



# Quality Clauses

Instructions: All items are required for all Purchase Orders, except the following optional clauses: 015, 016, 021, 022, 023, 025, and 029. When optional clauses are required, they will be added to P.O. in addition to these standard requirements

## QMS REQUIREMENTS

001. The Sellers Quality Control System shall comply with the requirements of one of the following standards:

- a. Mil-Q-9858 (issue in effect on date of order)
- b. Mil-I-45208 (issue in effect on date of order)
- c. ISO 9001
- d. ISO 9002
- e. AS9100

002. Supplier must document and maintain a quality control system which is acceptable to Altemp Alloys.

003. No substitution of material specification, size or any other nature will be allowed except by amendment on the purchase order. All materials shall be those furnished or specified by Altemp Alloys.

004. **Record Retention** - Suppliers shall retain verifiable objective evidence of build, inspection & test records, special process certifications, raw material certifications and certificates of conformance for a minimum of fifteen (15) years from date of shipment, unless a longer period is otherwise specified. The data shall be made available to Altemp Alloys upon request.

005. **Inspection System** - Manufactures and Suppliers shall develop inspection procedures and maintain records of inspection. Records shall include evidence of inspection for all attributes (i.e. first article inspection manufactures only) of products / processes supplied to Altemp Alloys. The inspection system shall evaluate products/processes to insure that only materials/services that conform to purchase order requirements are delivered to Altemp Alloys.

006. **Nonconforming Product** - Suppliers shall develop procedures that assure product that does not conform to specified requirements is not shipped to Altemp Alloys. Dispositions of *Use As Is* or *Repair* for products under Altemp Alloys' customer design control shall require written authorization prior to shipment.

007. **Special Processes** - Altemp Alloys' customer approved special process suppliers shall be used on all Altemp Alloys design authority hardware. The use of Altemp Alloys' customer approved supplier does not relieve the supplier from responsibility to furnish acceptable supplies.

008. **Supplier Control** - Suppliers, including distributors, are responsible for insuring (ensuring either/or) that the applicable requirements of this purchase order are imposed on lower tier procurements for raw material, components or process services being used in the manufacture of products or services being provided.

009. **Prohibited Sources** - Altemp Alloys suppliers and/or sub-tier suppliers are prohibited from using any source listed on the US government Excluded Parties List System (EPLS) (ref.

<https://www.epls.gov/>) in the production of products to be delivered to Altemp Alloys.

010. **Right of Entry** - Altemp Alloys, Altemp Alloys' customer and relevant regulatory authorities will have access to supplier's, and all other facilities involved in the order, where they will have access to all procedures, practices, processes, associated documents and records related to quality assurance, quality control and configuration control. Altemp Alloys reserves the right to determine and verify quality of work, records and material. The supplier shall notify Altemp Alloys of any change in the location of supplier's facility.

011. **Responsibility for Conformance** - Acceptance of product shall not be used as evidence of effective control of quality by the supplier, and shall not absolve the supplier of responsibility for acceptable products or preclude subsequent rejection by Altemp Alloys or its customers.

012. **Industry Specifications and Standards** - For all Military, Federal, and Industry specifications and standards, the supplier shall comply with the revision in affect at the time Altemp Alloys purchase order is issued. Altemp Alloys reserves the right to request a different revision that would be specified on the purchase order.

## CERTIFICATION OF CALIBRATION

013. **Calibration System** - Calibration of measuring and test equipment used for product acceptance shall be traceable to established international or national measurement standards (e.g., BSI, NIST). Procedures for periodic calibration, certification and maintenance of tools and equipment shall be established and followed.

014. Measuring and test equipment supplied or serviced under this Purchase Order shall be calibrated in accordance with Military Specification MIL-STD-45662 'Calibration System Requirements', or in accordance with ANSI/NCSL Z540-1

015. Supplier must be approved by: the National Aerospace and Defense Contractors Accreditation Program (NADCAP) for the process being performed. Certification of conformance must reflect approval expiration date.

## KEY CHARACTERISTICS:

016. The Seller shall maintain applicable statistical control charts for key characteristics identified by the customer drawings. A copy of the key characteristics statistical control charts must accompany all items in the shipment to Buyer. The Seller shall flow down to sub-tier suppliers the applicable requirements in the purchasing documents, including key characteristics where required.

017. **Statistical Techniques** - Suppliers are responsible for understanding and reducing variation within processes, and are encouraged to use control-charting techniques. When control

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charting is not performed, sample inspection of all attributes shall be performed to ANSI/ASQ Z1.4 (MIL-STD-105), Level II 1.0AQL,c=0

### REPORT OF DISCREPANCY:

018. Any departure from drawing specifications or other purchase order requirements must be documented by the Seller and submitted to the Buyer for consideration and disposition. A copy of this disposition document must accompany each affected shipment.

