

# VACCO Industries

10350 Vacco St.  
S. El Monte, CA 91733

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**PNM 101 – 400 SERIES  
QUALITY ASSURANCE REQUIREMENTS**

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## QUALITY ASSURANCE REQUIREMENTS

### 401 STANDARD TERMS AND CONDITIONS

#### A. SPECIFICATION EFFECTIVITY

WHEN A SPECIFICATION IS LISTED WITHIN THE PURCHASE ORDER, AND NO SPECIFIC REVISION IS SPECIFIED, ANY REVISION THAT IS AVAILABLE SHALL APPLY.

#### B. VACCO PROPRIETARY PROCEDURE AND DRAWING REQUIREMENTS

DRAWINGS AND PROCEDURES FURNISHED WITH THIS PURCHASE ORDER ARE PROPRIETARY IN NATURE. VACCO INDUSTRIES RETAINS THE EXCLUSIVE RIGHTS TO THESE DOCUMENTS, AND THEY MUST BE RETURNED UPON COMPLETION OF THIS PURCHASE ORDER. FAILURE TO RETURN THESE DOCUMENTS WILL DELAY ACCEPTANCE AND PAYMENT.

#### C. FRAUDULENT STATEMENT NOTIFICATION

THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY BE PUNISHED AS A FELONY UNDER FEDERAL STATUTES, INCLUDING FEDERAL LAW, TITLE 18, CHAPTER 47.

#### D. HANDLING PRECAUTIONS

SUPPLIER TO EXERCISE EXTREME CARE IN THE HANDLING OF PARTS TO ENSURE THAT NO DENTS, SCRATCHES, ETC., OCCUR. THE USE OF PROTECTIVE END CAPS IS REQUIRED ON ALL TUBE END PARTS. PROTECTIVE CAPS WILL BE FURNISHED BY VACCO.

#### E. PACKING REQUIREMENTS

FOR CUSTOM MACHINED, EXTERNALLY THREADED, GROUND OR MACHINED MATERIAL/HARDWARE, THE EXTERNAL AREAS MUST BE PROTECTED BY PLASTIC WEBBING OR PROVIDED IN SEGREGATED MANNER TO PROHIBIT DAMAGE DURING TRANSPORT TO VACCO INDUSTRIES.

ALL ITEMS ARE TO BE PACKAGED IN SUITABLE CONTAINERS FOR PROTECTION IN SHIPMENT AND STORAGE, AND IN ACCORDANCE WITH APPLICABLE SPECIFICATIONS. EACH CONTAINER OF A MULTIPLE CONTAINER SHIPMENT SHALL BE IDENTIFIED TO SHOW THE NUMBER OF THE CONTAINER AND THE TOTAL NUMBER OF CONTAINERS IN THE SHIPMENT AND THE NUMBER OF THE CONTAINER CONTAINING THE PACKING SLIP. ALL SHIPMENTS BY SUPPLIER SHALL INCLUDE A PACKING SHEET CONTAINING VACCO'S PURCHASE ORDER NUMBER, QUANTITY, PART NUMBER/SIZE, DESCRIPTION OF THE ITEMS SHIPPED, AND APPROPRIATE EVIDENCE OF INSPECTION. MATERIALS FROM DIFFERENT PURCHASE ORDERS SHALL BE LISTED ON SEPARATE PACKING SLIPS.

#### F. MATERIAL SAFETY DATA SHEETS

SUPPLIER MUST PROVIDE MATERIAL SAFETY DATA SHEETS MEETING THE REQUIREMENTS OF 29 CFR 1910.1200 (G) AND THE LATEST VERSION OF FEDERAL STANDARD NO. 313 IN EFFECT ON THE DATE OF THIS PURCHASE ORDER FOR ALL HAZARDOUS MATERIALS (FAR 252.223-7004). DATA SHALL BE SUBMITTED FOR ALL ITEMS INCLUDED IN THIS PURCHASE ORDER, WHETHER OR NOT THE SUPPLIER IS THE ACTUAL MANUFACTURER OF THE ITEMS. FAILURE TO PROVIDE DOCUMENTS WILL DELAY ACCEPTANCE AND PAYMENT.

#### G. SHEET OR STRIP STOCK - METALLIC

A. SHEET/STRIP MATERIAL MUST BE OF CHEMICAL MILLING QUALITY. SURFACES SHALL BE FREE FROM SCRATCHES, PITS, INCLUSIONS AND MILL ROLLING MARKS. ADDITIONALLY, NO WAVINESS OR CURL ON THE EDGES OF THE SHEET/STRIP MATERIAL WILL BE ACCEPTED.

B. SHEET/STRIP MATERIAL SHALL BE FLAT WITHIN 1/2 INCH T.I.R. OVER AN 18 INCH LENGTH, AND WITHIN 1/4 INCH T.I.R. OVER A 12 INCH WIDTH FOR MATERIAL OVER .010 INCH THICKNESS.

C. WHEN A COIL IS TO BE PROVIDED, THE MAXIMUM INDIVIDUAL COIL WEIGHT SHALL NOT EXCEED 300 POUNDS AND HAVE A MINIMUM CORE I.D. OF 16 INCHES.

D. MATERIAL PROVIDED MUST BE DEGREASED (28 DRY FINISH) TO BE ACCEPTABLE.

E. UPON CUTTING AN 18 INCH LONG SAMPLE OF COIL, ON A FLAT SURFACE, COIL SET CANNOT EXCEED 1/8 INCH ON EITHER END FOR THE MATERIAL UNDER .010 INCH THICKNESS.

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## H. TUBING – METALLIC

SUPPLIER SHALL PROVIDE A CERTIFICATION THAT STIPULATES THE TUBING IS IN FACT "SEAMLESS" IN CONDITION. FAILURE TO PROVIDE THIS STATEMENT ON CERTIFICATION DOCUMENTS SHALL DELAY ACCEPTANCE AND PAYMENT.

## I. O-RINGS AND ELASTOMERS

ALL SYNTHETIC O-RINGS AND ELASTOMERS PROVIDED TO VACCO INDUSTRIES SHALL BE INDIVIDUALLY SORTED AND PACKAGED. EACH PACKAGE SHALL HAVE A MINIMUM MARKING REQUIREMENT:

QUANTITY PER BAG  
VACCO PART NUMBER AND REVISION  
MANUFACTURER PART NUMBER  
COMPOUND CODE  
SPECIFICATION NUMBER AND REVISION  
CURE DATE IN QUARTERS  
BATCH CODE  
VACCO PURCHASE ORDER NUMBER  
EXPIRATION DATE PER MIL-HDBK-695

COMPONENTS SHALL NOT HAVE EXCEEDED 25% OF THEIR SHELF LIFE (AS DEFINED BY MIL-HDBK-695) AT THE TIME OF SHIPMENT

## J. RAW MATERIAL WELD REPAIR PROHIBITION (OTHER THAN CASTINGS)

IF ANY WELD REPAIR IS NECESSARY DURING THE FABRICATION PROCESS (OTHER THAN CASTINGS), VACCO INDUSTRIES APPROVAL MUST BE OBTAINED PRIOR TO THE PERFORMANCE OF ANY SUCH REPAIR. FAILURE TO OBTAIN APPROVAL WILL JEOPARDIZE ACCEPTANCE AND PAYMENT.

## K. 1. QUALIFIED PRODUCTS LIST IDENTIFICATION

THE ITEM(S) LISTED ON THIS PURCHASE ORDER THAT ARE CONTROLLED BY THE GOVERNMENT-ISSUED QUALIFIED PRODUCTS LIST MUST BE PROCURED FROM A QUALIFIED SOURCE NOTED WITHIN THAT DOCUMENT AND MUST CONFORM TO THE TESTING AND PROCESSING REQUIREMENTS OF THE LATEST REVISION OF THE DESIGNATED SPECIFICATION.

## 2. QUALIFIED PRODUCTS LIST CERTIFICATION

SELLER OF QUALIFIED PRODUCTS (GOVERNMENT OR BUYER) SHALL SUPPLY WITH EACH SHIPMENT. TWO (2) LEGIBLE AND REPRODUCIBLE COPIES OF A CERTIFICATION STATING THAT THE PRODUCT IS A QUALIFIED PRODUCT UNDER THE APPLICABLE GOVERNMENT OR BUYER SPECIFICATION REQUIREMENTS AND THAT HIS APPROVAL IS CURRENT. IF THE QUALIFIED PRODUCT IS INCORPORATED INTO A PRIME ITEM, THE CERTIFICATION MUST ATTEST TO THIS FACT AND DESIGNATE THE SUPPLIER'S NAME AND APPROVAL NUMBER.

## L. RAW MATERIAL TRACEABILITY

SUPPLIER SHALL IDENTIFY EACH PIECE OF MATERIAL AND EACH TEST REPORT TO PROVIDE TRACEABILITY TO THE CORRESPONDING HEAT/LOT, CASTING, FORGING OR BATCH NUMBER. THIS MARKING SHALL BE APPLIED WITH WATERPROOF INK OR OTHER PERMANENT PROCESS.

## M. VACCO-SUPPLIED MATERIAL

ANY MATERIAL SUPPLIED TO THE SUPPLIER WITH THIS PURCHASE ORDER SHALL BE USED EXCLUSIVELY. SUPPLIER SHALL NOT SUBSTITUTE ANY MATERIAL FOR MATERIAL PROVIDED. ALL MATERIAL NOT USED SHALL BE RETURNED TO VACCO.

## N. ITEM LOT/HEAT NUMBER INDIVIDUALITY

SUPPLIER TO PROVIDE EACH PURCHASE ORDER LINE ITEM FROM ONE LOT/HEAT. IN THE EVENT THAT THIS IS NOT POSSIBLE, NOTIFY VACCO INDUSTRIES' PURCHASING IMMEDIATELY FOR DISPOSITION.

