



Supplier Quality Requirements – Machined Parts and Assemblies

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1. WORKMANSHIP AND SPECIFICATIONS MANUAL (WSM)

The CSW Workmanship and Specifications Manual is applicable to all CSW procurements unless otherwise specified in the Purchase Order, Drawing, or Subcontractor Statement of Work. The Manual may be identified on the L3 drawing as either the Workmanship and Specifications Manual, WSM-01, WSM, or S01.

It invokes CSW Workmanship Standards (WS-XXX), Internal Specifications (IS-XXX), and Specification 60083155 (Torque and Retention Requirements for Threaded Hardware), establishing design, manufacturing, and acceptance requirements. The manual may be accessed at [BCS Workmanship and Specification Manual / Internal Specifications | L3Harris Technologies, Inc.](#)

The applicable Internal Specifications and Workmanship Standards for this commodity are the following:

- WS-004, Metal Fabricated Parts and Assemblies
- WS-010, Protective Finishes (as applicable)
- WS-011, General Cleaning
- WS-012, Marking, Engraving and Labeling
- WS-014, Riveting (as applicable)
- WS-015, Gaskets (if gasketing specified on Drawing)
- WS-022, Cosmetic Surface Conditions
- IS-001, Use of Non-Specified Hardware Material and Drawing Notes
- IS-006, Drawing Standards
- IS-008, Material Number Suffix Configuration
- IS-011, Elimination and Replacement of Primer and Paint Numbers
- IS-012, Minimizing the Use of Hexavalent Chromium Conversion Coatings
- IS-013, Substitution of Alternate Size and Shape Materials

If the completed Machine Fabricated Assembly contains additional subassemblies or processes (e.g. Circuit Cards, Cables, Welding, etc), then additional commodity specific requirements shall apply.

2. MATERIAL/PROCESS REQUIREMENTS

Supplier shall retain a copy of all procured raw material certifications. The certification shall include material specification, dimension description, alloy and condition. The supplier shall retain the original and any secondary independent test laboratory certification(s). This requirement shall be flowed down to all sub-tier suppliers.

Supplier shall retain copies of certifications to the applicable standards for all subcontracted special processes. Certifications from all levels of the supply chain shall be made available upon request.

3. INSPECTION DATA

Seller shall provide inspection data with each shipment. The data shall account for drawing characteristics and demonstrate inspection and acceptance. If sampling methodology is utilized, the data shall identify if sampling has been employed.

4. SPECIAL PROCESS

Refer to commodity specific requirements document for Special Processes.

5. NONDESTRUCTIVE TEST (NDT) PROCEDURE/TECHNIQUE SUBMITTAL REQUIREMENTS

- 5.1. Unless otherwise specified on the drawing or P.O., for CSW designed hardware the supplier shall submit general NDT procedures and part-specific technique sheets to CSW Buyer for CSW Engineering approval prior to conducting NDT.
- 5.2. Suppliers using outside sources for NDT shall ensure that the selected NDT sub-tier has CSW approval for the NDT procedure/technique used.
- 5.3. After initial approval, any changes to subject documents must be resubmitted to CSW for approval via the Change/Information Request Form.
- 5.4. On-site validation of procedures/technique sheets to verify specification compliance may be performed at the discretion of CSW.

END OF DOCUMENT

Revision History Summary

Revision #	Description of Change	Date
00	Initial Release.	1/08/2016
NA	Updated hyperlink in section 1. No revision upgrade necessary.	2/25/2025