



INDUSTRIAL PRECISION, INC.

PU7410101

**PURCHASE ORDER STANDARD
REMARKS CLAUSES**

Approval

Revision: F

Date: 9/13/18

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The following is a numerically sequenced list which is in accordance with AS9100 Rev D and ISO9001/2015. The following AS9100 clauses and IPI specific clauses are invoked on Industrial Precision Inc. purchase orders at the time of issue.

1. Quality Program Requirements

ISO 9001/2015

AS9100, Revisions D: Aerospace Standard: Quality Management Systems – Requirements of Aviation, Space, and Defense Organizations

8.1.3 Product Safety

- Plan, implement and control the process needed to assure product safety during the entire product life cycle as appropriate to the organization and the product

8.1.4 Prevention of Counterfeit Parts

- The organization shall plan, implement, and control processes, appropriate to the organization and the product, for the prevention of counterfeit or suspect counterfeit part use, and their inclusion in product(s) delivered to the customer

8.2.3 Review of the Requirements for Products and Services

- Organization shall ensure it can meet the requirements of the products or services it offers.
- A review should be in place before committing to supply products and services.

8.4.2 Type and Extent of Control

- The organization shall ensure that externally provided processes, products and services do not adversely affect the organizations ability to consistently deliver conforming products and services to its customers
- Verification activities of externally provided processes, products, and services shall be performed according to the risks identified by the organization

Note 2: Verification activities can include:

- Review of objective evidence of the conformity of the processes, products, and services from the external provider
- Inspection and audit at the external provider's premises
- Review of the required documentation
- Review of production part approval process data
- Inspection of products or verification of services upon receipt
- Review of delegations of product verification to the external provider

8.4.3 Information for External Providers

- Notify the organization of changes to process, products, or services including changes of their external providers or location of manufacture and obtain the organizations approval
- Right of access by the organization, their customer, and regulatory authorities to the applicable areas of facilities and to applicable documented information, at any level of the supply chain
- Ensuring that persons are aware of:
 - Their contribution to product or service conformity
 - Their contribution to product safety
 - The importance of ethical behavior

8.5.1 Control of Production and Service Provision

- Characteristics of the products to be produced, the services to be provided, or the activities to be preformed
- Results to be achieved
- Availability and use of suitable monitoring and measuring resources
- The implementation of monitoring a measurement activity at appropriate stages to verify that criteria for control of processes or outputs, and acceptance criteria for products and services, have been met
- Use of suitable infrastructure and environment for the operation of processes



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- The appointment of competent persons including any required qualification
- Validation, and periodic revalidation, of the ability to achieve planned results of the processes for production and service provision where the resulting output cannot be verified by subsequent monitoring or measurement
- Implement of actions to prevent human error
- The establishment of criteria for workmanship

- Accountability for all products during production
- Control and monitoring of identified critical items, including key characteristics, in accordance with established processes
- Determination of methods to measure variable data
- Identification of in-process inspection/verification points when adequate verification of conformity cannot be performed at later stages
- Availability of evidence that all production and inspection/verification operations have been completed as planned, or as otherwise documented and authorized
- Provision for the prevention, detection, and removal of foreign objects
- Control and monitoring of utilities and supplies
- Identification and recording of products released for subsequent production use pending completion of all required measuring and monitoring activities, to allow recall and replacement if it is later found that the product does not meet requirements

8.5.1.1 Control of Equipment, Tools, and Software Programs

- Equipment, tools, and software programs used to automate, control, monitor, or measure production processes shall be validated prior to final release for production and shall be maintained

8.5.1.3 Production Process Verification

- To meet requirements production verification activities should be in place
- Running a new part for the first time needs verification on production processes, the production itself and tooling known as First Article Inspection
- IPI must be informed, in writing, within 24 hours of non-conformance discovery.