## O. TITANIUM MATERIAL PROHIBITION

TITANIUM MUST NOT COME INTO CONTACT WITH TRICHLOROETHYLENE OR FREON. ANY FLUORINATED LUBRICANTS ARE PROHIBITED FOR USE ON THIS HARDWARE. CLEANING SHALL BE PERFORMED ONLY WITH ISOPROPYL ALCOHOL IN ACCORDANCE WITH THE CLEANING PROCEDURE APPROVED FOR THIS JOB ORDER. HANDLING SHALL BE PERFORMED WITH GLOVE-PROTECTED HANDS AS BARE

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SKIN CONTACT IS PROHIBITED. TOOLS SUCH AS GRINDING WHEELS WHICH ARE USED ON TITANIUM MUST BE CONTROLLED IN SUCH A WAY THAT THEY DO NOT COME INTO CONTACT WITH OTHER ALLOYS.

### **P. SAMPLING**

IF THE SUPPLIER EMPLOYS AN INSPECTION SAMPLING PLAN, THE LATEST REVISION OF MIL-STD-105 SHALL APPLY. ANY EXCEPTIONS MUST BE APPROVED IN WRITING BY VACCO INDUSTRIES PRIOR TO IMPLEMENTATION.

### **Q. FIRST ARTICLE REPORT**

WHENEVER THE SUPPLIER FABRICATES A PART NUMBER OR A PART NUMBER REVISION FOR THE FIRST TIME, THE SUPPLIER SHALL COMPLETE A FIRST ARTICLE REPORT ON THE FIRST CONFORMING ARTICLE. THIS REPORT SHALL CONTAIN THE ACTUAL VALUES OF ALL DRAWING AND OTHER CONTRACTUAL REQUIREMENTS, INCLUDING ALL DRAWING NOTES. THIS REPORT SHALL BE MAINTAINED BY THE SUPPLIER, AND SHALL BE MADE AVAILABLE TO THE VACCO INDUSTRIES UPON REQUEST.

### **R. THIOKOL STW7-3776**

THE RELIABILITY REQUIREMENTS STIPULATED IN THIOKOL DOCUMENT STW7-3776 ARE IMPOSED ON THIS PURCHASE ORDER.

### **S. AGE CONTROLLED MATERIAL**

THE SUPPLIER IS REQUIRED TO SUBMIT WITH EACH SHIPMENT A CERTIFICATE ATTESTING CONFORMANCE OF ELASTOMERIC/ORGANIC MATERIALS/PARTS LISTED ON/OR USED IN THE PERFORMANCE OF THE PURCHASE ORDER. AGE CONTROLLED MATERIALS SHALL BE IDENTIFIED AND PACKAGED IN ACCORDANCE WITH THE APPLICABLE PROCUREMENT SPECIFICATION. OTHER AGE SENSITIVE MATERIALS SUCH AS ADHESIVES; SEALANTS; COATING MATERIALS; AND POTTING COMPOUNDS, ETC.; SHALL AS A MINIMUM BE IDENTIFIED ON EACH CONTAINER OR CERTIFICATION FOR MATERIAL USED IN PROCESSES WITH THE FOLLOWING.

- 1) MANUFACTURER'S NAME
- 2) BATCH NUMBER
- 3) STORAGE TEMPERATURE
- 4) COMPOUND/SPEC NUMBER
- 5) DATE OF MANUFACTURE
- 6) SHELF LIFE

### **T. AGE-SENSITIVE MATERIAL**

MATERIALS AND/OR ARTICLES HAVING AGE DEGRADATION CHARACTERISTICS MUST INCLUDE: MANUFACTURER'S RECOMMENDED EXPIRATION DATE, SHELF LIFE, CURE DATE, RETEST DATE, COMPOUND NUMBER, ETC. (AS APPLICABLE) SO AS TO INDICATE USEFUL LIFE OF THE MATERIAL AND SPECIAL STORAGE REQUIREMENTS MUST BE DEFINED. MATERIAL SHALL HAVE NO LESS THAN EIGHTY PERCENT (80%) OF ITS SHELF LIFE REMAINING AT TIME OF DELIVERY TO VACCO.

### **U. SPECIAL PROCESS**

(HEAT TREAT, NON-DESTRUCTIVE TEST, SURFACE TREATMENT, ETC.) SUPPLIERS AND/OR SUB-TIER SUPPLIERS MUST BE A CURRENT VACCO APPROVED SOURCE. NAMES OF APPROVED SUPPLIERS MUST BE OBTAINED FROM VACCO PURCHASING OR QUALITY ASSURANCE DEPARTMENTS TO ASSURE USE OF CURRENTLY APPROVED SUPPLIERS.

### **V. MANUFACTURING AND INSPECTION PLAN**

SELLER SHALL PREPARE AND MAINTAIN AN INSPECTION TEST PLAN OR SHOP TRAVELER WHICH PROVIDES RECORDS OF ALL PERFORMED OPERATIONS AND INSPECTION. AS A MINIMUM, ROUTING SHEETS SHALL SHOW OPERATIONAL SEQUENCE, INSPECTION AND TEST POINTS AND OTHER PERTINENT CONTROL MEDIA. THE DOCUMENTS SHALL PROVIDE TRACEABILITY TO PERSONNEL PERFORMING OPERATIONS AND INSPECTION, ACCEPTABILITY BY INSPECTION, AND REFERENCE OF ANY ASSOCIATED DOCUMENTS SUCH AS REJECTION REPORTS, PROCESSING PROCEDURES, INSPECTION PROCEDURES, ETC. ONE (1) REPRODUCIBLE COPY OF THE PLAN SHALL BE SUBMITTED TO THE BUYER FOR APPROVAL, PRIOR TO THE START OF PRODUCTION.

### **W. SUPPLIER'S VARIABLES DATA (WITH SHIPMENT)**

ONE (1) COPY OF ALL INSPECTION VARIABLES DATA WHICH RECORDS OBJECTIVE EVIDENCE OF ACCEPTANCE TRACEABLE TO EACH ASSEMBLY, SUB-ASSEMBLY, OR COMPONENT. THE FORM USED FOR DOCUMENTATION OF VARIABLES DATA SHALL BE OPTIONAL.

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**PNM 101 – 500 SERIES  
QUALITY ASSURANCE AND INSPECTION SYSTEM REQUIREMENTS**



# VACCO Industries

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## QUALITY ASSURANCE AND INSPECTION SYSTEM REQUIREMENTS

### 501 SUPPLIER QUALITY PROGRAM REQUIREMENTS (ISO 9001)

SUPPLIER QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO ISO 9001, LATEST REVISION. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THIS SPECIFICATION MUST BE IMPOSED ON THE SUBCONTRACTOR. VACCO INDUSTRIES RESERVES THE RIGHT TO PERFORM ON-SITE SURVEYS OR INSPECTIONS TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 502 SUPPLIER QUALITY PROGRAM REQUIREMENTS (AS 9100)

SUPPLIER QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO AS 9100, LATEST REVISION. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THIS SPECIFICATION MUST BE IMPOSED ON THE SUBCONTRACTOR. VACCO INDUSTRIES RESERVES THE RIGHT TO PERFORM ON-SITE SURVEYS OR INSPECTIONS TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 503 SUPPLIER QUALITY PROGRAM REQUIREMENTS (NHB 5300.4 [1C])

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO ANSI/ISO/ASQ Q9001-2000. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THIS SPECIFICATION MUST BE IMPOSED ON THE SUBCONTRACTOR. VACCO INDUSTRIES RESERVES THE RIGHT TO PERFORM ON-SITE SURVEYS OR INSPECTIONS TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 504 SUPPLIER QUALITY PROGRAM REQUIREMENTS (NHB 5300.4 [1B])

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO ANSI/ISO/ASQ Q9001-2000. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THIS SPECIFICATION MUST BE IMPOSED ON THE SUBCONTRACTOR. VACCO INDUSTRIES RESERVES THE RIGHT TO PERFORM ON-SITE SURVEYS OR INSPECTIONS TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 505 SUPPLIER CALIBRATION PROGRAM REQUIREMENTS (ISO 10012/ANSI/NCSL Z540-1-1994)

SUPPLIER'S CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO ISO 10012/ANSI/NCSL Z540-1-1994). IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON SUBCONTRACTOR (CALIBRATION TO ANSI/NCSL Z540-1-1994 IS MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 506 SUPPLIER QUALITY CONTROL SYSTEM REQUIREMENTS – LATEST REVISION

AS A MINIMUM, SUPPLIER SHALL ESTABLISH AND MAINTAIN AN ORDERLY SYSTEM THAT PROVIDES FOR DEFECT DETECTION, IDENTIFICATION, SEGREGATION AND CORRECTION. SUCH SYSTEM SHALL FURTHER COMPLY WITH ONE OR MORE OF THE FOLLOWING SPECIFICATIONS AS INDICATED ON THE PURCHASE ORDER.

