

**CODE                      REQUIREMENT**
**Q1      GOVERNMENT SOURCE INSPECTION**

Government inspection is required prior to shipment from the Supplier's facility. Upon receipt of this order, the Supplier shall promptly notify the Government Representative who normally services the Supplier's facility so that appropriate planning for Government inspection can be accomplished. In the event that the Government Representative's office cannot be located, the Buckeye Shapeform Purchasing Agent must be notified immediately. A copy of this contract shall be furnished to the Government Representative upon receipt.

**Q2      CALIBRATION SYSTEM**

The Supplier must maintain a calibration system that is in compliance with ANSI Z 540-1 (latest revision). Calibration records must show traceability of the stands used for calibration to the National Institute of Standards and Technology (NIST). The Supplier is subject to an audit by Buckeye Shapeform at any time to verify compliance to this requirement.

**Q3      QUALITY ASSURANCE SYSTEM**

The Supplier shall have a Quality Assurance System conforming to the requirements of ISO 9001 (latest revision) or AS9100 (latest revision). All provisions therein shall apply to this Purchase Order. Substantiation information shall be made available upon request.

**Q4 - A    SAMPLING INSPECTION**

Sampling inspection procedures used by the Supplier must be in compliance with ANSI/ASQC Z1.9-1993 or ANSI/ASQC Z1.4-1993.

**Q4 - B    (SPC) STATISTICAL PROCESS CONTROL**

The supplier shall establish, document, and maintain statistical techniques to control and verify process capability and/or product key characteristics in the manufacture of the items purchased on this purchase order. Documentation is required on all dimensions, characteristics specifically listed on this Purchase Order. Minimum evidence of SPC documentation to Buckeye Shapeform shall be written certification listing each required dimension / characteristic, process Cp, process Cpk, and process Mean, and signed by the Supplier's Quality Representative.

**Q5      FIRST ARTICLE INSPECTION**
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A First Article Inspection is required from the initial production against this purchase order and submitted to Buckeye Shapeform. Buckeye Shapeform Purchasing Dept. will notify the Supplier in writing of the First Article approval. The approval to ship the balance of the order will be given by Buckeye Shapeform Purchasing, in writing, upon First Article approval.

**Q6      INSPECTION DATA AND LOT NUMBERING**

Verifiable quantitative test and / or inspection data is required with each lot submitted on this Purchase Order. Parts shall be submitted with each lot serialized and records maintained by Supplier per lot submitted.

**Q7      CERTIFICATION OF COMPLIANCE**

A dated Certification of Compliance (C of C), signed by the Supplier's Quality Representative, must accompany each lot shipped to Buckeye Shapeform indicating that all requirements of the purchase order, drawings and specifications have been met.

**Q8      CERTIFIED TEST REPORTS**

Certified Physical / Chemical Test Reports are required and must accompany each shipment for each item on this Purchase Order. Where specified by purchase order, Buckeye Shapeform specification or industry standard, these reports shall include actual chemical analysis, grain size, hardness, tensile/yield strength and percent elongation. Applicable test and material standards must be indicated on test reports. Actual test report data must be traceable to each heat lot supplied. These test reports must be stamped or signed and dated by an authorized supplier Quality Representative including title.

**Q9      PART/LOT TRACEABILITY**

The supplier shall maintain traceability of all materials back to the raw material supplier and provide documentation demonstrating this traceability. Documentation shall provide traceability of all processing steps from raw material through delivery to Buckeye Shapeform.

**Q10     PRESERVATION/PACKAGING**

Parts and/or material furnished on this purchase order shall be preserved, packed, and packaged in a "Best Commercial" manner, to prevent deterioration or damage during shipment. Specific requirements deviating from "Best Commercial" method shall be defined within the purchase order.

**Q11 SOURCE INSPECTION**

Buckeye Shapeform source inspection, at Supplier's facility, is required for all items submitted against this Purchase Order. Shapeform Quality Assurance will notify Supplier of the extent and points of the Supplier's manufacturing cycle that will require these inspections. Supplier will notify Buckeye Shapeform twenty four (24) hours in advance of when material will be ready for inspection. Source inspection is to be performed prior to shipment unless otherwise specified.

**Q12 INSPECTION ACCEPTANCE**

Final acceptance of finished goods shall be through quality assurance inspection at Buckeye Shapeform.

**Q13 RIGHT OF ENTRY**

All processing performed against this purchase order may be subject to review by Buckeye Shapeform, Buckeye Shapeform's customer, and/or the Government at any time during the duration of the purchase order. The supplier guarantees the right of access to their facilities, quality related records, and quality related data. Adequate notice will be given to the supplier, in the event this should occur.

**Q14 UNAUTHORIZED CHANGES**

The Supplier shall make no changes to work under this purchase agreement, including design, manufacturing processes, materials, or otherwise, which may affect Form, Fit or Function of the items, without prior written approval by Buckeye Shapeform.

**Q15 SPECIAL PROCESS CERTIFICATION**

Certification and relevant test data must be provided for any special processing performed on the materials/parts associated with this order. These processes include but are not limited to Heat Treating, Plating, Paint, Welding and NDT.

**Q16 RECORD RETENTION**

All certifications, manufacturing and quality documentation relating to product or processes supplied on this order must be retained and available for inspection by Buckeye Shapeform personnel or their customer for a period of six years. In lieu of retention at the supplier, records may be provided to Buckeye Shapeform for retention.

**Q17 QUALITY FLOW DOWN TO SUB-TIER SUPPLIERS**

The supplier's quality system shall assure that all relevant purchase order requirements, including key characteristics are flowed down to sub-tier suppliers. The supplier's sub-tier suppliers are responsible for compliance with the same specifications and requirements as specified on this purchase order.

**Q18 NONCONFORMING MATERIAL**

The supplier shall notify Buckeye Shapeform of nonconforming products as soon as discovered by the supplier. Authority to ship discrepant material must be obtained from Buckeye Shapeform by the supplier prior to shipment. Discrepant material shipped without prior written approval shall be rejected and returned at the supplier's expense.

**Q19 RAW MATERIAL TEST SPECIMENS**

Items delivered against this purchase order must be accompanied by raw material test specimens representative of the material and processing used in their manufacture. Specimens shall be submitted with the initial shipment from each lot or process batch delivered against this purchase order.

**Q20 SUBCONTRACT APPROVAL**

The supplier shall not subcontract any part of the manufacturing or finishing process of any part on this purchase order without prior written approval from Buckeye Shapeform.

**Q21 FOREIGN OBJECT DAMAGE (FOD) PROGRAM**

Buckeye Shapeform suppliers shall ensure work is accomplished in a manner preventing foreign objects or material in deliverable items. The Supplier shall maintain material handling, parts protection, work area housekeeping, tool accountability, hardware accountability, parts and materials in a manner sufficient to preclude the risk of FOD incidents.