supplied engineering data shall be properly controlled, protected from unauthorized modification, accessible only at the latest approved revision, and removed from use when obsolete.

Supplier shall ensure that only the revision specified on the AXON Purchase Order is used at the time manufacturing begins.

Use of an older revision than specified on the Purchase Order is prohibited unless formally authorized in writing by AXON through an approved ECO or Deviation.

2.8.2 Change Control and Approval

All change control requirements are governed by Section 2.9 Supplier Change Management. Supplier shall not implement changes without compliance with Section 2.9.

For NATO work, the Supplier shall establish and maintain configuration management controls consistent with ACMP 2100 and, where required by contract, a contract-specific Configuration Management Plan. The plan may form part of the Quality Plan and shall address configuration identification, baselines, change control, deviations/concessions, status accounting, and configuration verification/audits. See Appendix D, Section 2.21.5.

2.8.3 Incorporation of Revisions

When engineering changes are approved, Supplier shall:

- Implement changes in a controlled manner
- Verify process capability remains acceptable
- Update PFMEA, Control Plans, and work instructions as applicable
- Maintain traceability to revision implementation date

Supplier shall ensure no mixed-revision product is shipped unless explicitly authorized by AXON.

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2.8.4 Software and Firmware Security Controls

Where Supplier develops, modifies, programs, or manages software or firmware incorporated into AXON products, Supplier shall implement documented cybersecurity and configuration controls to protect product integrity and prevent unauthorized access or modification. At a minimum, Supplier shall:

- Maintain formal version control and configuration management for all software and firmware releases
- Restrict access to source code, programming tools, and build environments to authorized personnel only
- Implement access authentication and change authorization controls
- Protect software and firmware from unauthorized alteration, malware, or tampering
- Maintain secure backup and recovery of software source code and build artifacts
- Maintain traceability between released versions and validation records
- Notify AXON of any cybersecurity vulnerability that may affect delivered products

Changes to software or firmware shall comply with Section 2.9 Supplier Change Management.

2.8.5 Artificial Intelligence (AI) Use in Product or Process Control

Where Supplier utilizes artificial intelligence (AI), machine learning, or automated decision-making systems in product design, manufacturing processes, inspection, testing, or firmware/software development related to AXON products, Supplier shall:

- Validate AI-generated outputs prior to production release
- Maintain human oversight and approval of AI-driven decisions affecting product quality or compliance
- Ensure traceability of AI-generated configurations, test parameters, or design changes
- Comply with Section 2.9 Supplier Change Management for any AI-driven modifications

AI utilization shall not replace required validation, capability studies, or formal approval processes defined in this SQM.

2.9 Supplier Change Management

Supplier shall establish and maintain a documented Change Management process to control changes that may affect product quality, performance, compliance, or supply continuity.

The Change Management process shall apply to, but is not limited to, changes involving, Product design, Bill of Material (BOM), Materials or components, Sub-tier suppliers, Tooling (replacement, relocation, refurbishment, or modification), Manufacturing location, Manufacturing process methods, Inspection or test methods, Software or firmware, Production rate or capacity.

2.9.1 Approval Requirements

Supplier shall not implement any change affecting form, fit, or function, reliability or safety, regulatory compliance, manufacturability or scalability, or supply continuity without prior written approval from AXON. Supplier shall obtain AXON's prior written approval before implementing any change that may affect authenticity, traceability, configuration, qualification status, source of supply, authorized-distribution status, obsolescence status, inspection/test method, acceptance criteria, software/firmware configuration, or

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counterfeit-risk profile of any item supplied to AXON. All proposed changes shall be submitted through the Supplier Information Request (SIR) or Engineering Change Order (ECO) process, as applicable.

Each submission shall include:

- Description of the proposed change
- Risk assessment (including impact to CTQs, process capability, and regulatory requirements)
- Validation and verification plan
- Implementation timeline
- Containment plan (if applicable)

Change implementation shall not proceed until formal written approval is received from AXON.

Where required by contract, AXON will coordinate with the Acquirer/GQAR before approval of changes affecting NATO deliverables. See Appendix D, Sections 2.21.5, 2.21.8, and 2.21.11.

2.9.2 Change Classification

Supplier shall classify all proposed changes based on potential risk to product quality, performance, compliance, and supply continuity. Classification shall be documented in the SIR or ECO submission.

- Minor Change

  A change that does not affect form, fit, function, CTQs, safety, regulatory compliance, material composition, manufacturing location, or process capability. Notification through SIR is required. Validation requirements shall be determined by AXON.

- Major Change

  A change that may affect manufacturing processes, tooling, equipment, inspection methods, sub-tier suppliers, or production rate. Major Changes require documented risk assessment, defined validation plan, and written AXON approval prior to implementation.

- Critical Change

  A change that may affect form, fit, function, CTQs, reliability, safety, regulatory compliance, software/firmware behavior, or supply continuity. Critical Changes require formal SIR or ECO submission, comprehensive validation, and written AXON approval prior to implementation.

AXON reserves the right to reclassify any proposed change based on risk assessment.

2.9.3 Advance Notification

Supplier shall provide advance written notification to AXON for any proposed change that may impact Product performance, Cost, Delivery schedule, and Production capacity. Failure to provide advance notification may result in corrective action or supplier escalation.

2.9.4 Emergency Changes

In the event of an emergency change required to prevent production interruption, safety risk, or regulatory non-compliance. The change shall be documented and risk assessed, and AXON shall be notified within twenty-four (24) hours with formal SIR or ECO submission.

Emergency implementation does not waive the requirement for formal approval and validation.

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2.10 Material and Product Verification (Inspection & Test)

2.10.1 General Requirements

Supplier shall perform risk-based receiving inspection, verification, and authentication activities sufficient to detect nonconforming, suspect counterfeit, altered, damaged, expired, misrepresented, or untraceable materiel. The rigor of verification shall be commensurate with item criticality, source risk, obsolescence risk, supply-chain risk, prior quality history, and whether the item was obtained from an OEM/OCM, authorized distributor, or independent distributor.

For electronic, electrical, and electro-mechanical (EEE) items obtained from non-authorized or independent sources, Supplier shall apply risk-based inspection and test methods consistent with the applicable portions of IEC 62668-1, IEC 62668-2, AS5553, AS6081, AS6171, ARP6178, and ARP6328, as applicable to the item and sourcing risk. Supplier shall retain objective evidence of all inspections, tests, authentication activities, and resulting dispositions.

Supplier shall ensure that personnel responsible for inspection and test activities are appropriately trained, qualified for assigned tasks, and periodically retrained as required

Training records shall be maintained and made available upon request.

Supplier shall maintain records for all inspection and test activities in accordance with Section 2.6 (Records Retention).

All Supplier-developed Quality Control Plans (QCPs) shall:

- Be reviewed by AXON Quality
- Be approved through the FAIR/PPAP process
- Not be modified without prior AXON approval

2.10.2 Supplier Incoming Quality Control (IQC)

Supplier shall establish and implement incoming material verification processes to ensure compliance with all AXON documented requirements.

Incoming Quality Control Plans (IQCPs) shall define:

- Characteristics to be verified
- Measurement tools and techniques
- Sample size and frequency
- Acceptance and rejection criteria

At a minimum, IQCPs shall include verification of all CTQ / Capsuled / Inspection Dimensions specified on AXON drawings. Sampling plans shall be based on an industry-accepted standard (e.g., MIL-STD-1916 or equivalent). All inspection plans shall be based on C=0 methodology (reject lot on first failure), unless otherwise approved in writing by AXON.

2.10.3 Certificates of Analysis (CoA) / Certificates of Compliance (CoC)

Where required, a signed CoA or CoC shall accompany each production shipment or manufacturing lot. The certificate shall be signed by the Supplier’s authorized quality representative.

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2.10.4 In-Process Quality Control (IPQC)

Supplier shall establish process controls, inspection methods, and production testing sufficient to ensure compliance throughout manufacturing.

IPQC requirements shall be documented in a Quality Control Plan, including:

- Product characteristic or process parameter
- Specification or reference
- Measurement tool and technique
- Sample size and frequency
- Control method (e.g., First/Last Piece Check, SPC, Trend Chart, Poka-Yoke)
- Reaction plan

2.10.5 Final Quality Control (FQC) / Out-of-Box Audit (OBA)

Supplier shall verify that all assembly, inspection, testing, and packaging steps have been completed and meet AXON specifications prior to shipment.

FQC/OBA requirements shall be documented in the Quality Control Plan.

Approval of product by AXON does not relieve Supplier of full responsibility for product conformity.

2.10.6 Source Inspection (PSA)

AXON may perform source inspections (Pre-Shipment Audit – PSA) at Supplier or sub-tier facilities.

Source inspection may include verification of Product conformity, Process controls, Traceability systems, and Counterfeit material prevention measures. Supplier shall fully support and cooperate with all source inspection activities. Approval of product through PSA does not waive Supplier responsibility for full compliance.

2.10.7 Production Process Verification (First Article Inspection Report – FAIR / Production Part Approval Process – PPAP)

The purpose of FAIR/PPAP is to verify that the Supplier understands AXON engineering requirements, has processes capable of consistently producing conforming product, can produce at the quoted production rate

2.10.7.1 Pre-Production Build Requirements (SPF, EVT, DVT, PVT)

Supplier shall comply with the following validation requirements during pre-production builds unless otherwise defined in writing by AXON:

SPF (Supplier Process Feasibility) / Prototype Builds

- Complete FAIR required

EVT (Engineering Validation Test) Builds

- Complete FAIR required
- Cpk ≥ 1.33 required for all CTQs

DVT (Design Validation Test) Builds

- PPAP submission required

PVT (Production Validation Test) Builds

- Full PPAP approval required prior to shipment of production-intent material
- Interim approval or deviation required if full approval is pending

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These requirements apply to:

- New suppliers
- New parts
- Tooling changes
- Transfers of Work (TOW)
- Manufacturing location changes

Failure to meet validation requirements may result in shipment hold or rejection.

2.10.7.2 Resubmission Requirements

Notification to AXON and resubmission of FAIR/PPAP shall occur when:

- Design changes affect form, fit, or function
- Manufacturing location changes
- Tooling is replaced, modified, relocated, or refurbished
- Materials or processes change
- Corrective action requires validation
- Production lapse exceeds 12 months (subject to AXON review)

Annual FAIR/PPAP submission is required unless otherwise waived by AXON.

2.10.7.3 FAIR/PPAP Submission Requirements

FAIR/PPAP shall include:

- Verification of all specified product characteristics
- Process capability study for all CTQs
- Verification of other measurable engineering requirements

All three sections must be completed for each cavity, mold, or production stream.

2.10.7.4 Sample Size Requirements For FAIR/PPAP:

- Five (5) samples per requirement shall be verified
- For injection-molded parts with multi-cavity tools, five (5) parts per cavity shall be verified

2.10.7.5 Process Capability Requirements For CTQs:

- Minimum Cpk of 1.33 required
- Study must use statistically stable, in-control, normally distributed data
- Minimum 25 subgroups
- Subgroup size ≥ 5
- Minimum 32 total measurements
- Data collected over representative production run at quoted rate

AXON Engineering and Quality shall review and approve FAIR/PPAP submissions.

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2.10.7.6 Packaging Validation

Products sensitive to ESD, cosmetic, or mechanical damage shall be packaged appropriately.