- |                     |                                    |
|---------------------|------------------------------------|
| A. MIL-I-45208      | H. MIL-STD-1535 A                  |
| B. ISR-1E           | I. MIL-STD-45662                   |
| C. MIL-Q-9858       | J. ANSI / NCSL Z540-1-1994 MINIMUM |
| D. QRC-82           | K. ISO 10012                       |
| E. NHB 5300.4(1C)   | L. ISO 9001:2000 MINIMUM           |
| F. NHB 5300.4(1B)   | M. AS 9100B MINIMUM                |
| G. MIL-STD-1520 B/C | N. ANSI/ISO/ASQ Q9001-2000 MINIMUM |
| O. OTHER: _____     |                                    |

IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION IS MANDATORY). VACCO INDUSTRIES RESERVES THE RIGHT TO PERFORM ON-SITE SURVEYS OR INSPECTIONS TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 507 SUPPLIER QUALITY PROGRAM REQUIREMENTS (MIL-STD-1520 B/C)

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-Q-9858 AS SUPPLEMENTED BY QRC-82. SUPPLIER'S CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MIL-STD-45662 MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 508 SUPPLIER QUALITY PROGRAM REQUIREMENTS (MIL-STD-1535 A)

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-Q-9858 AS SUPPLEMENTED BY QRC-82. SUPPLIER'S CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MIL-STD-45662 MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

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### 509 SUPPLIER QUALITY PROGRAM REQUIREMENTS (MIL-STD-45662)

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-Q-9858 AS SUPPLEMENTED BY SUPPLIERS CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MIL-STD-45662 MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 510 SUPPLIER QUALITY PROGRAM REQUIREMENTS (ISO 9001:2000)

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-Q-9858 AS SUPPLEMENTED BY QRC-82. SUPPLIER'S CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MIL-STD-45662 MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 511 SUPPLIER QUALITY PROGRAM REQUIREMENTS (AS 9100)

SUPPLIER'S QUALITY PROGRAM REQUIREMENTS SHALL CONFORM TO AS SUPPLEMENTED BY SUPPLIERS CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MIL-STD-45662 MANDATORY). VACCO INDUSTRIES' TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

### 512 SUPPLIER QUALITY CONTROL SYSTEM REQUIREMENTS (MIL-STD-1520 B/C)

AS A MINIMUM, SUPPLIER SHALL ESTABLISH AND MAINTAIN AN ORDERLY SYSTEM THAT PROVIDES FOR DEFECT DETECTION, IDENTIFICATION, SEGREGATION AND CORRECTION. SUCH SYSTEM SHALL FURTHER COMPLY WITH ONE OR MORE OF THE FOLLOWING SPECIFICATIONS AS INDICATED ON THE P.O.:

- |                         |                     |                  |
|-------------------------|---------------------|------------------|
| A. MIL-I-45208 A        | E. NHB 5300.4(1C)   | I. MIL-STD-45662 |
| B. MIL-I-45208 A, ISR1  | F. NHB 5300.4(1B)   | J. ISO9001:94    |
| C. MIL-Q-9858 A         | G. MIL-STD-1520 B/C | K. OTHER _____   |
| D. MIL-Q-9858 A, QRC-82 | H. MIL-STD-1535 A   |                  |

SUPPLIER'S CALIBRATION PROGRAM REQUIREMENTS SHALL CONFORM TO MIL-STD-45662. IF WORK IS SUBCONTRACTED, THE APPLICABLE REQUIREMENTS OF THESE SPECIFICATIONS MUST BE IMPOSED ON THE SUBCONTRACTOR (CALIBRATION TO MILSTD-45662 MANDATORY). VACCO INDUSTRIES TO MAINTAIN SYSTEM AND PRODUCT QUALITY.

**VACCO Industries**

10350 Vacco St.  
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**PNM 101 – 600 SERIES  
INSPECTION REQUIREMENTS**

# VACCO Industries

10350 Vacco St.  
S. El Monte, CA 91733

## INSPECTION REQUIREMENTS

**UNLESS OTHERWISE SPECIFIED, MATERIAL SUPPLIED AND OPERATIONS PERFORMED BY THE SUPPLIER MUST BE INSPECTED BY THE FOLLOWING (REFERENCED) QUANTITATIVE AND VERIFIABLE METHOD.**

### 601 VACCO SOURCE INSPECTION

VACCO SOURCE INSPECTION IS REQUIRED AT YOUR FACILITY. NOTIFY VACCO INDUSTRIES' BUYER AT LEAST FORTY-EIGHT (48) HOURS IN ADVANCE OF THE TIME THE ITEMS ARE TO BE INSPECTED. INSPECTION DOCUMENTS, SPECIFICATIONS, DRAWINGS AND THE PURCHASE ORDER COVERING THE ITEMS ON THIS ORDER SHALL BE AVAILABLE FOR VACCO INSPECTION AT YOUR FACILITY.

**A. IN-PROCESS INSPECTION:** VACCO WILL ADVISE SUPPLIER OF THE IN-PROCESS INSPECTION POINTS FOR WHICH IN-PROCESS INSPECTION IS REQUIRED.

**B. FINAL INSPECTION:** INSPECTION REPORTS, CERTIFICATIONS, AND/OR SHIPPING DOCUMENTS MUST BE STAMPED AND/OR SIGNED BY THE VACCO SOURCE REPRESENTATIVE PRIOR TO SHIPPING.

**C. GOVERNMENT SOURCE INSPECTION:** IS REQUIRED PRIOR TO SHIPMENT FROM YOUR PLANT. UPON RECEIPT OF THIS PURCHASE ORDER, PROMPTLY NOTIFY THE GOVERNMENT REPRESENTATIVE WHO NORMALLY SERVICES YOUR PLANT, SO THAT APPROPRIATE PLANNING FOR GOVERNMENT INSPECTION CAN BE ACCOMPLISHED. ON RECEIPT OF THIS ORDER, PROMPTLY FURNISH A COPY TO THE GOVERNMENT REPRESENTATIVE WHO NORMALLY SERVICES YOUR PLANT OR, IF NONE, TO THE NEAREST ARMY, NAVY, AIR FORCE, OR DEFENSE SUPPLY AGENCY INSPECTION OFFICE. IN THE EVENT THE REPRESENTATIVE OR OFFICE CANNOT BE LOCATED, NOTIFY VACCO INDUSTRIES' BUYER IMMEDIATELY.

### 602 VACCO FIRST ARTICLE INSPECTION

VACCO INSPECTION OF THE FIRST ACCEPTABLE PIECE IS REQUIRED AT YOUR FACILITY PRIOR TO CONTINUING YOUR PRODUCTION RUN. NOTIFY VACCO INDUSTRIES' BUYER AT LEAST FORTY-EIGHT (48) HOURS IN ADVANCE OF THE TIME THE ITEMS ARE TO BE INSPECTED. INSPECTION DOCUMENTS, SPECIFICATIONS, DRAWINGS AND THE PURCHASE ORDER COVERING THE ITEMS ON THIS ORDER SHALL BE AVAILABLE FOR VACCO INSPECTION AT YOUR FACILITY. THE F/A ITEM AND REPORT SHALL BE PRESENTED, TOGETHER WITH ALL COMPLETED ITEMS, AT THE TIME OF SUCH INSPECTION.

### 603 VACCO WITNESSING OF FUNCTIONAL AND/OR ACCEPTANCE TESTING AT SUPPLIER'S FACILITY

SUPPLIER'S ACCEPTANCE/FUNCTIONAL TESTING MUST BE WITNESSED BY A VACCO REPRESENTATIVE. NOTIFY VACCO INDUSTRIES' BUYER AT LEAST FORTY-EIGHT (48) HOURS IN ADVANCE TO SCHEDULE VACCO WITNESSING. TEST DOCUMENTS, SPECIFICATIONS, DRAWINGS AND THE PURCHASE ORDER COVERING THE ITEMS ON THIS ORDER SHALL BE AVAILABLE FOR VACCO WITNESSING AT YOUR FACILITY.

### 604 GOVERNMENT SOURCE INSPECTION

GOVERNMENT SOURCE INSPECTION IS REQUIRED PRIOR TO SHIPMENT FROM YOUR PLANT. UPON RECEIPT OF THIS PURCHASE ORDER, PROMPTLY NOTIFY THE GOVERNMENT REPRESENTATIVE WHO NORMALLY SERVICES YOUR PLANT, SO THAT APPROPRIATE PLANNING FOR GOVERNMENT INSPECTION CAN BE ACCOMPLISHED. ON RECEIPT OF THIS ORDER, PROMPTLY FURNISH A COPY TO THE GOVERNMENT REPRESENTATIVE WHO NORMALLY SERVICES YOUR PLANT OR, IF NONE, TO THE NEAREST ARMY, NAVY, AIR FORCE, OR DEFENSE SUPPLY AGENCY INSPECTION OFFICE. IN THE EVENT THE REPRESENTATIVE OR OFFICE CANNOT BE LOCATED, NOTIFY VACCO INDUSTRIES' BUYER IMMEDIATELY.

### 605 100% FINAL INSPECTION BY SUPPLIER

SUPPLIER SHALL PERFORM 100% COMPONENT AND END ITEM FINAL INSPECTION OF ALL CHARACTERISTICS AND ITEMS LISTED ON BOTH THE PURCHASE ORDER AND DRAWING TO ASSURE CONFORMANCE TO THE SPECIFICATION REQUIREMENTS. SUPPLIER INSPECTION SHEETS MUST BE PROVIDED TO VACCO INDUSTRIES WITH THE HARDWARE AT THE TIME OF SHIPMENT. FAILURE TO PROVIDE THIS INFORMATION WILL DELAY ACCEPTANCE AND PAYMENT.

### 606 FIRST ARTICLE INSPECTION BY SUPPLIER

SUPPLIER TO PROVIDE EVIDENCE OF FIRST ARTICLE INSPECTION. SUPPLIER INSPECTION SHEETS MUST BE PROVIDED TO VACCO INDUSTRIES WITH THE HARDWARE AT THE TIME OF SHIPMENT. FAILURE TO PROVIDE THIS INFORMATION WILL DELAY ACCEPTANCE AND PAYMENT. THE "FIRST ARTICLE" INSPECTION REPORT SHALL INCLUDE ACTUAL DIMENSIONS, CHARACTERISTICS, AND METHODS USED FOR VERIFICATION, OF A SAMPLE FROM THE FIRST PRODUCTION RUN AND REPRESENTATIVE OF METHODS AND/OR PROCESSES USED. IF SOURCE INSPECTION IS REQUIRED, THE F/A ITEM AND REPORT SHALL BE PRESENTED, TOGETHER WITH ALL COMPLETED ITEMS, AT THE TIME OF SUCH INSPECTION.