### REPORT OF ESCAPE:

019. The Seller upon discovery of a shipment / delivery of nonconforming product must provide a notice of disclosure to the Buyer within 48 hours of discovery.

### DOCUMENTATION REQUIREMENTS

020. **Certificate of Compliance** – Seller shall provide with each shipment two copies of a certified statement that the Goods furnished on the Purchase Order meet Altemp Alloys specification requirements as stated on the Purchase Order and/or drawing(s) provided. At a minimum the Certificate of Conformance must contain the following information as it applies to the product(s) being certified:

- Part Name
- Drawing Number and revision date
- Serial number(s) as required
- Quantity of items inspected
- Purchase Order number
- List of specifications, grade, type to which the product was purchased
- Seller's name and address
- Signature and title of recognized Quality Assurance representative

Acceptance of product at Altemp Alloys is contingent upon receipt of a Certificate of Conformance, which contains the above referenced requirements. Certificate of Conformance under this requirement shall not be used in lieu of other requirements for test reports specified by this purchase order. Failure to supply certifications which comply with the above requirements may result in a delay of payment.

021. **MILL TEST REPORTS** - Supplier shall furnish two clear and legible sets of a certified copy of the original mill test report showing specific results of chemical and mechanical analysis on each heat of material supplied on this order. When test reports are chemistry only buyer approval will be required in writing on our purchase order.

022. When applicable, on processing test reports, our customer's part number and P.O. number must be reflected on all test reports as flowed down on Altemp Alloys' P.O. Also, Test report

must demonstrate compliance to purchase order and specified requirements (Altemp drawing and/or specifications).

023. Supplier shall furnish with each shipment on this order, copies of time and temperature charts representing the heat treating or brazing operations performed on the parts being shipped.

024. Packing list, certifications and other applicable documents must be identified by manufacturing lot or batch number.

025. One heat/lot per line item of purchase order unless more than one heat/lot approved by buyer in writing.

026. As required by the OSHA hazard communication standard, supplier shall provide a current material safety data sheet for all hazardous materials shipped to Altemp Alloys.

027. The delivery dates for each item on this order are Altemp's on-dock dates. When shipping items, supplier must allow adequate time for transportation in order to ensure that the on-dock dates are met.

### METAL/RAW MATERIAL REQUIREMENTS

028. For all purchased parts containing raw material, the supplier shall provide shipping documentation that provides verification that the material supplied is DFARS 252.225-7014, Alt. 1 and/or DMS 2201 (domestic only) compliant (i.e. melt source, melt country), unless otherwise specified on the purchase order. Any and all raw material shall be provided from a domestic or qualified country melt source (DFARS 252.225-7014, Alt. 1), unless otherwise specified on the purchase order. Requests for deviation must be submitted to the Altemp Alloys buyer.

029. Supplier shall furnish a test coupon for each lot of material submitted on this order. This coupon must be representative of the processing performed on that material.

### IDENTIFICATION FOR PRODUCT

030. Where impractical to stamp individual parts due to size or shape the lot, heat, charge and/or batch number shall be stamped on identifying tags or the smallest unit package including material type, specification, and traceable to the lot and/or ingot (if applicable) number(s) of materials used. Traceability records shall be available for review by the Buyer's Representative.

031. Raw material that can be stenciled or is mill marked shall be stenciled on the product and/or tagged with the material type, alloy type, material specification numbers, the condition (if applicable), nominal thickness, heat/batch number, purchase order.

032. Heat(s) will be segregated and clearly defined from each other.



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033. Coiled stock and rolled material shall be identified by a method integral to the core and which will be visible until the material has been completely removed from the core. The identification shall include as a minimum, material type, alloy type, material specification numbers, condition (if applicable), nominal thickness, heat/batch number, purchase order number and manufacturer identification.

## PRESERVATION AND PACKAGING

The following requirements apply only when specific preservation and packaging instructions are not invoked by the purchase order:

034. Items or processes performed under this Purchase Order shall exhibit workmanship indicative of aerospace quality. Evidence of flaws, mishandling (scratches and/or dings) or abuse shall be cause for rejection. Items must be furnished clean and free of labels, foreign material such as chips, dirt, oils, etc.

035. All supplies intended for delivery on the Purchase Order shall be protected against the usual hazards of corrosion, contamination, deterioration or other spoilage at the Seller's facility and prior to delivery.

036. All supplies delivered on the Purchase Order shall be packed with suitable protection to prevent corrosion, contamination, deterioration, spoilage or handling damage during transit and while in storage at Altemp Alloys.