Supplier shall submit packaging samples for approval and conduct testing on packaging to ensure part/product integrity prior to first shipment.

2.10.7.7 Regulatory Compliance

REACH and RoHS Certificates of Compliance shall be included with FAIR/PPAP submissions where applicable.

2.11 CPK Guidelines

Process capability performance shall be evaluated using Cpk values for CTQ characteristics.

The following guidelines apply:

Cpk < 0

- Majority of parts may be out of specification.
- Lot disposition shall be scrap or 100% screening.
- Tooling or process modification is required prior to continued production.

0 ≤ Cpk < 1.00

- Process is not capable.
- 100% inspection or AXON-approved deviation required.
- Tooling or process modification shall be evaluated, considering production urgency.

1.00 ≤ Cpk < 1.33

- Process is marginally capable.
- Increased inspection plan required.
- Continuous improvement actions shall be initiated to improve capability.

Cpk ≥ 1.33

- Process meets minimum capability requirement.
- Ongoing SPC monitoring required.

Cpk > 2.00

- Results shall be reviewed to confirm statistical validity and measurement accuracy.

Supplier shall not ship product from processes that do not meet minimum Cpk requirements, which is 1.33, without an approved Deviation.

2.12 Manufacturing Best Practices

Supplier shall implement manufacturing best practices to ensure consistent product quality, process stability, and scalability.

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2.12.1 Design for Manufacturability (DFM) / Design for Excellence (DFx)

Supplier shall actively participate in Design for Manufacturability (DFM) and Design for Excellence (DFx) activities throughout the product lifecycle.

DFM/DFx shall ensure that product designs are optimized for Manufacturability, Assembly efficiency, Scalability, Testability, Reliability, Cost effectiveness

2.12.1.1 NPI Stage Requirements

During New Product Introduction (NPI) stages including SPF, EVT, DVT, and PVT builds, Supplier shall:

- Review product design for manufacturability, assembly sequencing, and tolerance stack-up
- Evaluate automation readiness and test coverage
- Identify risks related to yield, tooling, fixtures, process capability, and capacity
- Provide documented DFM/DFx feedback to AXON prior to or during build planning
- Update PFMEA and Control Plans to reflect identified risks and mitigation actions
- Participate in formal design and build readiness reviews when requested

PVT builds shall utilize production-intent tooling, processes, inspection methods, and controls unless otherwise approved in writing by AXON.

2.12.1.2 Sustaining Engineering Changes (ECO)

For sustaining design changes, Supplier shall evaluate and document impact to:

- Form, fit, and function
- Tooling and fixtures
- Process capability (Cpk)
- Automation and test coverage
- Yield and reliability
- Production rate (Run@Rate capability)
- Sub-tier suppliers and materials

Supplier shall evaluate all sustaining engineering changes in accordance with Section 2.9 Supplier Change Management.

Updated PFMEA, Control Plans, and validation data shall be submitted when required.

2.12.2 Business Management Tools

Supplier should utilize appropriate business management systems (e.g., ERP, MRP, MES) to manage manufacturing operations effectively and maintain data accuracy.

2.12.3 Predictive and Preventive Maintenance

Supplier shall establish and maintain predictive and preventive maintenance programs for all production equipment and fixtures, including AXON-owned tooling.

Maintenance programs shall ensure that processes remain capable of meeting AXON requirements.

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2.12.4 Smart Automation for Assembly and Testing

Where feasible, Supplier should implement automation to:

- Reduce process variation
- Improve productivity
- Minimize operator-dependent errors

Smart automation may include use of sensors, vision systems, and automated error detection devices to prevent missing parts or incorrect assembly.

2.12.5 Test Process / Fixture Automation

Where feasible, Supplier should implement automated test and inspection equipment that:

- Captures parametric test data at the point of test
- Stores data in a retrievable format
- Provides objective pass/fail results
- Automatically segregates failed items

For PCBAs, failed units shall not proceed to the next manufacturing stage.

2.12.6 Testing Traceability

Where traceability is required, Supplier shall:

- Assign a unique identifier (e.g., serial number, barcode)
- Maintain test records traceable to each identifier

Traceability systems shall prevent unauthorized bypass of test failures.

2.12.7 Foreign Object Debris (FOD) Prevention

Supplier shall establish documented processes to prevent, detect, and remove Foreign Object Debris (FOD) from AXON products.

FOD control shall include housekeeping practices, inspection controls, and operator awareness training.

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2.13 Process Control

Supplier shall establish and maintain process controls to ensure fabrication and assembly processes consistently produce product meeting AXON requirements.

Process controls shall be documented in the applicable Quality Control Plan (QCP).

2.13.1 Statistical Process Control (SPC)

For characteristics designated as CTQ, Inspection Dimension, and/or Capsuled dimension, supplier shall demonstrate and maintain a minimum process capability index of Cpk ≥ 1.33 unless otherwise approved by AXON.

Continuous SPC monitoring shall be implemented during production at a frequency appropriate to process risk and capability performance.

When Cpk < 1.33, Supplier shall implement additional controls, which may include:

- Increased inspection frequency
- 100% screening
- Automated monitoring
- Error-proofing measures
- Process adjustment or tooling modification

Any shipment from processes not meeting minimum Cpk requirements shall require an approved Deviation.

2.13.2 Process Control Documentation

Supplier shall define and document process control methods, including Key process parameters, Control limits, Monitoring methods, Reaction plans, and Escalation criteria.

Reaction plans shall clearly define actions to be taken when a process is out of control, a specification limit is exceeded, and/or a trend indicates potential instability

2.13.3 Special Processes

Special processes (e.g., heat treating, brazing, soldering, plating, anodizing, chemical processing) shall:

- Be performed only by qualified and certified personnel
- Comply with applicable engineering specifications
- Maintain documented certification and training records

When special processes are performed by sub-tier suppliers, a Certificate of Compliance confirming adherence to drawing and specification requirements shall be provided.

2.13.4 Run at Rate (R@R)

When required, Supplier shall demonstrate Run at Rate capability, confirming that manufacturing processes can meet AXON quality requirements, sustain quoted production volumes, and maintain process stability at production rate

Run at Rate validation requirements shall be defined by AXON Supplier Quality Engineering.

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2.14 Control of Monitoring and Measuring Equipment

Supplier shall establish and maintain a documented process for the control, calibration, and verification of monitoring and measuring equipment used to verify AXON product requirements.

2.14.1 Calibration

Supplier is responsible for controlling and maintaining calibration of all monitoring and measuring equipment, including equipment owned by AXON but located at the Supplier's facility.

Calibration systems shall:

- Identify equipment uniquely
- Define calibration intervals
- Prevent use of out-of-calibration equipment
- Maintain calibration records

Calibration services (internal or external) shall comply with ANSI/NCSL Z540, ANSI/ISO/IEC 17025, or equivalent nationally recognized standard

If out-of-tolerance conditions are discovered that may affect delivered product, Supplier shall:

- Immediately assess product impact
- Notify AXON Quality Engineering in writing
- Implement containment as necessary

For NATO work, the Supplier's measurement management system shall be consistent with ISO 10012 and shall cover selection, metrological confirmation, calibration, verification, adjustment, use, and control of monitoring and measuring resources. Where out-of-tolerance conditions may have affected accepted or delivered product, the Supplier shall document the impact assessment by affected lot/serial and promptly notify AXON. See Appendix D, Section 2.21.9.

2.14.2 Measurement Capability

Supplier shall demonstrate that measurement, inspection, and test equipment are capable of producing accurate and repeatable results.

Measurement System Analysis (MSA) shall be performed as applicable, including Gage Repeatability and Reproducibility (GR&R), Bias studies, Linearity studies, and/or Stability over time

For CTQ measurements:

- GR&R results shall be ≤ 10% of tolerance or study variation unless otherwise approved by AXON
- Exceptions require documented review and approval by AXON Supplier Quality Engineering

MSA records shall be retained as part of FAIR/PPAP documentation where applicable.

2.14.3 Measurement Precision Requirement

Measurement, inspection, and test equipment shall have a minimum resolution of 10:1 relative to the tolerance being measured.

Example:
If tolerance = ±0.001 (total tolerance = 0.002), equipment resolution shall be at least 0.0002.

All measuring devices shall be verified to be within calibration prior to use in production.

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2.15 Identification and Traceability

Supplier shall establish and maintain a documented system to ensure proper identification and traceability of product throughout manufacturing and delivery.

2.15.1 Product Identification

Product shall be identified as defined by AXON drawings, specifications, or Purchase Order requirements.

Identification may include, as applicable: Part number, Revision level, Lot number, Date code, Serial number, and Manufacturing location.

Product identification shall be maintained throughout production to prevent mix-up or loss of traceability.

2.15.2 Serialization and Traceability

When serialization or traceability is required, Supplier shall maintain traceability records linking:

- Finished assemblies
- Subassemblies
- Individual components (where applicable)
- Test results
- Manufacturing process data

Traceability records shall enable identification of:

- Production date
- Manufacturing batch or lot
- Equipment or production line (if required)
- Applicable inspection and test records

Traceability data shall be retrievable within a reasonable timeframe upon AXON request.

For NATO work, and for safety critical, mission-critical, or otherwise designated critical items, the Supplier shall maintain full traceability from raw material and key sub-assemblies through manufacturing, inspection, test, storage, and shipment to the delivered lot or serial number. The Supplier shall also maintain a documented recall capability sufficient to identify and locate affected items within a timeframe agreed with AXON. See Appendix D, Section 2.21.11.

Supplier shall maintain traceability to the OEM/OCM, authorized distributor, or other AXON-approved source of supply. Traceability shall include, as applicable, manufacturer identity, manufacturer part number, lot number, date code, serial number, batch number, country of origin, chain of custody, certificate of conformity, certificate of analysis, and applicable test or inspection records.

Where full traceability to the OEM/OCM or authorized distributor is unavailable, Supplier shall treat the item as elevated counterfeit risk and shall not use or deliver the item to AXON unless AXON has provided prior written approval and Supplier has completed AXON-accepted risk-based authentication, inspection, test, and documentation controls.

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2.15.3 Injection Molded Part Identification

Unless otherwise specified, injection molded parts shall be identified with, Part number, Tool number, Cavity number, Revision level, Date wheel, and Material identification (where applicable)

This identification shall support traceability to specific tooling and production streams.

2.15.4 Segregation of Mixed Revisions

Supplier shall prevent mixing of product revisions unless explicitly authorized in writing by AXON.

When authorized, clear identification and segregation controls shall be implemented.

2.16 Handling, Storage, Preservation, and Shipping

Supplier shall establish and maintain documented processes to preserve product conformity during handling, storage, packaging, and shipment.

Processes shall prevent Mechanical damage, Cosmetic damage, Electrostatic discharge (ESD) damage, Moisture absorption, Contamination, and Deterioration due to environmental exposure.

2.16.1 Handling and Storage Controls

Supplier shall implement appropriate controls including, but not limited to Environmental controls, temperature and humidity where required), ESD protection measures, Clean handling practices, Protective packaging during internal transport, Segregation of nonconforming material.

Products sensitive to moisture, corrosion, or environmental exposure shall be stored in controlled environments or protected using approved methods (e.g., desiccants, moisture barrier bags).