## **VACCO Industries**

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### **607 SAMPLING INSPECTION**

ITEMS MAY BE INSPECTED BY THE SUPPLIER'S SAMPLING INSPECTION PLAN WHICH HAS BEEN PRE-APPROVED BY VACCO'S QUALITY ASSURANCE DEPARTMENT AND WHICH COMPLIES WITH ANSI/ASQC Z 1.4 (NORMAL, LEVEL II, SINGLE SAMPLING PROCEDURES).

### **608 CORRECTIVE ACTION REQUESTS**

WHEN CORRECTIVE ACTION REQUEST ARE ISSUED FOR NON-CONFORMANCES, SUPPLIER SHALL RESPOND WITHIN 15 DAYS WITH AN ANALYSIS OF THE CAUSE OF THE DISCREPANCY, A STATEMENT OF CORRECTIVE ACTION TAKEN TO PRECLUDE RECURRENCE, AND THE DATE (LOT, REVISION, ETC.) OF EFFECTIVITY OF SUCH ACTION.

### **609 SUPPLIER'S RESPONSIBILITY AND FINAL ACCEPTANCE**

. NEITHER SURVEILLANCE, SOURCE INSPECTION NOR TESTS PERFORMED BY VACCO OR ITS CUSTOMER, AT THE SUPPLIER'S, OR VACCO'S FACILITY, SHALL NECESSARILY CONSTITUTE FINAL APPROVAL OR ACCEPTANCE OF THE ITEMS OR GOODS ON THIS ORDER; NOR SHALL SUCH ACTIONS, OR THE SUPPLIER'S CONFORMANCE TO ALL APPLICABLE QUALITY REQUIREMENTS, RELIEVE THE SUPPLIER OF THE RESPONSIBILITY OF FURNISHING ITEMS IN CONFORMANCE TO THE REQUIREMENTS OF THIS ORDER. ALL ITEMS ARE SUBJECT TO FINAL INSPECTION, TESTS, ETC. AT VACCO'S FACILITY, NOT WITHSTANDING PRIOR PAYMENTS OR INSPECTIONS, AND FINAL ACCEPTANCE SHALL BE DETERMINED BY VACCO'S RECEIVING INSPECTION DEPARTMENT.

**VACCO Industries**

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**PNM 101 – 700 SERIES  
RAW MATERIAL REQUIREMENTS**

# VACCO Industries

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S. El Monte, CA 91733

## RAW MATERIAL REQUIREMENTS

### 701 MANUFACTURER/MILL TEST REPORTS

SUPPLIER SHALL FURNISH PHOTOCOPIES OF THE ORIGINAL MANUFACTURER/MILL PHYSICAL AND CHEMICAL TEST REPORTS, CONTAINING ALL ACCEPTANCE TEST RESULTS REQUIRED BY THE MATERIAL SPECIFICATIONS. TEST REPORTS PROVIDED SHALL CONFORM TO THE REQUIREMENTS OF GOVERNMENT SPECIFICATION DI-MISC-81020. (SEE ADDENDUM B (PNM-101-B) FOR A SAMPLE CERTIFICATION DATA REPORT.

IN ADDITION TO QUANTITATIVE CHEMICAL AND MECHANICAL PROPERTIES, THE MATERIAL TEST REPORTS SHALL INCLUDE THE CLASS, FORM, CONDITION (HEAT TREATED, ANNEALED, FORGED, COLD/HOT FINISHED, HOT/COLD DRAWN, ETC.), GRADE, TYPE AND FINISH, AS APPLICABLE, OF THE MATERIAL SUPPLIED.

THE MANUFACTURER/MILL TEST REPORTS MUST BE ON THE MANUFACTURER/MILL'S LETTERHEAD AND MUST CONTAIN THE NAME, TITLE OF THE COMPANY REPRESENTATIVE AND BE SIGNED BY THE SUPPLIERS' QUALITY REPRESENTATIVE OR MANAGEMENT. TRANSCRIPTION OF TEST REPORT DATA IS PROHIBITED, UNLESS THE ORIGINAL MANUFACTURER/ MILL TEST REPORT IS ATTACHED. STATEMENTS ON TEST REPORTS MUST BE POSITIVE AND UNQUALIFIED. DISCLAIMERS SUCH AS "TO THE BEST OF OUR KNOWLEDGE" OR "WE BELIEVE THE INFORMATION CONTAINED HEREIN IS TRUE" ARE NOT ACCEPTABLE.

ALL TEST REPORTS PROVIDED TO VACCO INDUSTRIES SHALL BE LEGIBLE AND CAPABLE OF REPRODUCTION THROUGH THREE (3) ITERATIONS OF COPYING, AND MUST BE LEGIBLE AFTER MICROFILMING.

IF MATERIAL IS PURCHASED FROM A DISTRIBUTOR, A CERTIFICATE OF CONFORMANCE FROM THE DISTRIBUTOR WHICH MEETS THE REQUIREMENTS OF CLAUSE 702 MUST ACCOMPANY THE MANUFACTURER/MILL TEST REPORT.

ALL CERTIFIED MATERIAL TEST REPORTS (EXCEPT FOR MILL OR INDEPENDENT LABORATORY TEST REPORT) SHALL INCLUDE A STATEMENT THAT "THE RESULTS SHOWN IN THIS REPORT ARE THE RESULTS OF TESTING PERFORMED BY OUR ORGANIZATION".

WHEN A SUPPLIER QUALITY DOCUMENT IS REVISED, IT SHALL BE IDENTIFIED AS A "CORRECTED copy" AND ALL CHANGES SHALL BE IDENTIFIED; I.E., (\*). THE REVISED DOCUMENT SHALL BE RE-SIGNED AND DATED.

### 702 CERTIFICATION OF CONFORMANCE

A CERTIFICATION OF CONFORMANCE ON YOUR COMPANY'S LETTERHEAD MUST ACCOMPANY ALL SHIPMENTS TO VACCO INDUSTRIES. THE CERTIFICATION MUST CONTAIN THE TYPED NAME AND TITLE AND BE SIGNED BY THE SUPPLIER'S QUALITY REPRESENTATIVE OR MANAGEMENT. FAILURE TO PROVIDE AN APPROPRIATE CERTIFICATION WILL DELAY ACCEPTANCE AND PAYMENT.

STATEMENTS ON MATERIAL CERTIFICATIONS MUST BE POSITIVE AND UNQUALIFIED. DISCLAIMERS SUCH AS "TO THE BEST OF OUR KNOWLEDGE" OR "WE BELIEVE THE INFORMATION CONTAINED HEREIN IS TRUE" ARE NOT ACCEPTABLE. CERTIFICATION OF CONFORMANCE SHALL CONTAIN ALL APPLICABLE INFORMATION INCLUDING PART NUMBERS, REVISIONS, DESCRIPTIONS AND QUANTITY. MATERIAL AND/OR PROCESSING SPECIFICATIONS AND THEIR REVISIONS ARE ALSO REQUIRED IF NOT ACCOMPANIED BY MATERIAL TEST REPORTS (CHEMICAL AND PHYSICAL OR ORIGINAL MILL TEST REPORTS). THIS ALSO APPLIES TO PROCESSING TEST REPORTS. ALL CERTIFICATIONS PROVIDED TO VACCO INDUSTRIES SHALL BE LEGIBLE AND CAPABLE OF REPRODUCTION THROUGH THREE (3) ITERATIONS OF COPYING, AND MUST BE LEGIBLE AFTER MICROFILMING.

A SAMPLE CERTIFICATION OF CONFORMANCE IS PROVIDED IN ADDENDUM B (PNM 101-B)

CERTIFICATION OF CONFORMANCE, DOCUMENTS AND REPORTS. VENDOR IS REQUIRED TO PROVIDE DOCUMENTED CERTIFICATION(S) THAT THE MATERIAL AND/OR SERVICES SUPPLIED AGAINST THIS ORDER MEET ALL APPLICABLE DRAWING, SPECIFICATION AND PURCHASE ORDER REQUIREMENTS. (A VACCO STANDARD CERTIFICATION FORM IS AVAILABLE UPON REQUEST). ALL CERTIFICATIONS, DOCUMENTS AND/OR REPORTS PROVIDED BY THE SUPPLIER RELATED TO THIS ORDER MUST BE LEGIBLE AND REPRODUCIBLE, AND SHALL CONTAIN THE FOLLOWING:

- 1) VACCO'S PURCHASE ORDER NUMBER
- 2) ITEM PART NUMBER, REVISION, NAME AND QUANTITY
- 3) APPLICABLE SPECIFICATION NUMBER(S)
- 4) COMPANY NAME
- 5) TITLE OF AUTHORIZED REPRESENTATIVE
- 6) PRINTED NAME OF AUTHORIZED REPRESENTATIVE
- 7) DATE AND SIGNATURE OF AUTHORIZED REPRESENTATIVE

RECORDS OF MATERIALS, PROCESSES AND TESTS MUST BE MAINTAINED FOR SEVEN (7) YEARS MINIMUM.

**VACCO Industries**

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**PNM 101 – 800 SERIES  
PROCESSING/FABRICATION REQUIREMENTS**

**TO BE USED WITH PURCHASE ORDERS ISSUED  
ON OR AFTER 3/7/12 BUT BEFORE 9/10/12.**



# VACCO Industries

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S. El Monte, CA 91733

## PROCESSING/FABRICATION REQUIREMENTS

### 801 CERTIFICATION OF CONFORMANCE

A CERTIFICATION OF CONFORMANCE ON YOUR COMPANY'S LETTERHEAD MUST ACCOMPANY ALL SHIPMENTS TO VACCO INDUSTRIES. THE CERTIFICATION MUST BE SIGNED BY THE SUPPLIERS QUALITY REPRESENTATIVE OR MANAGEMENT. THE CERTIFICATION SHALL CONTAIN THE TYPED NAME AND TITLE AND BE SIGNED BY THE SUPPLIER'S QUALITY REPRESENTATIVE OR MANAGEMENT. THE CERTIFICATION FAILURE TO PROVIDE AN APPROPRIATE CERTIFICATION WILL DELAY ACCEPTANCE AND PAYMENT.