8.7 Control of Nonconforming Outputs

- Take necessary actions to contain the effect of the nonconformity
- Defining corrective actions for nonconforming products and services detected after delivery, as appropriate to their impacts

2. Supplier Sub-Tier Control:

The supplier, as the recipient of the purchase order and or contract, is responsible for meeting all specified technical and quality requirements, whether the work is performed by the supplier or by the supplier's sub-tier sources. When the supplier uses a sub-tier source to perform services or work on products, the supplier shall include "Flow-Down" on purchase orders to his or her sub-tier sources, of all the applicable technical and quality requirements from the Industrial Precision purchase order, including when applicable the requirement to document and control "key characteristics" and to furnish objective evidence (test reports, certifications, charts, etc...) when required by the specific clause called out on the purchase order.

3. Unauthorized change and or substitutions.

The supplier may not make any changes and or substitutions to any products or services which are required by the purchase order, drawing, specification, standard, and or other applicable documents without prior written authorization by Industrial Precision. Suppliers and or supplier's sub-tier may be subject to an on-site review of proposed change at his or her facility.

4. Source Inspection:

The supplier shall notify Industrial Precision's purchasing agent to arrange for source inspection following supplier's inspection, and 48 hours prior to the date of availability for inspection by Industrial Precision. The supplier shall furnish, at no cost, necessary facilities and equipment, to Industrial Precision, Inc. source inspector.

4.1 -Parts are subject to Inspection at the supplier's plant prior to shipment.



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4.2 -Parts are subject to Inspection prior to ASSEMBLY at the supplier's plant.

4.3 -Parts are subject to GOVERNMENT Source Inspection at the supplier's plant.

NOTE: If Government inspection is required prior to shipment from your plant, upon receipt of this order, promptly notify the Government Representative who normally services your plant so that appropriate planning for Government inspection can be accomplished.

5. Inspection Reports:

Dimensional inspection reports are required for all manufactured items. As a minimum, these reports must contain the nature and number of observations made, the results of the observations, and by whom the inspection was performed.

NOTE: ANY SAMPLING PLAN MUST BE APPROVED BY INDUSTRIAL PRECISION QUALITY ASSURANCE DEPARTMENT PRIOR TO USE.

5.1 First Article Inspection:

Supplier will submit First Article documentation which shall include a dimensional inspection report (actual dimensions), X-Ray films, test data, etc. with first shipment of parts. First Article must be identified (tagged).

5.2 Final Inspection Report:

Supplier will submit with each shipment a completed Final Inspection Report.

6. Raw Material, Castings, Forgings:

If there is more than one heat lot of material, individual material lot integrity, with positive traceability to the delivered product, and applicable material test report must be maintained.

6.1 Supplied by Industrial Precision - Strict accountability of material furnished by Industrial Precision for use on this order shall be maintained by supplier. Supplier shall certify that

(a) All product(s) delivered on this order was manufactured from material furnished by Industrial Precision,

(b) From the material heat or lot numbers identified on the material or Industrial Precisions shipper; and

(c) No material substitution was made. If material was dropped shipped a Material Release Authorization must be obtained from Industrial Precision Quality prior to beginning production.

6.2 Supplier furnished (Mill cert required - must include chemical & physical analysis). **NOTE; If more than one heat lot is supplied per part number, parts MUST BE DIRECTLY TRACEABLE TO APPLICABLE HEAT LOTS.**

7. Packing Slip required with each shipment:

As a minimum, packing slip must contain the following: part number, revision, part name, quantity, & serial /lot number if applicable.

8. Special Process Certification and Sources:

Suppliers of special processes shall ensure qualifications of personnel performing services related to product quality.

As a minimum, suppliers should have records of training for personnel and available for review upon request.

8.1 One copy of the special process certification is required (H.T., Passivate, Plating, etc.) with each shipment.

8.2 Only Industrial Precision approved process sources may be used (contact purchasing manager at Industrial Precision for approved process sources listing).