2.16.2 Packaging Requirements

Packaging for customer delivery shall follow, AXON Bill of Material (BOM) requirements, AXON Packaging Standards (where defined), AXON Transportation Routing Directive.

Where packaging is not specified, Supplier shall apply best commercial practices to ensure product protection.

Products sensitive to ESD, cosmetics, or mechanical damage shall be packaged in a manner that prevents, Scratches, Dents, Cracks, Contamination, and Moisture ingress.

2.16.3 Shelf-Life and Age-Sensitive Materials

Supplier shall maintain documented controls for materials subject to shelf-life limitations.

For age-sensitive materials (e.g., O-rings, seals, gaskets), the Certificate of Compliance (CoC) or Certificate of Analysis (CoA) shall include Manufacturer name, Manufacturer address, Cure date, Batch number, Compound type.

Such materials shall have been manufactured within the previous eight (8) quarters unless otherwise approved. Adhesives, paints, sealants, and other materials requiring MSDS documentation shall:

- Have a minimum of seventy-five percent (75%) of shelf-life remaining at time of shipment
- Clearly display expiration date on the outer container

Materials that exceed defined shelf life shall be treated as nonconforming material.

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2.16.4 Moisture Control for Hygroscopic Materials

For hygroscopic injection molded parts and similar materials:

- Environmental conditions shall be controlled to prevent moisture absorption
- Desiccant packaging shall be used where required
- Desiccant shall not be removed from sealed packaging more than one (1) hour prior to use
- If temperature and humidity controls are not maintained, sealed packaging with desiccant shall be used during storage (typically 4–12 months as applicable to material type)

Supplier is responsible for preventing moisture-related defects such as cracking, deformation, or ultrasonic welding failures.

2.17 Customer Property

Customer property includes, but is not limited to, Product, Equipment, Tooling, Gages, Fixtures, Intellectual property, Documentation, and AXON-owned materials.

Customer property shall be clearly identified, protected, and controlled at all times.

Customer property shall not be Reworked, Modified, Transferred to another party, and Used for any purpose other than authorized AXON production without prior written approval from AXON.

2.17.1 Property Control and Tracking

Supplier shall maintain a documented Property List to monitor:

- Location
- Condition
- Usage status
- Maintenance history

Of all AXON-owned tooling, equipment, and materials in Supplier custody.

Records shall be made available to AXON upon request.

2.17.2 Loss, Damage, or Unsuitable Condition

If customer property is, Lost, Damaged, Worn, or Found unsuitable for use, supplier shall immediately notify AXON, document the condition, and cooperate in determining corrective action

For tooling affecting product specifications or cosmetic requirements, Supplier shall immediately notify AXON and coordinate repair, rework, or disposition activities with the responsible AXON Tooling Engineer.

Supplier shall not knowingly produce product using worn or damaged tooling.

Exceptions are permitted only through an approved Deviation or SIR process.

2.17.3 Customer-Owned Material Traceability

Supplier shall provide certification that AXON-owned materials were used in the manufacture of the product.

Traceability records shall include:

- Work order number
- Purchase Order number
- Lot or batch identification

Such information shall be included on the Supplier’s Certificate of Compliance.

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2.18 APPENDIX A – Electronic Assembly Suppliers

2.18.1 Electronic Assembly – General Requirements

Supplier shall ensure the following controls are implemented for Printed Circuit Board Assembly (PCBA) production:

- 100% Solder Paste Inspection (SPI) prior to component placement
- 100% Automated Optical Inspection (AOI) with 3D inspection capability after reflow
- 100% X-ray inspection for components with bottom terminations or hidden solder joints

2.18.2 Counterfeit Electronic Component Avoidance

Supplier shall establish, document, and maintain a counterfeit electronic component prevention and control program to ensure that only authentic and conforming components are used in AXON products.

The program shall include, at a minimum:

- Procurement of electronic components only from Original Component Manufacturers (OCMs), Original Equipment Manufacturers (OEMs), or authorized distributors
- Documented traceability to the original manufacturer
- Risk-based inspection and testing of components sourced from non-authorized suppliers
- Verification of marking, packaging, and labeling authenticity
- Segregation and control of suspect counterfeit material
- Immediate notification to AXON upon identification of suspect or confirmed counterfeit components
- Flow-down of counterfeit prevention requirements to sub-tier suppliers
- Maintenance of date code, lot code, and purchase documentation traceability

Use of independent distributors, brokers, gray-market sources, surplus sources, or other non-authorized sources requires prior written AXON approval and risk-based controls consistent with applicable industry standards, including AS5553, AS6081, AS6171, IEC 62668-1, IEC 62668-2, ARP6178, and ARP6328.

For designated safety-critical, mission-critical, electronic, electrical, electromechanical (EEE), or other obsolescence-prone items, the Supplier shall maintain an Obsolescence Management Plan consistent with EN/IEC 62402 and control obsolescence-driven changes through AXON change management and configuration management processes.

2.18.3 Electronic Assembly Handling

Supplier shall prevent contamination during PCBA manufacturing, including contamination from Flux residues, Body oils, Unauthorized hand creams or lotions, Deteriorated gloves or finger cots.

Supplier shall establish documented handling procedures consistent with IPC-A-610 guidelines, including Clean workstations (no food or drink), Minimized handling during processing, Prohibition of stacking assemblies, Use of protective racks or containers, No bare-hand contact with solderable or optical surfaces, Frequent glove/finger cot replacement, Prohibition of silicone-containing hand creams.

2.18.4 Moisture Control & IPC-1602 Compliance

Supplier and sub-tier suppliers shall store and handle printed circuit boards in accordance with IPC-1602 (current revision). Moisture-sensitive boards and devices shall be properly sealed and controlled to prevent moisture uptake and delamination, solder defects, or reliability issues.

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2.18.5 PCBA Depanelization

To prevent mechanical stress damage, Supplier shall use automated depanelization equipment or stress-reducing fixturing. Manual depanelization methods that induce board stress, and manual separation without stress mitigation is not permitted.

2.18.6 Lead Trimming – Through Hole Components

Lead trimming shall occur at the component level prior to installation and soldering. Post-solder trimming of through-hole leads is not permitted.

2.18.7 Electrostatic Discharge (ESD) Control

Supplier shall maintain compliance to ANSI/ESD S20.20 or equivalent.

The ESD program shall include:

- Periodic reviews and ESD audits
- ESD flooring and ionization systems
- Continuous monitoring of wrist straps
- Prohibition of wireless ESD wrist straps

2.18.8 Hand Soldering and Rework

Hand soldering shall be minimized. Rework or repair shall comply with IPC-7711 and IPC-7721 (latest revision). Any high-volume, high-risk or extensive rework activity requires AXON review and approval.

2.18.9 Vapor Cleaning Process

Applicable when specified on assembly drawings. Supplier personnel must be trained and approved by AXON. Assemblies must be free of process-related contaminants and cleaning shall follow AXON defined procedures.

2.18.10 AXON Approved Flux Removal Process

When imposed by drawing or PO:

- Only AXON-approved materials shall be used.
    - Current approved cleaning fluids:
        - 3M Novec 72DA Engineering Fluid
        - Techspray Precision-V 372DA Vapor-Degreaser Solvent Product# 372DA.
        - 3M™ Novec™ 73DE Engineered Fluid.
        - 3M™ Novec™ 72DE Engineered Fluid.
- Equivalent products require written AXON approval
- Cleaning shall remove all flux residues and contaminants
- IPA shall not be used unless specifically approved

Supplier shall support boards during cleaning to prevent mechanical damage.

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2.18.11 Test Point Solder Removal

When allowed by Purchase Order:

- Solder shall be fully removed from test point surfaces
- No raised solder or surface irregularities permitted
- Electrical clearance must be maintained
- Cleaning shall use approved no-clean agents (IPA prohibited unless approved)
- Visual inspection shall follow IPC-A-610
- Initial samples require AXON approval

This process shall only be used as a temporary recovery method while corrective actions are implemented.

2.18.12 PCB Cross Section Analysis

PCB Supplier shall perform cross-section analysis for all First Article Inspections and all subsequent PCB lots.

FAI documentation shall be included in PPAP and approval must be obtained prior to shipment.

Cross-section analysis shall include:

- Base material thickness for all layers
- Surface plating thickness
- Via plating thickness
- Dielectric spacing between layers (for HV/Controlled Impedance)
- Total PCB/FPCB thickness
- Material manufacturer and type
- Impedance measurements (where applicable)
- Electrical test verification
- Gerber compliance
- Current IPC revision compliance

2.18.13 PCBA-Specific FAIR/PPAP Requirements

PCBA FAIR/PPAP submissions shall include:

- RoHS and REACH compliance declaration for full assembly covering all components and parts in BOM.
- Counterfeit material prevention declaration (Tier 1 suppliers)
- Solder joint cross-sections (as defined with SDE)
- Dye and pry test for BGA components
- Strain gauge testing (≤ 500 microstrain unless otherwise approved)
- Mechanical interference analysis
- AOI/X-ray inspection coverage report
- Conformal coating thickness and adhesion validation
- Reflow oven and conformal coating curing oven profiles
- Functional tester logs
- Functional tester GR&R

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2.19 APPENDIX B – Molding Suppliers

2.19.1 Use of Regrind in Molded Parts

Regrind material shall only be used when explicitly permitted on the AXON part drawing.

If regrind usage is not specified on the drawing, regrind material is prohibited.

Supplier shall establish and maintain a documented process controlling:

- Regrind percentage
- Regrind traceability
- Mixing controls
- Verification of material properties

Use of regrind does not relieve the Supplier of responsibility to meet all specified mechanical and material performance requirements.

Supplier shall periodically evaluate mechanical properties to ensure that regrind use does not degrade:

- Strength
- Impact resistance
- Dimensional stability
- Material integrity

2.19.2 Hygroscopic Injection Molded Parts – Moisture Control

Supplier shall implement moisture control practices for hygroscopic molded materials.

Environmental controls shall address Temperature and Relative humidity.

Supplier shall consider environmental combinations (e.g., 55°C / 62% RH and 70°C / 50% RH) that may affect material properties.

Desiccant packaging shall not be opened more than one (1) hour prior to use, and be maintained in sealed packaging where temperature and humidity are not controlled

When environmental controls are not maintained, sealed bags with desiccant (e.g., silica gel) shall be used for storage periods typically ranging from 4 to 12 months, depending on material type and application.

Supplier is responsible for preventing moisture-related defects such as cracking, dimensional instability, or ultrasonic weld failures.

2.19.3 Mold Tooling Qualification

All injection molding tools used for AXON product shall be qualified through an AXON-approved FAIR/PPAP process prior to production release.

Tool qualification shall include Dimensional verification, CTQ capability validation, and Production-rate demonstration (if required)

Production shall not begin until formal approval is granted by AXON.

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2.20 APPENDIX C - Contract Manufacturer (CM) Quality Addendum

2.20.1 Purpose and Applicability

This Appendix establishes additional quality requirements applicable to Contract Manufacturers (CMs) responsible for the manufacture, assembly, integration, test, configuration, packaging, and/or shipment of complete or substantially complete AXON products.
Contract Manufacturers shall comply with all applicable requirements of this Supplier Quality Manual (SQM). The requirements in this Appendix are **supplemental** and address the additional responsibilities associated with finished-device manufacturing, system-level integration, firmware and configuration control, production readiness, direct-to-customer shipment, field support, and management of sub-tier suppliers.