IF VACCO SUPPLIED THE RAW MATERIAL, THE SUPPLIER MUST REFERENCE VACCO'S MATERIAL CERTIFICATION NUMBER (AS NOTED ON VACCO'S SHIPPING DOCUMENTS) ON ALL CERTIFICATIONS PROVIDED TO VACCO. IF THE RAW MATERIAL IS SUPPLIED BY THE SUPPLIER, THE REQUIREMENTS OF CLAUSE 701 ALSO APPLY.

WHEN THE VACCO PURCHASE ORDER REQUIRES CONFORMANCE TO SPECIFIC SPECIFICATIONS, THE CERTIFICATION MUST REFERENCE EACH SPECIFICATION NUMBER AND REVISION. IF WORK IS SUBCONTRACTED, A CERTIFICATION FROM THE SUBCONTRACTOR MUST BE PROVIDED TO VACCO IF THE WORK IS A SPECIAL PROCESS (I.E., NONDESTRUCTIVE TESTING, QUALIFICATION/ACCEPTANCE TESTING, HEAT TREATMENT, CHEMICAL CLEANING, PLATING, WELDING, ETC.) OR WHEN REQUIRED BY OTHER CLAUSES OF THE VACCO PURCHASE ORDER (I.E. MERCURY FREE STATEMENT, ETC.).

STATEMENTS ON MATERIAL CERTIFICATIONS MUST BE POSITIVE AND UNQUALIFIED. DISCLAIMERS SUCH AS "TO THE BEST OF OUR KNOWLEDGE" OR "WE BELIEVE THE INFORMATION CONTAINED HEREIN IS TRUE" ARE NOT ACCEPTABLE.

ALL CERTIFICATIONS PROVIDED TO VACCO INDUSTRIES SHALL BE LEGIBLE AND CAPABLE OF REPRODUCTION THROUGH THREE (3) ITERATIONS OF COPYING, AND MUST BE LEGIBLE AFTER MICROFILMING.

A SAMPLE CERTIFICATION OF CONFORMANCE IS PROVIDED IN ADDENDUM B (PNM 101-B).

### 802 STANDARD NAVY DRAWING MARKINGS

SUPPLIER TO SUPPLY STANDARD NAVY DRAWING MARKINGS IN ACCORDANCE WITH DRAWING REQUIREMENTS. FAILURE TO IDENTIFY THE MATERIAL WILL DELAY ACCEPTANCE AND PAYMENT.

### 803 MCS-6 LEVEL A REQUIREMENT

MCS-6 LEVEL A TRACEABILITY SHALL BE MAINTAINED AT ALL INTERVALS OF PRODUCTION. IF WORK IS SUBCONTRACTED, THIS REQUIREMENT MUST BE CONTRACTUALLY IMPOSED ON THE SUBCONTRACTOR, MATERIAL TEST SPECIMENS OR SAMPLES REQUIRED BY SECTIONS 4.5 AND 4.6 OF MCS-6, SHALL BE RETAINED BY THE SUPPLIER FOR AT LEAST SEVEN (7) YEARS AFTER COMPLETION OF THIS PURCHASE ORDER.

### 804 MCS-6 LEVEL B REQUIREMENT

MCS-6 LEVEL B TRACEABILITY SHALL BE MAINTAINED AT ALL INTERVALS OF PRODUCTION. THE OVER-CHECK FREQUENCY SHALL MEET THE ADDITIONAL REQUIREMENTS OF ADDENDUM A (PNM 101-A). IF WORK IS SUBCONTRACTED, THIS REQUIREMENT MUST BE CONTRACTUALLY IMPOSED ON THE SUBCONTRACTOR. MATERIAL TEST SPECIMENS OR SAMPLES REQUIRED BY SECTIONS 4.5 AND 4.6 OF MCS-6 SHALL BE RETAINED BY THE SUPPLIER FOR AT LEAST SEVEN (7) YEARS AFTER COMPLETION OF THIS PURCHASE ORDER.

### 805 MCS-6 LEVEL C REQUIREMENT

MCS-6 LEVEL C TRACEABILITY SHALL BE MAINTAINED AT ALL INTERVALS OF PRODUCTION. THE OVER-CHECK FREQUENCY SHALL MEET THE ADDITIONAL REQUIREMENTS OF ADDENDUM A (PNM 101-A). IF WORK IS SUBCONTRACTED, THIS REQUIREMENT MUST BE CONTRACTUALLY IMPOSED ON THE SUBCONTRACTOR. MATERIAL TEST SPECIMENS OR SAMPLES REQUIRED BY SECTIONS 4.5 AND 4.6 OF MCS-6 SHALL BE RETAINED BY THE SUPPLIER FOR AT LEAST SEVEN YEARS AFTER COMPLETION OF THIS PURCHASE ORDER.

### 806 VACCO FURNISHED MATERIAL/TOOLING

SUPPLIER SHALL ENSURE THAT ALL MATERIAL FURNISHED BY VACCO IS FREE FROM SHIPPING DAMAGE PRIOR TO COMMENCING WORK. SUPPLIER ASSUMES RESPONSIBILITY FOR THE TOTAL VALUE OF MATERIAL, PARTS, ETC., WHEN SCRAPPED AS A RESULT OF DAMAGE DUE TO VENDOR PROCESSING OR HANDLING. SUPPLIER IS NOT RESPONSIBLE FOR VACCO CONTROLLED PARAMETERS, BUT IS RESPONSIBLE FOR PROTECTING VACCO'S INVESTMENT IN RAW MATERIALS AND PARTIALLY COMPLETED ITEMS. A CERTIFICATION STATING THAT APPLICABLE ITEMS WERE MANUFACTURED FROM THE MATERIAL FURNISHED BY VACCO IS REQUIRED AND VACCO LOT AND/OR OTHER TRACEABILITY NUMBERS MUST BE IDENTIFIABLE TO THE ITEMS SHIPPED. ANY EXCESS MATERIAL, INCLUDING SCRAP, SHALL BE HELD UNTIL COMPLETION OF THE ORDER AND THEN RETURNED (PROPERLY IDENTIFIED) TO VACCO. SUPPLIER IS RESPONSIBLE FOR THE PROPER USE AND HANDLING OF ALL TOOLING AND OTHER EQUIPMENT PROVIDED BY VACCO. ANY DAMAGE THERETO MUST BE REPORTED IMMEDIATELY TO VACCO QUALITY ASSURANCE. ALL TOOLING FURNISHED WITH THIS ORDER SHALL BE RETURNED TO VACCO WITH THE LAST SHIPMENT THEREOF UNLESS OTHERWISE DIRECTED BY VACCO PURCHASING.

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**PNM 101 – 900 SERIES  
MISCELLANEOUS QUALITY ASSURANCE REQUIREMENTS**

**TO BE USED WITH PURCHASE ORDERS ISSUED  
ON OR AFTER 3/7/12 BUT BEFORE 9/10/12.**

# VACCO Industries

10350 Vacco St.  
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## MISCELLANEOUS QUALITY ASSURANCE REQUIREMENTS

### 901 SERIAL NUMBERS

THE CONTRACTOR SHALL SERIALLY NUMBER THE SUPPLIES CALLED FOR IN THIS PURCHASE ORDER WITH SERIAL NUMBERS OF HIS OWN DESIGNATION.

### 902 MERCURY FREE CERTIFICATION

A MERCURY FREE CERTIFICATION MUST ACCOMPANY ALL SHIPMENTS TO VACCO INDUSTRIES ON THIS PURCHASE ORDER. THE MERCURY FREE STATEMENT MAY BE MADE DIRECTLY ON THE TEST REPORT/CERTIFICATE OF CONFORMANCE OR MAY BE A SEPARATE CERTIFICATION. THE STATEMENT SHALL CERTIFY THAT DURING THE MANUFACTURING PROCESS, MATERIAL FURNISHED ON THE ABOVE PURCHASE ORDER DID NOT COME IN CONTACT WITH MERCURY OR ITS COMPOUNDS OR ANY MERCURY CONTAINING DEVICES WITH A SINGLE BOUNDARY OF CONTAINMENT. FAILURE TO PROVIDE THIS CERTIFICATION WILL DELAY ACCEPTANCE AND PAYMENT.

### 903 "LEVEL I" TRACEABILITY

THE ITEMS ON THIS PURCHASE ORDER ARE DESIGNATED AS "LEVEL I" (FOR CRUCIAL NAVY SHIPBOARD APPLICATIONS). SUPPLIER TO ASSURE THAT THE PROVIDED HEAT/LOT SEGREGATION IS NOT LOST OR MIXED. IF WORK IS SUBCONTRACTED, THIS REQUIREMENT MUST BE IMPOSED ON THE SUBCONTRACTOR.

### 904 FRAUDULENT STATEMENT REQUIREMENTS

"FRAUD AND FALSIFICATION STATEMENT" (PNM 101-900-1) APPLIES TO THIS ORDER IN ITS ENTIRETY AND MUST BE COMPLETED AND RETURN TO VACCO INDUSTRIES WITH THE ITEMS ON THIS PURCHASE ORDER. FAILURE TO PROVIDE THIS CERTIFICATION WILL DELAY ACCEPTANCE AND PAYMENT.