9. Certificate of Conformance:

Supplier shall furnish a certification with each shipment that the product or service complies with all purchase order requirements, drawings, & specifications. The certification shall identify as a minimum, part number, including revision, purchase order number, serial / lot number (if applicable), quantity, supplier name & address, signature & title of a responsible member of supplier's organization.

10. Packaging, Preservation, & Shipping:

Supplier shall assure that all items are adequately protected from damage, loss, deterioration, degradation or substitution. Each container must be properly marked or labeled to maintain content identity, its origin, & destination.

11. Control of Non-Conforming Material or Products:

Suppliers system must make provisions for prompt identification, documentation, & submittal to buyer for disposition of any non-conforming product found during manufacturing or inspection operations, and a system to implement effective corrective action to prevent recurrence. In those instances where it is indicated that non-conforming products may have been shipped, the system shall provide for prompt buyer notification. Nonconforming products must be segregated (pending disposition, i.e., scrap, rework, etc.) to prevent return to production or shipment.

12. Pre-Production Preliminary Approval:



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Products on this purchase order have been identified as Critical and require additional controls for processing operations, manufacturing, and inspection. The Supplier shall notify Industrial Precision at least one week prior to production at which Time Industrial Precision may schedule an on-site review for approval of but not limited to supplier's equipment, methods, processes, and controls to be used during production run. Post approval, any subsequent changes proposed by the supplier Shall be submitted to Industrial Precision for review and approval prior to implementation in production.

13. Mercury Free Certification:

Supplier shall provide a certificate of conformance covering each shipment, worded substantially as follows: "This is to certify that all product(s), P/N _____, Revision _____, delivered on this Packing List/Shipper No. _____, under Industrial Precision Purchase Order No. _____, Line Item No. _____, Serial/Lot number (if applicable) _____, have not, during the manufacturing and/or processing operations performed by Supplier or Suppliers sub-tier sources, come in contact with or have been exposed to Mercury bearing instruments or equipment, or Mercury in any other form."

Company Name: _____ Date: _____
Signed by: _____ Title: _____
Printed Name: _____

14. Ozone Depleting Substances ("ODS's):

With respect to goods delivered to purchaser on or after May 15, 1993, Supplier agrees to comply with the U.S. clean air act amendments of 1990 regarding warning statements on products manufactured with ODS's, products containing ODS's, and containers containing ODS's. The need for warning statements, the specific wording of statements, and the placement of statements shall be in accordance with requirements of the U.S. Environmental Protection Agency implementing regulations.

15. Statistical Process Control (SPC):

Statistical techniques shall be used to control manufacturing processes for Industrial Precision Procurement.

Notes:

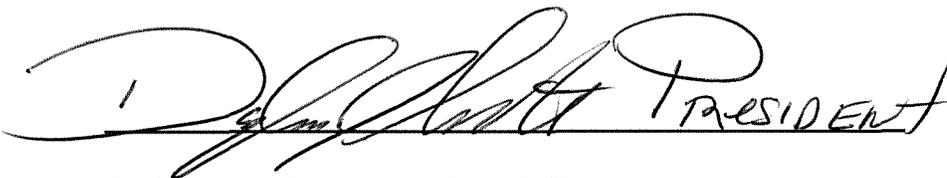
- 15.1 Key Characteristics are located on Industrial Precisions' process sketches, process control plan and/or as specified.
- 15.2 The supplier shall furnish with each shipment, accurate process capability (Cpk) values, minimum of 1.5 required, and have control charts available for audit at Industrial Precision's request. Data/Control Charts should be traceable to each lot.

16. Right of Entry:

Industrial Precision, Inc. and its customers reserve the right of entry into your facility at anytime during the performance of contract/purchase order to perform inspections/audits related to said contract/purchase order.

17. Foreign Object Damage:

Handling of material will be such to prevent invasion by foreign objects.

 PRESIDENT 9/13/18

Authorized Signature, Title & Date

 9/13/18

Quality Manager Signature & Date