Where requirements in this Appendix conflict with contractual documents, product-specific requirements, or other sections of this SQM, the order of precedence defined in Section 1.2 shall apply.
The CM remains responsible for finished-product conformity regardless of AXON inspection, audit, validation, approval, or directed sourcing.

2.20.2 Governance, Responsibility and Decision Authority

The CM is responsible for executing manufacturing operations using approved engineering documentation, validated processes, approved materials, qualified equipment, and controlled production systems.

CM responsibilities include, as applicable:

- Manufacturing process development and execution
- PFMEA and Manufacturing Control Plan development
- Process capability and production-rate validation
- Incoming, in-process, functional, and final testing
- Firmware loading and configuration control
- Serialization and traceability
- Regulatory labeling and packaging
- Management of applicable sub-tier suppliers
- Finished-product conformity and shipment release
- Failure analysis and corrective action support

AXON retains authority over product requirements, engineering changes, deviations, safety and regulatory acceptance, and authorization for mass-production release.

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2.20.3 AXON Decision Ownership

Unless otherwise defined in writing by the applicable program:

- **AXON Engineering** is responsible for approval of product design requirements, technical specifications, design validation, and design-related changes.
- **AXON Supplier Quality** is responsible for approval of manufacturing process readiness, PFMEA, Control Plans, FAIR/PPAP, process capability, manufacturing validation, and Run@Rate.
- **AXON Supply Chain / Operations** is responsible for confirming material availability, capacity, supply continuity, and production-volume readiness.
- **AXON Regulatory, Compliance, Product Safety, Information Security, or other functions** shall provide approval where applicable to product-specific requirements.
- The applicable **AXON Program / Operations leadership** shall make the final production **Go / No-Go decision** after required functional approvals are complete.

CM execution or completion of a build does not constitute AXON production-release authorization.

2.20.4 New Product Introduction and Production Readiness

The CM shall participate in AXON New Product Introduction (NPI) activities including EVT, DVT, and PVT, as applicable.

Each phase shall have defined objectives, validation requirements, identified risks, and documented acceptance criteria appropriate to product and process maturity.

2.20.4.1 EVT – Engineering Validation

During EVT, the CM shall support manufacturability and early-process validation, including:

- DFM/DFx review
- Identification of assembly, tooling, test, capacity, and quality risks
- Preliminary PFMEA and Control Plan development
- Test-method and fixture development
- Identification of CTQs and special process controls
- FAIR and process capability activities as required by Section 2.10

Open risks shall be documented with owners and mitigation plans.

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2.20.4.2 DVT – Design and Manufacturing Validation

During DVT, the CM shall demonstrate increased manufacturing maturity and validate production-intent processes where practical.

DVT readiness shall include, as applicable:

- Updated PFMEA and Control Plans
- Production-intent tooling and fixtures
- Measurement and test system validation
- Process capability results
- Manufacturing work instructions
- Test coverage validation
- Firmware/configuration controls
- Traceability-system validation
- PPAP submission as required by Section 2.10

Significant manufacturing risks shall have defined mitigation or containment prior to progression to PVT.

2.20.4.3 PVT – Production Validation and Production Readiness

PVT shall serve as the primary manufacturing readiness gate for mass production.

PVT shall use production-intent materials, tooling, equipment, processes, software/firmware, test systems, operators, inspection methods, packaging, and production controls unless otherwise approved in writing by AXON.

PVT shall incorporate, as applicable:

- Full PPAP validation
- Production-line qualification
- PFMEA and Control Plan verification
- Test-system and fixture validation
- Firmware and configuration verification
- Traceability and serialization verification
- Packaging and labeling validation
- Operator and inspector qualification
- Production-volume and capacity validation
- Run@Rate
- Review of open quality, engineering, supply, regulatory, and manufacturing risks

Run@Rate is therefore considered part of the PVT/production-readiness evaluation rather than a separate production-release gate unless AXON specifically requires a separate Run@Rate event.

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2.20.4.4 Production Release

Completion of PVT does not automatically authorize mass production.

Following PVT, AXON shall conduct a documented **Production Readiness Review (PRR)** or equivalent Go/No-Go review to confirm that required exit criteria have been satisfied.

PRR is the **decision review**, not an additional validation build.

Mass production shall not begin until AXON provides documented production-release authorization.

2.20.5 Production Readiness Acceptance Criteria

Unless otherwise agreed in writing by AXON, production readiness shall be demonstrated using measurable acceptance criteria.

At a minimum:

- All applicable FAIR/PPAP requirements shall be completed or formally dispositioned.
- CTQ process capability shall meet **Cpk ≥ 1.33**.
- Required MSA / GR&R shall meet SQM requirements.
- Production shall demonstrate ability to achieve the approved production rate during Run@Rate.
- FPY, final yield, defect performance, and test-failure rates shall meet program targets approved by AXON prior to PVT.
- No unresolved safety-critical or regulatory nonconformances shall remain open.
- Critical manufacturing risks shall be mitigated or have AXON-approved containment.
- Required functional and safety testing shall demonstrate product conformity.
- Firmware, configuration, serialization, and traceability controls shall be validated.
- Required tooling, equipment, operators, materials, and sub-tier suppliers shall demonstrate readiness.

Program-specific targets for **FPY, DPPM, throughput, capacity, test yield, and other manufacturing metrics** shall be documented before PVT. Where product maturity, volume, or manufacturing characteristics make a standard threshold inappropriate, AXON may approve alternate acceptance criteria in writing.

Failure to meet an acceptance criterion shall result in corrective action, additional validation, containment, deviation, or a No-Go decision as determined by AXON.

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2.20.6 PFMEA, Control Plan, and Risk Integration

The CM shall develop and maintain a PFMEA addressing manufacturing, assembly, test, firmware loading, inspection, labeling, packaging, and other applicable production processes.

The PFMEA shall be treated as a living risk-management document and shall be updated when:

- New manufacturing risks are identified
- Product or process changes occur
- Failures occur during NPI or production
- SCAR or corrective actions are initiated
- Field failures identify manufacturing-related risks
- New sub-tier, tooling, equipment, or manufacturing methods are introduced

PFMEA outputs shall be directly linked to the Manufacturing Control Plan.

High-risk failure modes, CTQs, safety-related characteristics, and critical process parameters identified through PFMEA shall have appropriate preventive or detective controls in the Control Plan, including:

- Control method
- Inspection or test method
- Sample size or frequency
- Acceptance criteria
- Data-recording requirements
- Reaction plan
- Escalation criteria

Reaction plans shall clearly define actions to be taken when a process becomes unstable, specifications are exceeded, capability falls below requirements, or a critical control cannot be performed.

AXON may require evidence showing traceability between PFMEA risks, Control Plan controls, validation activities, and production testing.

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2.20.7 Design Responsibility and JDM Requirements

Where the CM or a Joint Design Manufacturer (JDM) has responsibility for product, subsystem, hardware, software, firmware, or mechanical design, the CM/JDM shall implement design risk management appropriate to its design responsibility.

The CM/JDM shall develop and maintain a **Design Failure Mode and Effects Analysis (DFMEA)**, or AXON-approved equivalent, for the applicable design scope.

DFMEA shall:

- Identify potential design failure modes and effects
- Address safety, reliability, performance, regulatory, and manufacturability risks
- Identify design-related CTQs and critical characteristics
- Define required risk-reduction actions and validation
- Be reviewed and updated as the design evolves

Relevant DFMEA outputs shall flow into:

DFMEA → PFMEA → Control Plan → Validation / Test → Production Monitoring

Design risks requiring manufacturing controls shall therefore be reflected in the PFMEA and Control Plan.

AXON approval of CM/JDM design activities does not relieve the CM/JDM of responsibility for the design scope assigned contractually.

2.20.8 Production Controls and Manufacturing Execution

The CM shall establish documented production controls sufficient to ensure finished AXON devices are manufactured in a controlled, repeatable, and validated manner.

Manufacturing processes shall emphasize **prevention and early detection** rather than reliance on final inspection.

Production shall be performed using:

- Approved engineering documentation
- Approved BOM and materials
- Approved PFMEA and Control Plans
- Approved work instructions
- Approved firmware/software configurations
- Validated inspection and test methods
- Approved packaging and labeling requirements

Processes affecting product safety, CTQs, firmware integrity, regulatory compliance, or critical product functionality shall receive enhanced controls appropriate to risk.

The CM shall immediately initiate containment and notify AXON when significant process instability is identified.

Production shall be stopped when necessary to prevent shipment of nonconforming or potentially unsafe products.

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2.20.9 Finished Device Test and Validation

Unless otherwise specified by AXON, finished devices shall undergo **100% functional test** prior to shipment.

Testing shall verify applicable product functionality, performance, configuration, and safety-related functions in accordance with approved AXON requirements.

Test processes and equipment shall be validated before production use and shall include:

- Defined acceptance criteria
- Repeatable and reproducible results
- Appropriate MSA / GR&R where applicable
- Controlled test-software revision
- Prevention of unauthorized test bypass
- Segregation of failed units
- Traceability of test result to device serial number

Automated data capture shall be implemented where feasible.

Test records should include, as applicable:

- Device serial number
- Firmware/software revision
- Test-station identification
- Test result and applicable parametric data
- Date/time of test
- Rework or retest history

Changes to test software, test limits, fixtures, methods, or acceptance criteria shall comply with Section 2.9 Supplier Change Management.

2.20.10 Firmware, Software, and Configuration Control

Where the CM loads, programs, configures, or tests firmware or software incorporated into an AXON product, firmware/software loading shall be treated as a controlled manufacturing process.

The CM shall ensure:

- Only AXON-approved revisions are used
- Firmware/software is maintained in controlled repositories
- Access is restricted to authorized personnel
- Programming systems verify correct revision and successful loading
- Unauthorized modification is prevented
- Firmware/software revision is linked to device serial number where applicable
- Programming and test systems are validated and revision controlled

Mixed firmware or configuration revisions shall not be shipped unless explicitly authorized by AXON.

Cybersecurity incidents that may affect product configuration, firmware integrity, manufacturing systems, or traceability shall be reported to AXON immediately.

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2.20.11 Device Serialization and Traceability

Finished devices shall maintain traceability sufficient to support containment, investigation, warranty analysis, and recall.

Where serialization is required, traceability shall link the finished-device serial number to applicable:

- Product revision/configuration
- Firmware/software revision
- Manufacturing date and location
- Production line or station
- Test and inspection results
- Rework or repair history
- Production lot
- Critical subassemblies or components as required

Traceability systems shall prevent duplicate or omitted serial numbers and unauthorized alteration of production records.

For direct-to-customer shipments, shipment and customer/destination traceability shall be maintained as required by AXON.

2.20.12 Direct-to-Customer Shipment

Where AXON authorizes the CM to ship finished products directly to customers, the CM assumes additional responsibility for final verification and shipment conformity.

Prior to shipment, the CM shall verify, as applicable:

- Correct product and configuration
- Correct firmware/software revision
- Successful completion of required inspection and testing
- Correct regulatory and regional labeling
- Correct serialization
- Packaging integrity
- Required shipment documentation
- Destination/customer requirements

AXON may suspend or revoke direct-shipment authorization when product quality, traceability, regulatory, configuration, or other compliance risks are identified.