**(STATEMENT BELOW TO BE INCLUDED ON ALL APPLICABLE DOCUMENTS WHEN IMPOSED BY THE PURCHASE ORDER)**

#### FRAUDULENT STATEMENT

THE FEDERAL STATEMENT NOTIFICATION REQUIREMENTS ARE HERE BY PASSED DOWN TO OUR SUPPLIERS.  
"THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY BE PUNISHABLE AS A FELONY UNDER FEDERAL STATUTES, INCLUDING FEDERAL LAW, TITLE 18, CHAPTER 47."

### 905 DOMESTICITY - BUY AMERICAN ACT

MATERIAL PROVIDED ON THIS ORDER MUST BE PROVIDED FROM OR MANUFACTURED FROM DOMESTIC SOURCES AS REQUIRED BY DCA #76-75 FOREIGN ACQUISITIONS (BUY AMERICAN ACT). IF THIS CLAUSE CANNOT BE ADHERED TO, NOTIFY VACCO INDUSTRIES' PURCHASING PRIOR TO SHIPMENT OF MATERIAL.

### 906 VACCO INDUSTRIES PRELIMINARY CERTIFICATION REVIEW

SUPPLIER TEST REPORTS FOR MATERIAL BEING PURCHASED SHALL BE SUBMITTED AND APPROVED BY VACCO INDUSTRIES' QUALITY ASSURANCE DEPARTMENT PRIOR TO RELEASE FOR SHIPMENT.

### 907 PENETRANT INSPECTION

LIQUID PENETRANT INSPECTION OF HARDWARE ON THIS PURCHASE ORDER IS REQUIRED IN ACCORDANCE WITH THE LISTED SPECIFICATIONS, PROCEDURES AND ACCEPTANCE CRITERIA. AS A MINIMUM, THE SUPPLIER SHALL ASSURE THAT THE FOLLOWING INFORMATION IS INCLUDED ON THE CERTIFICATION OF INSPECTION.

- A. PART NUMBER
- B. MATERIAL AND HEAT/LOT NUMBER
- C. DESCRIPTION/TYPE AND/OR CLASSIFICATION OF CASTING, FORGING OR WELDMENT
- D. QUANTITY
- E. SERIALIZATION, IF DELINEATED
- F. VACCO INDUSTRIES' PURCHASE ORDER NUMBER
- G. SUPPLIER'S INTERNAL CONTROL NUMBER
- H. DATE OF INSPECTION
- I. PROCEDURE, ACCEPTANCE CRITERIA AND THEIR EFFECTIVE REVISIONS

ALL HARDWARE FOUND TO BE ACCEPTABLE BY NONDESTRUCTIVE EXAMINATION ARE TO BE IDENTIFIED BY PLACING THE PROPER ACCEPTANCE TEST/INSPECTION STAMP ON THE PHYSICAL PARTS. ALL HARDWARE FOUND TO BE UNACCEPTABLE SHALL BE IDENTIFIED IN SUCH A MANNER WHICH WILL ADEQUATELY DISTINGUISH THE MATERIAL FROM THE ACCEPTABLE LOT (WITHOUT PHYSICALLY

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DAMAGING THE PARTS). IN THOSE CASES WHERE N.D.T. IS PERFORMED BY A SUBCONTRACTOR, A COPY OF THE SUBCONTRACTORS CERTIFICATION MUST ACCOMPANY ANY SHIPMENT TO VACCO INDUSTRIES. FAILURE TO DO SO WILL DELAY ACCEPTANCE AND PAYMENT.

### 908 ULTRASONIC INSPECTION

ULTRASONIC INSPECTION OF HARDWARE ON THIS PURCHASE ORDER IS REQUIRED IN ACCORDANCE WITH THE LISTED SPECIFICATIONS, PROCEDURES, SCAN PLANS AND ACCEPTANCE CRITERIA. AS A MINIMUM, THE SUPPLIER SHALL ASSURE THAT A COPY OF THE CORRESPONDING SCAN PLAN IS PROVIDED AND THAT THE FOLLOWING INFORMATION IS INCLUDED ON THE CERTIFICATION OF INSPECTION.

- A. PART NUMBER
- B. MATERIAL AND HEAT/LOT NUMBER
- C. DESCRIPTION/TYPE AND/OR CLASSIFICATION OF CASTING, FORGING OR WELDMENT
- D. QUANTITY
- E. SERIALIZATION, IF DELINEATED
- F. VACCO INDUSTRIES' PURCHASE ORDER NUMBER
- G. SUPPLIER'S INTERNAL CONTROL NUMBER
- H. DATE OF INSPECTION
- I. PROCEDURE, SCAN PLAN NUMBER, ACCEPTANCE CRITERIA AND THEIR EFFECTIVE REVISIONS

ALL HARDWARE FOUND TO BE ACCEPTABLE BY NONDESTRUCTIVE EXAMINATION ARE TO BE IDENTIFIED BY PLACING THE PROPER ACCEPTANCE TEST/INSPECTION STAMP ON THE PHYSICAL PARTS. ALL HARDWARE FOUND TO BE UNACCEPTABLE SHALL BE IDENTIFIED IN SUCH A MANNER WHICH WILL ADEQUATELY DISTINGUISH THE MATERIAL FROM THE ACCEPTABLE LOT (WITHOUT PHYSICALLY DAMAGING THE PARTS). IN THOSE CASES WHERE N.D.T. IS PERFORMED BY A SUBCONTRACTOR, A COPY OF THE SUBCONTRACTOR'S CERTIFICATION MUST ACCOMPANY ANY SHIPMENT TO VACCO INDUSTRIES. FAILURE TO DO SO WILL DELAY ACCEPTANCE AND PAYMENT.

### 909 MAGNETIC PARTICLE INSPECTION

MAGNETIC PARTICLE INSPECTION OF HARDWARE ON THIS PURCHASE ORDER IS REQUIRED IN ACCORDANCE WITH THE LISTED SPECIFICATIONS, PROCEDURES, TECHNIQUE SHEETS AND ACCEPTANCE CRITERIA. AS A MINIMUM, THE SUPPLIER SHALL ASSURE THAT A COPY OF THE CORRESPONDING TECHNIQUE SHEETS ARE PROVIDED AND THAT THE FOLLOWING INFORMATION IS INCLUDED ON THE CERTIFICATION OF INSPECTION.

- A. PART NUMBER
- B. MATERIAL AND HEAT/LOT NUMBER
- C. DESCRIPTION/TYPE AND/OR CLASSIFICATION OF CASTING, FORGING OR WELDMENT
- D. QUANTITY
- E. SERIALIZATION, IF DELINEATED
- F. VACCO INDUSTRIES' PURCHASE ORDER NUMBER
- G. SUPPLIER'S INTERNAL CONTROL NUMBER
- H. DATE OF INSPECTION
- I. PROCEDURE, TECHNIQUE SHEET NUMBER, ACCEPTANCE CRITERIA AND THEIR EFFECTIVE REVISIONS

ALL HARDWARE FOUND TO BE ACCEPTABLE BY NONDESTRUCTIVE EXAMINATION ARE TO BE IDENTIFIED BY PLACING THE PROPER ACCEPTANCE TEST/INSPECTION STAMP ON THE PHYSICAL PARTS. ALL HARDWARE FOUND TO BE UNACCEPTABLE SHALL BE IDENTIFIED IN SUCH A MANNER WHICH WILL ADEQUATELY DISTINGUISH THE MATERIAL FROM THE ACCEPTABLE LOT (WITHOUT PHYSICALLY DAMAGING THE PARTS). IN THOSE CASES WHERE N.D.T. IS PERFORMED BY A SUBCONTRACTOR, A COPY OF SUBCONTRACTOR'S CERTIFICATION MUST ACCOMPANY ANY SHIPMENT TO VACCO INDUSTRIES. FAILURE TO DO SO WILL DELAY ACCEPTANCE AND PAYMENT.

### 910 RADIOGRAPH INSPECTION

RADIOGRAPH INSPECTION (X-RAY) OF HARDWARE ON THIS PURCHASE ORDER IS REQUIRED IN ACCORDANCE WITH THE LISTED SPECIFICATIONS, PROCEDURES, SHOOTING SKETCHES AND ACCEPTANCE CRITERIA. COMPLETED FILMS, TECHNIQUE SHEETS/SHOOTING SKETCHES AND READER SHEETS SHALL BE PROVIDED TO VACCO INDUSTRIES UNLESS OTHERWISE SPECIFIED. AS A MINIMUM, THE SUPPLIER SHALL ASSURE THAT THE FOLLOWING INFORMATION IS INCLUDED ON THE CERTIFICATION OF INSPECTION.

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- A. PART NUMBER
- B. MATERIAL AND HEAT/LOT NUMBER
- C. DESCRIPTION/TYPE AND/OR CLASSIFICATION OF CASTING, FORGING OR WELDMENT
- D. QUANTITY
- E. SERIALIZATION, IF DELINEATED
- F. VACCO INDUSTRIES' PURCHASE ORDER NUMBER
- G. SUPPLIER'S INTERNAL CONTROL NUMBER
- H. DATE OF INSPECTION
- I. PROCEDURE, SHOOTING SKETCH NUMBER, ACCEPTANCE CRITERIA AND THEIR EFFECTIVE REVISIONS

ALL HARDWARE FOUND TO BE ACCEPTABLE BY NONDESTRUCTIVE EXAMINATION ARE TO BE IDENTIFIED BY PLACING THE PROPER ACCEPTANCE TEST/INSPECTION STAMP ON THE PHYSICAL PARTS. ALL HARDWARE FOUND TO BE UNACCEPTABLE SHALL BE IDENTIFIED IN SUCH A MANNER WHICH WILL ADEQUATELY DISTINGUISH THE MATERIAL FROM THE ACCEPTABLE LOT (WITHOUT PHYSICALLY DAMAGING THE PARTS). IN THOSE CASES WHERE N.D.T. IS PERFORMED BY A SUBCONTRACTOR, A COPY OF THE SUBCONTRACTOR'S CERTIFICATION MUST ACCOMPANY ANY SHIPMENT TO VACCO INDUSTRIES. FAILURE TO DO SO WILL DELAY ACCEPTANCE AND PAYMENT.

