



Quality Assurance Provisions

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Author: Andi Youmans	Revision: 1.0	Rev. Date: 1/10/2024

BUCKEYE SHAPRFORM PURCHASE ORDER ATTACHMENT "A"

CODE REQUIREMENT

Q1 SUPPLIER MANAGEMENT

Supplier performance rating will be determined by:

- results of the annual supplier survey or on-site audit,
- the supplier's ability to maintain a minimum on-time delivery rate of 90%, and
- any non-conformances issued by Buckeye Shapeform.

Q2 BSF 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.

Q3 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.

Q4 FIRST ARTICLE INSPECTION

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.

CODE REQUIREMENT

Q5 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.

Q6-A SAMPLING INSPECTION

Sampling inspection procedures used by the Supplier must be performed in accordance with ANSI/ASQC Z1.4, with an AQL of 1.0.

Q6-B GOVERNMENT SAMPLING INSPECTION

Sampling inspection procedures used by the Supplier must be performed in accordance with MIL-STD-1916, Level III.

Q6-C 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.

Q7 QUALITY MANAGEMENT SYSTEM

The Supplier shall have a Quality Management System conforming to the requirements of ISO 9001:2015 and/or AS9100D. All provisions therein shall apply to this Purchase Order. A copy of the Supplier's Management System Certificate shall be made available upon request.

Q8 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.



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CODE REQUIREMENT

Q9 COUNTERFEIT PARTS PREVENTION

Supplier shall establish and maintain controls which seek to prevent the purchase and delivery of Suspect and Counterfeit Parts to Buckeye Shapeform. Supplier shall only purchase products to be delivered or incorporated as Work to Buckeye Shapeform directly from the Original Component Manufacturer (OCM)/Original Equipment Manufacturer (OEM) or through an OCM/OEM authorized distributor chain. Work shall not be acquired by the supplier and furnished to Buckeye Shapeform from independent distributors or brokers unless approved in advance and in writing by Buckeye Shapeform.

Supplier shall immediately notify Buckeye Shapeform with the pertinent facts if the Supplier becomes aware that it has furnished Suspect or Counterfeit parts. After such notification, when requested by Buckeye Shapeform, Supplier shall provide copies of OCM/OEM documentation in its possession that authenticates traceability (up to and including other testing validation methods) of the affected items to the applicable OCM/OEM.

Suspect counterfeit parts and/or materials shall be immediately quarantined to prevent parts/materials from getting back into component/materials supply chain until authenticity validation can be conducted.

In the event that the Supplier delivers items under this Contract that are determined to be counterfeit, Supplier shall, at its expense, (i) promptly replace such Counterfeit items with items conforming to the requirements of this Contract, and (ii) reimburse BuckeyeShapeform for all reasonable, direct costs incurred for the removal and replacement of Counterfeit items, including any testing costs necessitated by the removal and replacement, if any. Suppliers eligible for utilization of the Government-Industry Data Exchange Program (GIDEP) shall utilize the GIDEP process to alert industry of encountered counterfeit parts. Supplier is prohibited from shipping material for which a GIDEP Alert has been issued. The supplier agrees to support Buckeye Shapeform in GIDEP compliance efforts. Also the Supplier shall not ship any suspected counterfeit parts.

CODE REQUIREMENT

Q10 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.

Q11-A CHANGE NOTIFICATION

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.

Q11-B GOVERNMENT CHANGE NOTIFICATION

The supplier shall notify Buckeye Shapeform of any changes to processes, products, or services, including changes of their external providers or location of manufacture, and obtain the organization's approval.

Q12 SUB-TIER SUPPLIER FLOW DOWN

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.

Q13 TEST SPECIMENS (COUPONS)

Items delivered against this purchase order must be accompanied by a test specimen 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.

Q14 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.



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Q15 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.

Q16 COMPETENCE AND AWARENESS

Buckeye Shapeform expects its suppliers to ensure that its employees demonstrate competence, including any required qualifications.

Employees must also understand: a. their contribution to product or service conformity in the delivery of Buckeye Shapeform Products b. their contribution to Buckeye Shapeform's product safety c. the importance of their ethical behavior in all transactions.

Q17 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.

Q18-A CERTIFICATE 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.

Q18-B CERTIFICATE OF ORIGIN

A dated Certification of Origin (C of O), signed by the Supplier's Quality Representative, must accompany each lot shipped to Buckeye Shapeform declaring in which country the purchased product was manufactured.

CODE REQUIREMENT

Q18-C CERTIFIED TEST REPORT

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.

Q19 SPECIAL PROCESSES

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.

Q20 CALIBRATION SYSTEM

The Supplier must maintain a calibration system that is in accordance with ISO 17025:2017. 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.



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REVISION HISTORY

REVISION	DATE	DESCRIPTION OF CHANGE	APPROVED BY
1.0	1/10/2024	Major Rewrite Supersedes MAT0102	Andi Youmans