Where finished devices are shipped to AXON prior to customer distribution, the CM shall provide sufficient test, configuration, and traceability records to support AXON receiving verification.

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2.20.13 Regulatory and Certification Control

AXON retains responsibility for product-level regulatory certification unless otherwise contractually assigned. The CM is responsible for ensuring manufacturing activities do not invalidate or compromise applicable certifications.

The CM shall ensure:

- Only approved materials and components are used
- Approved product configurations are maintained
- Regulatory labels and markings are correctly applied
- Manufacturing changes that may affect certification are not implemented without AXON approval
- Applicable environmental requirements such as RoHS and REACH are maintained

Any manufacturing issue that may affect product safety, regulatory compliance, or certification status shall be immediately reported to AXON.

2.20.14 Sub-Tier Supplier Management

The CM is responsible for the quality and performance of sub-tier suppliers supporting AXON finished products, including AXON-directed suppliers where applicable.

The CM shall:

- Flow down applicable AXON requirements
- Monitor sub-tier quality and delivery performance
- Manage corrective actions
- Identify critical or single-source dependencies
- Maintain appropriate supply-risk and contingency plans
- Ensure sub-tier changes comply with Section 2.9 Supplier Change Management
- Notify AXON of significant sub-tier risks that may affect product quality, safety, regulatory compliance, or supply continuity

AXON approval or direction of a sub-tier supplier does not relieve the CM of responsibility for finished-device conformity.

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2.20.15 Field Failure, RMA, and Recall Support

The CM shall support AXON in the investigation and resolution of manufacturing-related field failures, warranty returns, and potential recalls.

When a manufacturing-related issue is identified that may affect shipped product, the CM shall promptly:

- Notify AXON
- Contain affected production and inventory
- Identify potentially affected serial numbers or lots
- Provide applicable production, test, firmware, and traceability records
- Support failure analysis and root cause investigation
- Implement corrective actions in accordance with Section 2.3

For returned product assigned to the CM for analysis or repair, the CM shall maintain controlled processes ensuring returned material is segregated from new production and all repair/rework history is traceable to the applicable device.

Where recall or field containment is required, the CM shall provide traceability and technical support necessary to rapidly identify affected devices.

2.20.16 Business Continuity and Supply Risk

The CM shall maintain a documented Business Continuity Plan appropriate to the products and manufacturing operations supporting AXON.

The plan shall address applicable risks including:

- Facility or utility disruption
- Critical equipment failure
- Cybersecurity incident
- Labor interruption
- Transportation or logistics interruption
- Sub-tier supplier disruption
- Critical material shortages
- Loss of manufacturing or traceability data

The CM shall establish recovery strategies and shall periodically review the effectiveness of its continuity plans.

AXON shall be promptly notified when a disruption may materially affect quality, production capacity, or product delivery.

Following significant disruption, validated production processes shall be confirmed prior to shipment restart.

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2.20.17 Performance Monitoring and Escalation

In addition to Section 2.5 requirements, CMs shall monitor finished-device manufacturing performance using appropriate metrics including:

- First Pass Yield (FPY)
- Final Yield
- DPPM / defect rate
- Test failure rate
- Rework and repair rate
- CTQ capability
- Production volume
- Throughput / capacity
- On-time delivery
- Field or warranty failure trends
- Sub-tier supplier performance

Performance targets shall be established with AXON based on product maturity, criticality, volume, and manufacturing risk.

Negative trends, repeated failure to meet agreed targets, or deterioration affecting product safety, quality, delivery, or supply continuity shall trigger documented investigation and corrective action.

AXON may increase oversight, inspection, audit frequency, containment requirements, or escalation status based on risk and performance.

2.20.18 Rework and Repair

Rework and repair shall be performed only under documented and controlled procedures.

For safety-critical or otherwise AXON-designated products:

- Applicable rework procedures shall be reviewed or approved by AXON as required
- Reworked devices shall undergo required functional verification
- Rework history shall be traceable to the device
- Repeated or high-frequency rework shall trigger root cause investigation

Rework shall not be used as a substitute for correcting an unstable or incapable manufacturing process.

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2.20.19 Change Management

All Contract Manufacturers shall comply with **Section 2.9 – Supplier Change Management**.

CMs shall not independently implement changes to product design, materials, components, firmware, software, tooling, equipment, manufacturing location, processes, inspection/test methods, line configuration, capacity, or sub-tier sources where the change meets the notification or approval requirements of Section 2.9.

The CM is responsible for ensuring applicable sub-tier supplier changes are identified and submitted to AXON through the required SIR/ECO process before implementation.

Where an approved CM change affects validated manufacturing processes, AXON may require partial or full requalification, updated PPAP, PVT validation, or repeat Run@Rate based on risk.

2.20.20 Records and Data Integrity

CMs shall comply with Section 2.6 Records Retention and maintain records sufficient to demonstrate manufacturing and finished-product conformity.

Records shall include, as applicable:

- PFMEA and Control Plans
- NPI and production-readiness approvals
- FAIR/PPAP records
- Run@Rate results
- Inspection and test data
- Firmware and configuration records
- Device traceability
- Training and qualification records
- Rework and repair history
- Regulatory and labeling verification
- Sub-tier supplier records
- Change approvals and implementation records
- Field failure and RMA investigation records

Electronic manufacturing records shall be protected from unauthorized modification, backed up as appropriate, and maintain sufficient audit trail to support investigations and traceability.

2.20.21 Exceptions

Any exception to the requirements of this Appendix shall follow the exception/deviation process defined in this Supplier Quality Manual.

Unless otherwise approved in writing by AXON, Contract Manufacturers are expected to comply with both the general requirements of this SQM and the additional requirements defined in Section 2.24.

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2.21 APPENDIX D – NATO Quality Requirements

Appendix D applies only to work performed under AXON contracts or purchase orders that expressly invoke NATO STANAG and/or AQAP requirements or equivalent national defense quality requirements. The provisions below supplement the cited SQM sections and are intended to be read together with them.

2.21.1 Applicability, Scope, and Order of Precedence (AQAP 2310 §4.3, §5.1.2; AQAP 2131 §1.3)

The Supplier shall comply with this SQM, the applicable purchase order or contract, and the contractually invoked STANAG/AQAP publications. AXON shall identify STANAG/AQAP applicability in the contractual documentation. When a conflict exists between this SQM and the invoked STANAG/AQAP requirements, the Supplier shall promptly notify AXON for resolution and the contractually invoked requirement(s) shall take precedence unless AXON provides written direction otherwise.

Incorporated Counterfeit Avoidance and Obsolescence Standards. Where NATO STANAG/AQAP requirements, the purchase order, the Supplier Agreement, or AXON's written direction invokes counterfeit avoidance or obsolescence-management obligations, Supplier shall establish controls consistent with the following standards, as applicable to the items supplied and the risks presented: ISO 22380, EN/IEC 62402, IEC 62668-1, IEC 62668-2, SAE AS5553, SAE AS6081, SAE AS6171, SAE ARP6178, and SAE ARP6328. These standards shall be used to define risk-based controls for authenticity, traceability, authorized sourcing, independent distributor risk assessment, inspection, authentication, test, suspect counterfeit control, reporting, obsolescence management, and supply-chain flowdowns.

Unless otherwise stated in the purchase order or contract, the Supplier shall apply these standards in a risk-based manner, taking into account item criticality, safety impact, mission impact, obsolescence status, source of supply, supply-chain complexity, prior quality history, and availability of OEM/OCM traceability.

2.21.2 Quality Management System, Documented Information, and NATO Quality Representative (AQAP 2310 §4.1-4.3; §5.1.1)

The Supplier shall maintain and apply a QMS compliant with AS9100 or a demonstrably equivalent standard accepted by AXON for the applicable scope of NATO work. The Supplier shall maintain documented procedures, records, and controls needed to satisfy the NATO contract and the invoked quality requirements. The Supplier shall designate a management representative or equivalent quality authority who reports to top management, is competent in quality management, and is authorized to liaise with AXON and, where applicable, the Acquirer/GQAR regarding NATO quality matters. The Supplier's QMS and its application to the contract shall be subject to acceptance and surveillance by the Acquirer and/or GQAR, in addition to AXON oversight.

2.21.3 Contract Review and Identification of Invoked Requirements (AQAP 2310 §5.1.1-§5.1.2)

Upon NATO contract award, AXON will notify the Supplier and document a formal contract review that identifies: 1) all customer, statutory, regulatory, technical, and invoked NATO STANAG/AQAP quality requirements; 2) the Supplier's capability and capacity to satisfy those requirements; 3) contradictions, ambiguities, or omissions requiring AXON clarification; 4) critical items, key characteristics, special processes, and right-of-access obligations; and 5) the need for a contract-specific Quality Plan, Configuration Management Plan, Risk Management Plan, Anti-Counterfeit Management Plan, and Obsolescence Management Plan. The Supplier shall retain objective evidence of this review.

The contract review shall also identify whether any item is electronic, electrical, electro-mechanical, software-enabled, safety-critical, mission-critical, obsolete, obsolescence-prone, sourced from a non-authorized channel, or otherwise subject to elevated counterfeit risk. Supplier shall document the resulting counterfeit-risk classification and identify any required deliverables, authentication testing, AXON approval, or sub-tier flowdowns before commencing procurement or production.

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2.21.4 Contract-Specific Quality Plan (AQAP 2310 §5.4.1.1; AQAP 2105)

When required by the purchase order or contract, the Supplier shall prepare, implement, and maintain a contract-specific Quality Plan before start of production or service provision. The Quality Plan shall describe how the Supplier's QMS and processes are applied to fulfill contractual, technical, inspection, test, preservation, and AQAP requirements. At a minimum, the Quality Plan shall identify applicable documents and specifications; sequence of key activities; responsibilities and authorities; inspection and test planning; required records; controls for off-site or outsourced work; interfaces with the Configuration Management Plan and Risk Management Plan; and a requirements-to-solution compliance matrix.

For work involving counterfeit-risk items, obsolete or obsolescence-prone items, independent-distributor sourcing, or AXON-designated critical items, the Quality Plan shall include and reference the Supplier's Anti-Counterfeit Management Plan, sourcing controls, supplier-approval controls, traceability requirements, receiving-inspection controls, authentication/test escalation criteria, suspect counterfeit containment process, reporting process, obsolescence management controls, and annual compliance evidence required by AXON.

The Quality Plan shall be submitted to AXON for review and acceptance when contractually required and shall be made available to the GQAR on request.

2.21.5 Configuration Management Plan and Configuration Control (AQAP 2310 §5.4.1.2; ACMP 2100)

For NATO/AQAP work, the Supplier shall establish and maintain configuration management controls consistent with ACMP 2100 and, where required, a contract-specific Configuration Management Plan. The plan may be integrated into the Quality Plan. It shall address configuration identification and baselines, product structure and configuration items, control of changes to design data, manufacturing processes, software/firmware, test methods, deviations and concessions, configuration status accounting, as-planned / as-built / as-delivered traceability, and configuration verification or audits linked to FAIR/PPAP or other acceptance activities, as applicable.

2.21.6 Risk Management Plan (AQAP 2310 §5.2.1)

The Supplier shall establish, maintain, and periodically review a contract-specific Risk Management Plan aligned with ISO 31000. Risk identification shall begin during contract review and continue through delivery and post-delivery support, as applicable. The plan shall address contractual, technical, quality, schedule, external-provider, special-process, configuration, counterfeit, obsolescence, and supply-continuity risks. The Supplier shall define risk ownership, evaluation criteria, mitigation actions, escalation thresholds, review frequency, and retention of risk records. The current risk register and related objective evidence shall be available to AXON and the GQAR upon request.