### **911 ACCEPTANCE TEST REPORTS (FLOW, SHOCK, VIBRATION, ETC.)**

SUPPLIER MUST INCLUDE WITH EACH SHIPMENT ACTUAL COPIES OF ACCEPTANCE TEST RESULTS, SIGNED BY AN AUTHORIZED AGENT OF THE SUPPLIER, INDICATING THE ACTUAL RESULTS OF ACCEPTANCE TESTS REQUIRED BY THE PURCHASE ORDER. WHERE QUANTITATIVE LIMITS ARE ESTABLISHED WITHIN THE PROCEDURE OR SPECIFICATION, THE REPORT SHALL INDICATE THE ACTUAL VALUES OBTAINED. THE TEST REPORTS SHALL INCLUDE THE CONTROL IDENTITY (E.G. HEAT, LOT, SERIAL NUMBER) OF MATERIAL/ITEMS TESTED.

### **912 HEAT TREATMENT CERTIFICATION REQUIREMENT**

SUPPLIER SHALL PERFORM HEAT TREATMENT IN ACCORDANCE WITH THE SPECIFICATIONS AND REVISIONS LISTED ON THIS PURCHASE ORDER. SUPPLIER SHALL SUPPLY A CERTIFICATION FOR THE HEAT TREATMENT, HEAT TREAT CHARTS AND MERCURY FREE STATEMENT WITH THE SHIPMENT. FAILURE TO PROVIDE THIS DOCUMENTATION WILL DELAY ACCEPTANCE AND PAYMENT.

### **913 HARDNESS REQUIREMENTS FOR HEAT TREATMENT PROCESSORS**

SUPPLIER SHALL RECORD HARNES READINGS ON THE HEAT TREAT CERTIFICATIONS FOR ITEMS HEAT TREATED ON THIS PURCHASE ORDER. FAILURE TO PROVIDE THIS INFORMATION WILL DELAY ACCEPTANCE AND PAYMENT.

### **914 CALIBRATION CONTROL AND CERTIFICATION**

SUPPLIER TO CALIBRATE THE TOOLS/GAGES DESIGNATED ON THIS PURCHASE ORDER IN ACCORDANCE WITH ANSI/NCSS Z540 1. CERTIFICATION MUST SPECIFY DIRECT N.I.S.T. TRACEABILITY. IF RECONDITIONING IS NECESSARY, ADDITIONAL VACCO INDUSTRIES' QUALITY ASSURANCE CALIBRATION DEPARTMENT AUTHORIZATION IS REQUIRED PRIOR TO PROCEEDING.

### **915 DETRIMENTAL MATERIAL**

THE REQUIREMENTS OF MIL-STD-767 APPLY TO THIS PURCHASE ORDER.

### **916 SOLDERABILITY OF LEADS, ETC.**

SOLDERABILITY OF EXTERNAL LEADS AND TERMINALS: EXTERNAL LEADS, PIN AND TERMINALS OF ALL COMPONENTS SHALL BE TESTED AND COMPLY WITH THE SOLDER ABILITY REQUIREMENTS SPECIFIED IN MIL-STD-202, METHOD 208, INCLUDING AGING REQUIREMENTS.

### **917 MANNED SPACE FLIGHT**

MANNED SPACE FLIGHT REQUIREMENTS FOR USE IN MANNED SPACE FLIGHT. MATERIALS, MANUFACTURING AND WORKMANSHIP OF HIGHEST QUALITY STANDARDS ARE ESSENTIAL TO ASTRONAUT SAFETY.

IF YOU ARE ABLE TO SUPPLY THE DESIRED ITEMS WITH A QUALITY WHICH IS HIGHER THAN THAT OF THE ITEMS SPECIFIED OR PROPOSED, YOU ARE REQUESTED TO BRING THIS FACT TO THE IMMEDIATE ATTENTION OF THE PURCHASER.

THIS CLAUSE WILL BE INSERTED IN ALL SUBCONTRACTS AND PURCHASE ORDERS FOR SUCH ITEMS DOWN TO THE LOWEST TIER.

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### 918 CHANGE IN APPROVED PROCESSES

SUPPLIER MAY NOT CHANGE ANY DRAWING, PROCESS, MATERIAL OR PROCEDURE ORIGINALLY SUBJECT TO VACCO'S APPROVAL WITHOUT WRITTEN AUTHORIZATION FROM VACCO'S QUALITY DEPARTMENT.

### 919 GIDEP ANNOUNCEMENTS

IF A GIDEP (GOVERNMENT-INDUSTRY DATA EXCHANGE) ANNOUNCEMENT IS ISSUED ON ANY PRODUCTS ON THIS ORDER AN IMMEDIATE RESPONSE FROM YOU WILL BE REQUIRED.

### 920 WELDING PROCEDURE

SELLER SHALL FURNISH TWO (2) COPIES OF ALL PROPOSED WELDING PROCEDURES TO BUYER FOR APPROVAL PRIOR TO PRODUCTION. CHANGES TO APPROVED PROCEDURES REQUIRES BUYER RE-APPROVAL PRIOR TO IMPLEMENTATION BY SELLER.

### 921 SPECIAL CERTIFICATIONS

THE FOLLOWING REFERENCED CERTIFICATIONS(S) ARE REQUIRED WITH EACH SHIPMENT AGAINST THIS ORDER:

**A.(1) RAW MATERIAL CERTIFICATION.** A PHYSICAL AND CHEMICAL TEST REPORT FROM THE MILL SOURCE, INDICATING QUANTITATIVE VALUES OF INGREDIENTS AND REFERENCING APPLICABLE SPECIFICATIONS IS REQUIRED

**A.(2) RAW MATERIAL CERTIFICATION.** A CERTIFICATION DISCLOSING THE "TYPICAL" CHEMICAL AND PHYSICAL PROPERTIES OF THE MATERIAL SUPPLIED IS REQUIRED.

**A.(3) RAW MATERIAL CERTIFICATION.** A CHEMICAL COMPOSITION TEST REPORT FROM THE MILL SOURCE INDICATING QUANTITATIVE VALUES OF INGREDIENTS AND REFERENCING APPLICABLE SPECIFICATIONS IS REQUIRED.

**A.(4) RAW MATERIAL CASTINGS/FORGINGS.** SELLER SHALL FURNISH TWO (2) TEST BARS FROM THE SAME MILL MASTER MELT WITH THE FIRST SHIPMENT AND WITH EACH MELT CHANGE THEREAFTER. SPECIMENS SHALL CONFORM TO FEDERAL TEST STANDARD NO. 151 IDENTIFIED WITH SUPPLIER'S NAME OR TRADEMARK.

**B. PROCESS CERTIFICATION.** A CERTIFICATION IS REQUIRED FOR MATERIAL SUBJECT TO "SPECIAL PROCESSES" (SUCH AS HEAT TREATING, WELDING, SURFACE TREATMENT, ETC.). IT SHALL INCLUDE IDENTIFICATION OF THE PROCESS (BY APPLICABLE SPECIFICATION NUMBER, REVISION, TYPE, CLASS, ETC.), NAME OF SUBCONTRACTOR (IF OTHER THAN SUPPLIER), SIGNATURE AND CERTIFICATION LEVEL OF THE PERSON PERFORMING THE PROCESS, AND SERIAL NUMBERS OF PARTS PROCESSED (IF APPLICABLE).

**B.(1) HEAT TREAT.** IN ADDITION TO THE REQUIREMENTS OF 6B ABOVE, COPIES OF FURNACE CHARTS AND VACUUM CHARTS (IF APPLICABLE) ARE REQUIRED SHOWING TEMPERATURES, RAMP RATES, TIME AT TEMPERATURE, FURNACE NUMBER, VACUUM LEVELS, ETC.

**C. NON-DESTRUCTIVE TESTING.** ITEMS SUBJECTED TO NONDESTRUCTIVE TESTING (I.E. DIE PENETRANT, MAGNETIC PARTICLE, ULTRASONIC, ETC.) REQUIRE A REPORT OF ACTUAL TESTS PERFORMED, IDENTIFIABLE TO THE ACCEPTANCE REQUIREMENTS FOR THE MATERIAL SUBMITTED (REFERENCING SPECIFICATION, REVISION, TYPE, METHOD, ETC.), WITH THE SIGNATURE, TITLE AND LEVEL OF AUTHORIZED PERSON PERFORMING THE TEST, AND DOCUMENTARY ASSURANCE THAT THE MATERIAL CONFORMS TO THE SPECIFICATION REQUIREMENTS. ACCEPT/REJECT RESULTS MUST BE INCLUDED. PARTS OR MATERIALS REQUIRING RADIOGRAPHIC TESTS SHALL BE SUBMITTED TO A VACCO APPROVED LABORATORY AND PROCESSED ACCORDING TO APPLICABLE VACCO AND/OR GOVERNMENT SPECIFICATIONS OR STANDARDS. FINDING BE RECORDED ON APPROPRIATE FORMS, WHICH SHALL INCLUDE THE NAME, SIGNATURE, TITLE AND LEVEL OF THE AUTHORIZED OPERATOR. THE X-RAY FILM, A TECHNIQUE SKETCH, AND TWO (2) COPIES OF THE REPORT SHALL BE FURNISHED.

**D. WIRE/CABLE CERTIFICATION.** EACH TYPE OF WIRE OR CABLE ON THIS ORDER MUST INCLUDE A CERTIFICATION INDICATING THE SIZE, COLOR, CLASS, TYPE AND MILITARY SPECIFICATION TO WHICH THE MATERIAL CONFORMS.