Counterfeit-risk assessment shall consider, at a minimum, source of supply, authorized-distribution status, OEM/OCM traceability, market availability, obsolescence status, item criticality, safety or mission impact, prior supplier history, country-of-origin or chain-of-custody concerns, unusual pricing or lead time, documentation gaps, packaging or marking anomalies, and test or inspection anomalies. Supplier shall document mitigation actions for elevated-risk items and shall make the risk assessment available to AXON and/or the GQAR upon request.

2.21.7 External Providers, Flowdown, Right of Access, and Cooperation with GQAR (AQAP 2310 §5.4.6, §5.7, §5.8; AQAP 2131 §3.1)

The Supplier shall flow down all applicable contractual, STANAG, AQAP, GQA, inspection/test, configuration, traceability, counterfeit-prevention, preservation, record-retention, and right-of-access requirements to applicable external providers and sub-tier suppliers. Purchasing documents for NATO work shall include the statement: "All requirements of this contract may be subject to GQA. You will be

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notified of any GQA activity to be performed." The Supplier shall grant AXON, the Acquirer, and any designated GQAR access to relevant facilities, processes, documents, electronic records, inspection and test activities, communication facilities, reasonable workspace, equipment for reasonable use, and knowledgeable personnel needed to perform GQA activities, subject to applicable legal and security restrictions. The Supplier shall support planned and unplanned GQAR visits and shall notify AXON of significant subcontract risk before work starts when such risk may affect contractual performance.

Supplier shall ensure that external providers and sub-tier suppliers supporting NATO work are contractually required to comply with applicable counterfeit-avoidance, authorized-sourcing, traceability, independent-distributor control, obsolescence-management, inspection/test, suspect counterfeit reporting, record-retention, and right-of-access requirements. Supplier shall not use an external provider's approval status, AXON-directed sourcing, source inspection, or GQAR activity as a basis to reduce Supplier's own responsibility for product conformity, authenticity, traceability, or contractual compliance.

Supplier shall maintain objective evidence that applicable NATO quality assurance requirements and counterfeit-avoidance requirements were flowed down, reviewed, accepted, and implemented by external providers. AXON, the Acquirer, and/or the GQAR may request copies of such flowdowns and related supplier-control records.

2.21.8 Production and Service Provision, Inspection and Test, Special Processes, and Certificates of Conformity (AQAP 2310 §5.4.5, §5.4.7-§5.4.10; AQAP 2131 Chapter 2)

The Supplier shall perform all inspections and tests required by the contract and maintain documented procedures and acceptance criteria for those activities. Inspection and test status shall be clearly indicated and controlled. Critical items and key characteristics shall be identified and controlled using appropriate quality planning, validation, and acceptance methods.

Inspection, Authentication, and Testing of High-Risk Items. Supplier shall apply inspection, verification, and authentication methods proportionate to the counterfeit risk and criticality of the item. Such methods may include documentation review, packaging inspection, labeling and marking inspection, physical inspection, dimensional inspection, visual inspection, destructive or non-destructive analysis, electrical testing, material analysis, radiographic inspection, decapsulation, chemical analysis, software/firmware verification, or other methods appropriate to the item and risk.

For electronic, electrical, and electro-mechanical items obtained from independent distributors, brokers, or other non-authorized sources, Supplier shall apply risk-based controls consistent with AS6171 and related industry standards, as applicable. Supplier shall retain objective evidence of all inspection, authentication, test, and disposition activities and shall provide such evidence to AXON, the Acquirer, or the GQAR upon request.

Special processes and other processes whose outputs cannot be fully verified by subsequent inspection shall be validated, approved, monitored, and requalified as required. Where the Supplier performs design and development, such activities shall be controlled under documented processes aligned with AS9100 and the contract; otherwise, the Supplier shall treat the work as build-to-print unless AXON provides written authorization.

For each delivery requiring a CoC or CoA, the document shall identify, at minimum, the Supplier name and address, AXON purchase order or contract number, applicable part number and revision, lot/batch/serial identification as applicable, governing specifications, approved deviations or concessions, statement of conformity, date and place of release, and authorized signature. The CoC/CoA shall be traceable to the applicable inspection and test records.

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2.21.9 Measurement Management (AQAP 2310 §5.4.11; AQAP 2131 §2.1(5))

The Supplier's system for control of monitoring and measuring resources shall be consistent with ISO 10012 and shall cover selection, identification, metrological confirmation, calibration, verification, adjustment, protection, and use of measuring and test equipment. The Supplier shall maintain records showing calibration status, interval control, and measurement-process controls. When out-of-tolerance conditions may have affected accepted or delivered product, the Supplier shall document the impact assessment by affected lot or serial, implement containment as necessary, and promptly notify AXON.

2.21.10 Nonconforming Outputs, Rework, Concessions, and Complaint Escalation (AQAP 2310 §5.4.12, §5.5; AQAP 2131 §2.6)

The Supplier shall control nonconforming outputs under documented procedures that include identification, segregation, review, disposition, re-verification, and record retention. Unknown-status product shall be treated as nonconforming until verified. For NATO/AQAP work, any proposal to use product as-is, repair, rework outside approved methods, or otherwise release product under concession/deviation for delivery to AXON shall be formally documented and submitted to AXON for disposition. The Supplier shall not ship NATO/AQAP product under concession unless written approval has been granted by AXON and, where contractually required, by the Acquirer/GQAR. Significant complaints, escapes, or post-delivery quality issues affecting NATO/AQAP work shall be reported promptly to AXON so that required downstream notifications can be made.

2.21.11 Critical Items, Traceability, Preservation, and Recall Capability (AQAP 2310 §5.3.1, §5.4.8-§5.4.9)

AXON may designate certain items, characteristics, assemblies, or processes as safety-critical, mission-critical, or otherwise critical. For such items, the Supplier shall maintain enhanced controls within the Quality Plan and Control Plans, including identification of key characteristics, validated special processes where applicable, and full traceability from raw material and key sub-assemblies through manufacturing, inspection, test, storage, and shipment to the delivered lot or serial number. The Supplier shall preserve product in a manner that maintains conformity and shall maintain a documented recall capability sufficient to identify, locate, and contain affected items within a timeframe agreed with AXON.

2.21.12 Counterfeit Materiel Prevention and Avoidance (AQAP 2021 Chapter 2; AQAP 2310 Annex E)

Supplier shall establish, implement, maintain, and periodically review a documented Counterfeit Materiel Prevention Program appropriate to the nature, criticality, complexity, obsolescence status, and supply-chain risk of the items supplied to AXON. The program shall apply to electronic, electrical, electro-mechanical, software-enabled, high-value mechanical, safety-critical, mission-critical, obsolete, obsolescence-prone, or otherwise AXON-designated high-risk items.

The program shall include, at a minimum:

1. a written anti-counterfeit policy endorsed by top management;
2. defined responsibilities, authorities, and escalation paths for counterfeit-avoidance activities;
3. appointment of a responsible management representative or equivalent authority for counterfeit-avoidance compliance;
4. risk-based supplier selection, approval, monitoring, and re-evaluation controls;
5. preferential sourcing from OEMs, OCMs, and OEM/OCM-authorized or franchised distributors;
6. controls restricting use of independent distributors, brokers, surplus sources, gray-market sources, or other non-authorized sources;
7. documented AXON approval before use of any independent distributor or non-authorized source for AXON product, unless expressly waived in writing by AXON;
8. risk-based receiving inspection, documentation review, authenticity verification, and test requirements;

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9. inspection and test escalation criteria for obsolete, high-risk, or non-authorized-channel items;
10. traceability and chain-of-custody requirements sufficient to demonstrate authenticity and conformity;
11. quarantine, containment, investigation, disposition, and prevention of re-entry into the supply chain for suspect or confirmed counterfeit materiel;
12. prompt reporting to AXON of suspect or confirmed counterfeit materiel associated with AXON product or purchase orders;
13. flow-down of counterfeit-avoidance requirements to external providers and sub-tier suppliers;
14. personnel competence, training, and awareness requirements;
15. retention of objective evidence demonstrating implementation and effectiveness of the counterfeit-prevention program; and
16. periodic review and continuous improvement of counterfeit-prevention controls.

Supplier shall use risk-based practices consistent with ISO 22380, IEC 62668-1, IEC 62668-2, AS5553, AS6081, AS6171, ARP6178, and ARP6328, as applicable to the item, source, and contractual risk.

2.21.13 Sourcing Restrictions and Independent Distributor Controls (AQAP 2021 Chapter 2; AQAP 2310 Annex E)

Supplier shall procure items for AXON product from the OEM, OCM, or OEM/OCM-authorized distributor whenever such sources are available. Supplier shall not procure items from independent distributors, brokers, surplus dealers, unauthorized distributors, gray-market sources, online marketplaces, or other non-authorized sources for AXON product without AXON's prior written approval.

Any request to use an independent distributor or other non-authorized source shall include, at a minimum:

1. reason the OEM/OCM or authorized-distributor source is unavailable or unsuitable;
2. identification of the proposed source;
3. part number, revision, lot/date code, serial number, quantity, and manufacturer information;
4. available traceability and chain-of-custody documentation;
5. distributor risk assessment;
6. obsolescence or DMSMS assessment, if applicable;
7. proposed inspection, authentication, and test plan;
8. proposed acceptance criteria;
9. quarantine and containment controls pending acceptance; and
10. records to be retained and provided to AXON.

Supplier shall not use or deliver such items until AXON has provided written approval and Supplier has completed the required inspection, authentication, test, and documentation activities.

2.21.14 Suspect and Confirmed Counterfeit Reporting (AQAP 2021 Chapter 2; AQAP 2310 Annex E)

Supplier shall immediately notify AXON if Supplier identifies, suspects, receives notice of, or has reason to believe that any materiel associated with AXON product or AXON purchase orders may be counterfeit, suspect counterfeit, misrepresented, untraceable, altered, used, refurbished, reclaimed, or otherwise nonconforming.

The notification shall include, to the extent known, affected AXON purchase orders, part numbers, revisions, lot numbers, serial numbers, quantities, source of supply, affected shipments, current location of affected materiel, containment actions, inspection or test results, investigation status, and proposed corrective action.

Supplier shall cooperate with AXON, the Acquirer, the GQAR, the OEM/OCM, applicable reporting bodies, and appropriate governmental or law-enforcement authorities as required by contract or law. Supplier shall

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not dispose of, return, transfer, or release suspect or confirmed counterfeit materiel without AXON's written authorization, except where required by law.

2.21.15 Obsolescence Management and DMSMS Controls (AQAP 2021 §2.5; EN/IEC 62402)

For items designated by AXON as safety-critical, mission-critical, obsolescence-prone, long-life, defense-related, or otherwise high risk, Supplier shall establish and maintain an Obsolescence Management Plan consistent with EN/IEC 62402. The plan shall address identification of obsolescence-prone items, lifecycle monitoring, DMSMS risk, last-time-buy planning, alternate-source evaluation, alternate-part qualification, redesign risk, storage risk, software/firmware support, counterfeit-risk impacts, and timely notification to AXON.

Supplier shall notify AXON promptly of actual or anticipated obsolescence, end-of-life notices, product-change notices, discontinuance notices, allocation, shortage, diminished manufacturing sources, or other conditions that may affect availability, authenticity, traceability, configuration, or conformity. Supplier shall not implement an obsolescence-driven alternate source, alternate part, redesign, date-code expansion, life-extension strategy, or last-time-buy strategy for AXON product without AXON's prior written approval.

2.21.16 Annual Supplier Questionnaire and Certification

For NATO work and for any supplier supporting AXON-designated high-risk, safety-critical, mission-critical, electronic, electrical, electro-mechanical, obsolete, or obsolescence-prone items, Supplier shall complete AXON's annual supplier quality and counterfeit avoidance questionnaire upon request. The questionnaire may address, without limitation, Supplier's QMS status, STANAG/AQAP readiness, anti-counterfeit program, authorized-sourcing controls, independent-distributor controls, traceability practices, obsolescence-management practices, training records, inspection/test controls, nonconforming-material controls, suspect counterfeit reporting, sub-tier flowdown, records retention, and prior counterfeit or suspect counterfeit events.

Supplier shall certify that questionnaire responses are accurate, complete, and supported by objective evidence. Supplier shall provide supporting documentation upon AXON's request. Failure to complete the questionnaire, failure to provide requested evidence, or submission of inaccurate or incomplete information may result in AXON supplier-quality escalation, corrective action, audit, source inspection, suspension of purchasing activity, disqualification, or other remedies available under the applicable Supplier Agreement, purchase order, or law.

2.21.17 Records Retention and Availability (AQAP 2310 §4.3; AQAP 2131 §2.1(6))

For NATO work, the Supplier shall retain applicable records for the longer of the contractual requirement, the applicable regulatory requirement, or life of program plus six (6) years. Records shall remain legible, protected, retrievable, and available to AXON and, where contractually applicable, the Acquirer/GQAR within a reasonable timeframe. The retained record set shall include, as applicable, contract-review evidence, QMS evidence, Quality Plans, Configuration Management Plans, Risk Management Plans, purchasing flow-down records, inspection and test records, FAIR/PPAP records, CoCs/CoAs, calibration and measurement records, traceability records, nonconformance and concession records, counterfeit investigations, complaint handling records, and GQAR-related correspondence.

The retained record set shall also include, as applicable, annual supplier questionnaires and certifications, anti-counterfeit plans, counterfeit-risk assessments, distributor risk assessments, independent-distributor approval records, authorized-source documentation, OEM/OCM traceability evidence, chain-of-custody records, authentication test plans, inspection and test results, obsolescence assessments, DMSMS records, last-time-buy records, suspect counterfeit investigation records, containment records, disposition records, reporting records, sub-tier flow-down records, and training records.

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2.21.18 NATO STANAG/AQAP Standards and Standards Incorporated by Reference

Standard (latest contractually invoked edition)	**Title**
NATO STANAG 4107	Mutual Acceptance of Government Quality Assurance and Usage of the Allied Quality Assurance Publications (AQAP)
NATO AQAP-2310	Quality Assurance Requirements for Aviation, Space, and Defence Suppliers
NATO AQAP-2131	Quality Assurance Requirements for Final Test and Inspection
NATO AQAP-2021	Guidance for the Avoidance of Counterfeit Materiel in the Supply Chain
NATO AQAP-2105	Requirements for Quality Plans
NATO ACMP 2100	Core Set of Configuration Management Requirements
NATO ADMP 01	Guidance for Developing Dependability Requirements
AS9100	Quality Management Systems – Requirements for Aviation, Space and Defense Organizations
ISO 9001	Quality Management Systems
ISO 10012	Measurement Management Systems
ISO 22380	Security and Resilience: Authenticity, Integrity, and Trust for Products and Documents
ISO 31000	Risk Management
EN/IEC 62402	Obsolescence Management
IEC 62668-1	Process Management for Avionics: Counterfeit Prevention
IEC 62668-2	Managing Electronic Components from Non-Franchised Sources
SAE AS5553	Counterfeit Electrical, Electronic, and Electromechanical Parts: Avoidance, Detection, Mitigation, and Disposition
SAE AS6081	Counterfeit Electrical, Electronic, and Electromechanical Parts: Avoidance, Detection, Mitigation, and Disposition – Distributors
SAE AS6171	Test Methods Standard: General Requirements, Suspect/Counterfeit Electrical, Electronic, and Electromechanical Parts
SAE ARP6178	Guideline for Development of Counterfeit Electronic Parts: Avoidance, Detection, Mitigation, and Disposition Systems

The foregoing standards apply to the extent invoked by contract, purchase order, AXON specification, NATO STANAG/AQAP requirement, or risk-based supplier quality determination. Where a standard is not expressly invoked, the Supplier shall use the standard as guidance for establishing risk-appropriate counterfeit avoidance controls.

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2.21.19 Annex D Cross-Reference Matrix

SQM Section	Appendix D Reference	Primary AQAP Source
1.2 Applicability	2.21.1, 2.21.3	AQAP 2310 §4.3, §5.1.2; AQAP 2131 §1.3
2.1 General Requirements / Right of Access	2.21.7	AQAP 2310 §5.4.6, §5.7, §5.8; AQAP 2131 §3.1
2.2 Management Systems / Risk Management	2.21.2, 2.21.6	AQAP 2310 §4.1-4.3; §5.2.1
2.4 Nonconforming Material	2.21.10	AQAP 2310 §5.4.12, §5.5; AQAP 2131 §2.6
2.6 Records Retention	2.21.17	AQAP 2310 §4.3; AQAP 2131 §2.1(6)
2.7 Document Management Requirements	2.21.3, 2.21.4	AQAP 2310 §5.1.1-§5.1.2; §5.4.1.1
2.8 Engineering Data / 2.9 Change Management	2.21.5, 2.21.11	AQAP 2310 §5.3.1; §5.4.1.2; §5.4.5
2.10 Material and Product Verification	2.21.4, 2.21.7, 2.21.8	AQAP 2310 §5.4.7-§5.4.10; AQAP 2131 Chapter 2
2.14 Control of Monitoring and Measuring Equipment	2.21.9	AQAP 2310 §5.4.11; AQAP 2131 §2.1(5)
2.15 Identification and Traceability	2.21.11	AQAP 2310 §5.4.8-§5.4.9
2.18 Appendix A – Electronic Assembly Suppliers	2.21.12, 2.21.13, 2.12.14, 2.21.15	AQAP 2021 Chapter 2; AQAP 2310 Annex E

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2.22 APPENDIX E - Definitions and Acronyms

AML/AVL: Approved Manufacturer List/Approved Vendor List

Authorized Distributor: A distributor with a contractual authorization from the original manufacturer to sell, distribute, or support the applicable item and to provide manufacturer-based traceability and warranty support.

BOM: Bill of Material

CAPA: Corrective and Preventive Action

Characteristic: A distinguishing feature.

CoA: Certificate of Analysis

CoC: Certificate of Compliance

COTS: Commercial Off the Shelf

Cpk: The capability index for a stable process. Estimate of sigma based on “within subgroup” variation. Sigma calculated with the (R-Bar/d2) equation. A predictor of short term or current state variation.

CTQ: Critical-To-Quality Characteristic. Same as an Inspection Dimension.

Counterfeit Material: An item, part, component, assembly, software, firmware, material, or related documentation that is an unauthorized copy, imitation, substitute, or modified item that is knowingly, recklessly, or negligently misrepresented as genuine, new, conforming, traceable, or otherwise acceptable under the applicable contract, specification, drawing, or purchase order.

DPPM: Defective Parts Per Million: A defect rate calculated as:

$$\text{DPPM} = \frac{\text{1,000,000 X number of defective parts produced/tested}}{\text{total number of parts produced/tested}}$$

Deviation: A temporary change or departure from approved AXON specifications or documented requirements. Deviation authorization can only be provided by AXON in the form of an approved deviation process

DFM: Design for Manufacturability.

ECR: Engineering Change Request

ECO: Engineering Change Order

EEE: Electronic, Electrical, and Electromechnical

FAIR: First Article Inspection Report: A complete, independent, and documented physical and functional inspection process to verify that prescribed production methods have produced an acceptable item as specified by engineering drawings, planning, purchase order, engineering specifications, and/or other applicable documents.

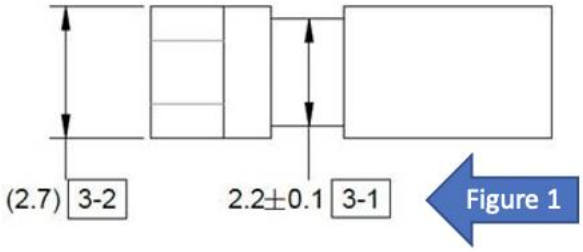
First Pass Yield (FPY): The number of good units produced divided by the number of total units going through the process.

FOD: Foreign object debris / detection

General Dimension: A dimension provided on a drawing to define the size or geometric characteristic of a feature, not deemed to be a CTQ Characteristic. General dimensions are expected to be verified during the first article inspection process and at a minimum 1 time per year during an annual layout. Additional verification is up to the supplier based on the amount of risk the supplier is willing to accept if non-

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conforming product is identified by AXON or its customers. Use the Quality Control Plan to document the inspection strategy for all general dimensions. The supplier is responsible for shipping only conforming parts to AXON. An example of a general dimension is shown in figure 1.



GQA: Government Quality Assurance: The process by which the appropriate National Authority, NATO organization, Acquirer or its authorized representative establishes confidence. That the Supplier (AXON) and its External Providers (AXON's Suppliers) are meeting the contractual requirements relating to quality, including regulatory requirements like STANAG/AQAP, FAR, DFARS; product conformity requirements, quality management system requirements, and associated documented information, verification, validation, inspection, testing and release obligations.

GQAR: Government Quality Assurance Representative: The person or personnel designated by the appropriate National Authority, NATO organization, or Acquirer to perform Government Quality Assurance activities including the review, evaluation, verification, validation, inspection, testing, release, surveillance, audit, access, and acceptance-related activities under the applicable contract, STANAG/AQAP requirements, and related quality assurance flowdowns.

GR&R: Gage Repeatability and Reproducibility: The process used to evaluate a gauging instrument's accuracy by ensuring its measurements are repeatable and reproducible, represents both the equipment variation and the appraiser variation.

Independent Distributor: A distributor, broker, reseller, or other source that is not an OEM, OCM, or OEM/OCM-authorized distributor for the applicable item.

Inspection Dimension or CTQ: Critical-To-Quality Characteristic. Also known as an Inspection Dimension on some Legacy drawings.

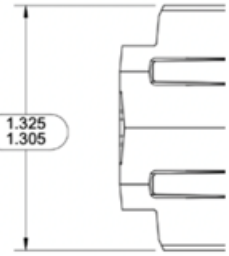
A feature on the drawing inside a capsule whose variation within the specified tolerance has a significant influence on product fit, performance, service life, or manufacturability. Will require capability studies during FAIR/PPAP and ongoing SPC monitoring. The minimum Cpk requirement is 1.33. When a feature is designated as a CTQ or Inspection Dimension it indicates that there is the need for variation management (i.e. Statistical Process Control) of the process(es) to ensure the feature is produced at or very close to the nominal rather than just within tolerance. CTQ's require a minimum process capability of 1.33 Cpk to be met during the first article inspection process and maintained by the supplier after release to production.