**E. LOX COMPATIBILITY.** A CERTIFICATION ATTESTING TO THE MATERIAL'S COMPATIBILITY WITH LIQUID OR GASEOUS OXYGEN PER VACCO PS-325 (IMPACT TEST PROCEDURE) AND NHB 8060.1 IS REQUIRED.

**F. INDEPENDENT LABORATORY ANALYSIS.** A CERTIFICATION, INDICATING THE QUANTITATIVE VALUES OF INGREDIENTS (AS REQUIRED BY APPLICABLE MATERIAL AND/OR PURCHASE ORDER REQUIREMENTS), FROM AN INDEPENDENT LABORATORY, IS REQUIRED.

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### 922 SUPPLIER'S VARIABLES DATA (WITH SHIPMENT)

ONE (1) COPY OF ALL INSPECTION VARIABLES DATA WHICH RECORDS OBJECTIVE EVIDENCE OF ACCEPTANCE TRACEABLE TO EACH ASSEMBLY, SUB-ASSEMBLY, OR COMPONENT. THE FORM USED FOR DOCUMENTATION OF VARIABLES DATA SHALL BE OPTIONAL.

### 923 IDENTIFICATIONS/TRACEABILITY

THE FOLLOWING REFERENCED IDENTIFICATION AND/OR TRACEABILITY REQUIREMENTS APPLY:

**A. MIL-STD-130.** PARTS AND MATERIALS SHALL BE IDENTIFIED PER MIL-STD-130.

**B. TRACEABILITY.** POSITIVE TRACEABILITY OF PARTS, BY CROSS-REFERENCING ALL MANUFACTURING AND SHIPPING DOCUMENTS WITH REPORTS AND CERTIFICATIONS FOR RAW MATERIAL LOTS OR BATCHES FROM WHICH ITEMS WERE MANUFACTURED, IS REQUIRED.

**C. NASA CERTIFICATION/ TRACEABILITY.** DOCUMENTATION, SHOWING DATE OF MANUFACTURE AND HEAT, BATCH OR LOT NUMBER, MUST ACCOMPANY THE MATERIAL FURNISHED ON THIS ORDER. EACH LOT MUST NOT BE INTERMIXED WITH SUBSEQUENT LOTS OF THE SAME PIECE.

**D. SUPPLIER FURNISHED MATERIAL.** MATERIAL IDENTIFICATION, WITH THE PRODUCER'S HEAT LOT OR UNIQUE IDENTIFIER ASSIGNED AND CROSS-REFERENCED ON TEST REPORTS, REPRESENTING A SINGLE HEAT, BATCH OR MELT, IS REQUIRED. IN THE EVENT THAT MORE THAN ONE LOT OF MATERIAL IS SUPPLIED, EACH FABRICATED BATCH MUST BE IDENTIFIED SO AS TO MAINTAIN INDIVIDUAL LOT INTEGRITY.

### 924 SUPPLIER CONTROLLED PRODUCTS

TWO (2) COPIES OF APPLICABLE DRAWINGS, SPECIFICATIONS AND/OR CATALOGS SHALL ACCOMPANY THE INITIAL SHIPMENT ON THIS ORDER.

### 925 VACCO CUSTOMER APPROVED SUPPLIERS

PROCESSING PERFORMED ON PRODUCTS SUPPLIED AGAINST THIS ORDER MUST BE PERFORMED BY VENDORS APPROVED BY VACCO'S CUSTOMER. NAMES OF SUCH APPROVED SUPPLIERS MAY BE OBTAINED FROM VACCO'S PURCHASING OR QUALITY ASSURANCE DEPARTMENT TO ASSURE USE OF CURRENTLY APPROVED SUPPLIERS.

### 926 MANUFACTURING AND INSPECTION PLAN

SELLER SHALL PREPARE AND MAINTAIN AN INSPECTION TEST PLAN OR SHOP TRAVELER WHICH PROVIDES RECORDS OF ALL PERFORMED OPERATIONS AND INSPECTION. AS A MINIMUM, ROUTING SHEETS SHALL SHOW OPERATIONAL SEQUENCE, INSPECTION AND TEST POINTS AND OTHER PERTINENT CONTROL MEDIA. THE DOCUMENTS SHALL PROVIDE TRACEABILITY TO PERSONNEL PERFORMING OPERATIONS AND INSPECTION, ACCEPTABILITY BY INSPECTION, AND REFERENCE OF ANY ASSOCIATED DOCUMENTS SUCH AS REJECTION REPORTS, PROCESSING PROCEDURES, INSPECTION PROCEDURES, ETC. ONE (1) REPRODUCIBLE COPY OF THE PLAN SHALL BE SUBMITTED TO THE BUYER FOR APPROVAL, PRIOR TO THE START OF PRODUCTION.

### 927 DOMESTIC SPECIALTY METALS

DFAR 252.225-7014 APPLIES TO THIS PURCHASE ORDER. THE MATERIAL FURNISHED ON THIS PURCHASE ORDER MUST BE FROM DOMESTIC MELT BILLET.

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### RAW MATERIAL OVERCHECK PROGRAM REQUIREMENTS

1. SAMPLES OF RAW MATERIAL SHALL BE SUBMITTED TO A QUALIFIED TEST LABORATORY FOR VERIFICATION. THESE OVERCHECKS ARE REQUIRED FOR EACH COMBINATION OF SUBCONTRACTOR/GENERIC MATERIAL TYPE.

THE FREQUENCY OF THESE SAMPLES SHALL MEET THE FOLLOWING MINIMUM REQUIREMENTS:

- A. ONE SAMPLE FROM THE INITIAL LOT RECEIVED EACH CALENDAR YEAR.
- B. ONE SAMPLE FROM EVERY TENTH LOT RECEIVED FOR THE REMAINDER OF THE CALENDAR YEAR.
- C. FOR MCS-6, LEVEL A, ONE SAMPLE FROM EACH LOT UP TO A TOTAL OF SIX PER CALENDAR YEAR.

2. GENERIC MATERIAL TYPES ARE DEFINED AS:

- A. NICKEL-CHROMIUM-IRON BASE ALLOYS (INCONELS AND HASTELLOYS)
- B. NICKEL-COPPER ALLOYS (MONELS)
- C. COPPER-NICKEL ALLOYS (CUPRO-NICKELS)
- D. AUSTENITIC STAINLESS STEELS (AISI 300 SERIES)
- E. MARTENSITIC AND FERRITIC STAINLESS STEELS (AISI 400 SERIES AND 17-4PH CLASS)
- F. CARBON AND ALLOY STEELS (AISI 4340, MIL-S-23194, HY-80, ETC.)
- G. TITANIUM ALLOYS
- H. COBALT BASE ALLOYS (STELLITES)
- I. NICKEL-CHROMIUM-BORON ALLOYS (COLMONOYS)
- J. COPPER BASE ALLOYS (BRASS, BRONZE, AND OTHER ALLOYS CONTAINING GREATER THAN 50% COPPER BY WEIGHT OTHER THAN CUPRO-NICKELS)



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**SUPPLIER LETTERHEAD**

**CERTIFICATION OF CONFORMANCE**

SUPPLIER: \_\_\_\_\_

PURCHASE ORDER NUMBER: \_\_\_\_\_ JOB NUMBER: \_\_\_\_\_

1.0 THE CERTIFICATIONS INDICATED BELOW APPLY TO THE PURCHASE ORDER SHOWN ABOVE.

\_\_\_\_\_ 1.1 CERTIFICATION OF CONFORMANCE: THIS IS TO CERTIFY THAT ALL MATERIALS SUPPLIED ON THE ABOVE PURCHASE ORDER ARE IN COMPLIANCE WITH ALL REQUIREMENTS AND APPLICABLE SPECIFICATIONS AND REGULATIONS. ALL RECORDS ARE ON FILE AND ARE SUBJECT TO EXAMINATION AT ANY TIME.

SPEC. NO.:	REV.	SPEC. NO.:	REV.
SPEC. NO.:	REV.	SPEC. NO.:	REV.

\_\_\_\_\_ 1.2 CERTIFICATION OF NON-MERCURY CONTAMINATION: THIS IS TO CERTIFY THAT DURING THE MANUFACTURING PROCESS, MATERIAL FURNISHED ON THE ABOVE PURCHASE ORDER DID NOT COME IN CONTACT WITH MERCURY OR ITS COMPOUNDS OR ANY MERCURY CONTAINING DEVICES WITH A SINGLE BOUNDARY OF CONTAINMENT.

\_\_\_\_\_ 1.3 THIS IS TO CERTIFY THAT THE VACCO-SUPPLIED MATERIAL WAS USED ON THIS PURCHASE ORDER, AND MATERIAL CERTIFICATION NUMBERS ARE DESIGNATED ON THE SHIPPER FOR EACH PURCHASE ORDER ITEM SHIPPED. MATERIAL CERTIFICATION NUMBER:

\_\_\_\_\_ 1.4 THIS IS TO CERTIFY THAT MY INSPECTION SYSTEM CONFORMS TO MIL-I-45208.

WITH REGARD TO PRODUCTS THAT ARE PROCURED BY VACCO INDUSTRIES, WHICH ARE MANUFACTURED TO A SUPPLIER'S DESIGN, THE SUPPLIER SHALL NOTIFY AND OBTAIN APPROVAL FROM VACCO IF DESIGN CHANGES ARE MADE FROM THE ORDERED PRODUCT DESCRIPTION.

\_\_\_\_\_  
DATE

\_\_\_\_\_  
SUPPLIER QUALITY ASSURANCE

\_\_\_\_\_  
NAME TYPED

\_\_\_\_\_  
TITLE

**TO BE USED WITH PURCHASE ORDERS ISSUED  
ON OR AFTER 3/7/12 BUT BEFORE 9/10/12.**