The exact method and expectation of SPC and data availability shall be established with Supplier Quality Engineering and documented in the supplier's Quality Control Plan.

CTQ's or Inspection Dimensions will be designated on the drawing in one of 2 ways: A dimension enclosed by an oval/capsule (see figure 2) or a dimension marked with a CTQ inside a dimension box (see figure 3), with details specified in the drawing notes (see figures 4 & 5).

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Figure 2



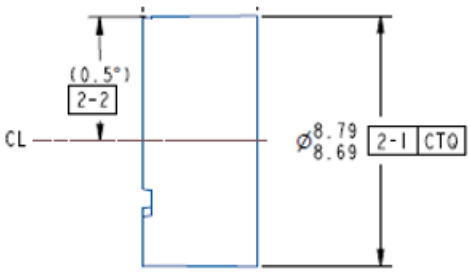


Figure 3

Figure 4

INSPECTION DIMENSIONS, FOR QA USE, ARE INDICATED BY A CAPSULE: (X.XXX)

DRAWING INDICATES FIRST ARTICLE INSPECTION [X-X] AND CRITICAL-TO-QUALITY [CTQ] DIMENSIONS. ASSOCIATED CAD FILE DEFINES ALL NON-DIMENSIONED GEOMETRY (DEFAULT TOLERANCES APPLY TO NON-DIMENSIONED GEOMETRY). A DIMENSION IN PARENTHESIS IS FOR REFERENCE ONLY AND IS NOT REQUIRED TO MEET ANY TOLERANCE SPECIFICATION. DIMENSION LABELS ARE FORMATTED AS VIEW#-DIM# TYPE. EXAMPLE: [3-14] [CTQ] MEANS THAT DIMENSION 14 IN VIEW 3 IS CRITICAL-TO-QUALITY. REFER TO THE AXON SUPPLIER QUALITY MANUAL FOR FAIR/PPAP, CPK, GRR, ONGOING SPC AND OTHER QUALITY REQUIREMENTS.

Figure 5

Incoming Quality Control (IQC): Inspection performed by the Supplier's prior to a product's use.

Master/Golden Sample(s): A representative sample of product manufactured during the production run used to create the FAIR/PPAP that must be identified, preserved and retained for the same period of time that the FAIR/PPAP records are retained. If multiple cavitied, product streams or production sites are used to make parts, then samples must be retained for each.

Measurement System Analysis (MSA) – an experimental and mathematical method of determining how much the variation within the measurement process contributes to overall process variability. MSA is required for all equipment used in measuring CTQ's. Studies for Repeatability & Reproducibility, Bias between multiple gages/fixtures, Linearity, and Stability over time. See FAIR/PPAP Tool Kit.

Nonconforming material: Product or material which does not conform to specified requirements. This includes nonconforming product or material returned from a customer.

OBA: Out of Box Audit

Obsolescence: The transition of an item, component, material, software, firmware, process, or support capability toward unavailability, discontinuance, end-of-life, diminished manufacturing sources, or material shortage.

OEM/OCM: Original Equipment Manufacturer or Original Component Manufacturer that designed, manufactured, or has legal control over the item or component.

PSA: Pre-Shipment Audit. The purpose of PSA is to verify if materials and products are consistent to the spec and criteria and will take containment action if any major non-conformance found in the factory.

PPAP: Production Part Approval Process. The PPAP process is a set of tools and deliverables that demonstrate the capability of a supplier to meet Axon's quality and production rate requirements.

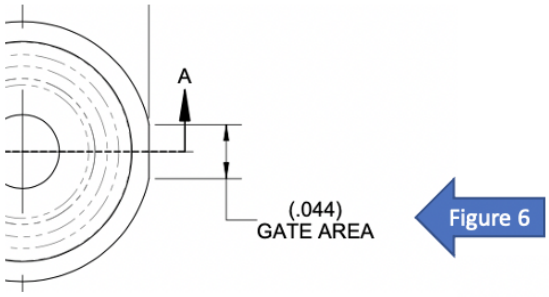
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Ppk: The performance index for a stable process. Estimate of sigma based on “total” variation. Sigma calculated with the (root mean square) equation. It is a predictor of long term or future state variation.

Quality Control Plan (QCP): A document that defines all the methods used for product and process control including inspection tools, sample size, sample frequency and reaction plans when out of specification or out of control processes are detected. See FAIR/PPAP Tool Kit

QMS: Quality Management System

Reference Dimension: A dimension on an engineering drawing provided for information only. Reference dimensions are provided for a variety of reasons and are often an accumulation of other dimensions that are defined elsewhere (e.g. on the drawing or other related documentation). A reference dimension appears on the drawing as a numerical value enclosed in parenthesis, as shown in figure 6. During the first article inspection report/PPAP reference dimensions shall be recorded to understand their initial variation and establish a point of reference for future analysis.



Repair: The act of restoring the functional capability of nonconforming material. However, the restored material does not conform to applicable drawings or specifications. Only allowed under AXON approved Deviation.

Rework: The act of reprocessing nonconforming material, using original or alternate equivalent (AXON approved) processing, in a manner that assures compliance of the material with applicable drawings or specifications.

R@R: Run@Rate is where the supplier proves and demonstrates that its manufacturing process is capable to produce acceptable parts according to customer requirements at the quoted production rate.

SCAR: Supplier Corrective Action Report: is a form in Octave that lists issues/defects that have been found on a product delivered by a supplier, communicates them to the supplier, and requests, containment, investigation, and corrective action (8D).

SDE: Supplier Development Engineer: is the main contact at Axon for quality topics with suppliers.

8D: Eight disciplines corrective action report: is a problem-solving approach for product and process improvement.

Shall: Indicates a requirement that is mandatory.

Should: Indicates a requirement but has more flexibility than a shall. Should’s must meet the intent of the requirement.

SIR: Supplier Information Request, used for potential supplier related changes i.e. to request change to drawing, material, a change to fit, form or function, Transfer of Work (TOW), submitted in Octave.

Special Process: A process that generates a characteristic that is difficult to verify. For example, a process involving Heat Treating (e.g. brazing, nitriding, hardening), Soldering, or Chemical Processing

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(e.g. plating, anodizing, conversion coating). Additionally, the process must be defined by a specification and/or standard on the AXON drawing (e.g. solder in accordance with J-STD-001).

Supplier: A company and its suppliers that provide materials or parts, direct or indirect, to AXON.

SQM: Supplier Quality Manual. This document.

SPC: Statistical Process Control. The preferred method to reduce process variation.

Test Requirements Document (TRD): A document that defines the required testing that is performed on 100% of the product being manufactured internally or externally.

TOW: Transfer of Work between locations

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2.23 Revision History

The Revision History documents significant changes made to the AXON Supplier Quality Manual.

Minor editorial updates (e.g., grammar, formatting, or clarification without intent change) may not be individually itemized.

Revision Summary Table

Revision	Description of Changes	Author(s)
15.0	Complete rewrite. Combined Supplier Quality Manual and Supplier Quality Assurance Clauses into a single document.	D. Wasson, J. Repyak
16.0	• Added SIR and PSA definitions • Added AXON Directed Supplier (sub-tier) • Reduced document retention from 5 years to 3 years • Added CPK Guidelines • Updated traceability requirements for PCBA • Added hygroscopic/desiccant guidelines • General grammar and formatting updates	D. Wasson
17.0	• Formalized Supplier Change Management as a standalone section. • Introduced Change Classification framework (Minor / Major / Critical). • Added Software & Firmware Security Controls. • Added Information Security and Data Protection requirements. • Added structured Supplier Performance Escalation levels. • Defined Pre-Production Validation requirements (SPF / EVT / DVT / PVT). • Added Nonconforming Material Discovered After Shipment • Clarified Run@Rate requirements for mass production tooling. • Strengthened FAIR/PPAP statistical and CTQ capability requirements. • Enhanced GR&R study requirements for CTQ measurements. • Added Supplier Response timelines for NCMR and RMA. • Strengthened Counterfeit Electronic Component Prevention requirements. • Improved PCBA-specific validation requirements. • Improved cross-referencing and eliminated duplicate change-control language. • Structural reorganization and grammar refinement for improved clarity and audit defensibility.	TK See, Mauricio Salazar

18	• Added Contract Manufacturer Quality Addendum as Appendix C
	• Added NATO STANAG/AQAP applicability requirement for AXON purchase orders and contracts that invoke NATO, STANAG, AQAP, or equivalent national-defense quality requirements.
	• Added definitions to Appendix A including Authorized Distributor, Counterfeit Material, EEE, GQA, GQAR, Independent Distributor, Obsolescence, and OEM/OCM
	• Added Appendix D – NATO Requirements, containing:
	  ○ Scope, applicability, and order-of precedence provisions for NATO STANAG/AQAP requirements.
	  ○ QMS, quality-representative, and documented-information requirements.
	  ○ Contract review and identification of NATO STANAG/AQAP requirements.
		TK See, Mauricio Salazar, Traci Dixon

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Revision	Description of Changes	Author(s)
	○ Contract-specific Quality Plan requirements. ○ Configuration-management requirements and Configuration Management Plan content. ○ Risk-management requirements and Risk Management Plan content. ○ Purchasing, external-provider, and sub-tier requirement flow-down. ○ GQA/GQAR right-of-access and cooperation requirements. ○ Production, inspection, testing, acceptance, and special-process controls. ○ Measurement-management and calibration requirements. ○ Control of nonconforming product, rework, repair, concessions, deviations, and waivers. ○ Critical-item control, traceability, preservation, and recall requirements. ○ Counterfeit material prevention, reporting, investigation, disposition, and independent distributor controls. ○ Obsolescence management and DMSMS controls. ○ Annual supplier questionnaire/certification requirements. ○ NATO-specific record-retention and availability requirements. ○ Cross-reference information for applicable NATO STANAG/AQAP and related standards.	

Revision Control Notes

- Revision approval shall follow AXON internal document control procedures.
- The revision number shall be updated only after formal approval.
- This document is considered uncontrolled when printed unless otherwise specified.

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2.24 Exceptions to SQM Requirements Compliance Acknowledgement

Exceptions to the SQM Requirements for AXON Supplier

Below are the exceptions to the document along with the supporting rationale for the exception.

Requirement (Section #, Title)	Requirement (Description)	Rationale for Exception

2.25 SQM Requirements Compliance Acknowledgement

Objective	The intent of this form is to document acknowledgement that the recipient complies with the requirements set forth in the latest revision of the SQM requirements document listed above. This form also serves as the means for the recipient and AXON to agree upon those requirements that do not apply.
Scope	This acknowledgement document is to be used in conjunction with the above SQM Requirements document.

To be completed by the Supplier:

SQM Document # & Title: _____

Document Version: _____

Supplier Name: _____

SQM Requirements Compliance Acknowledgement

The recipient has reviewed the above referenced document and acknowledges compliance to all requirements stated within said document, with the exception of those requirements identified on the exceptions page above.

Supplier's Quality Management Name	Supplier's Quality Management Signature	Date

AXON Approval

AXON has reviewed and approves of the exceptions taken by the Supplier.

Axon Supplier Quality Engineer (SQE) Name	Axon Supplier Quality Engineer (SQE) Signature	Date

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