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* Verify Revision Before Use *	Document Identification:	7.4.1.3.1

1. PURPOSE

This document describes the general and special product assurance requirements (clauses) that will be used by Arnold Magnetic Technologies (AMT) on Contracts (POs), Contracts or other formal agreement (hereafter referred to as the Contract) between a Supplier and AMT. The purpose of this document is to clearly define for each purchase of products or services all of the necessary and applicable technical and quality requirements the Supplier is required to comply with to meet AMT, AMT's customers, and/or regulatory requirements.

2. RESPONSIBILITY AND AUTHORITY

The Purchasing and Quality Managers are responsible that all the applicable requirements are communicated to the suppliers and that the suppliers are in conformance with these requirements. By delivering products or services on the Contract, the Supplier certifies that such products or services are in compliance with all applicable requirements of the Contract, and objective evidence of compliance is available and will be furnished to AMT for review upon request.

3. SCOPE

This document applies to all Contracts where Purchasing Quality Clauses (PQC's) are identified. General requirement PQC's apply to all orders regardless of whether or not they are individually called out on the Contract. Any customer specified flow downs/quality requirements noted in PQC 27 or on the Contract supersede AMT PQC requirements.

4. GENERAL REQUIREMENTS

The following requirements apply to all products delivered to AMT where the requirements of meeting the standard PQC's are referenced on the Contract.

a. Product Safety

By accepting the Contract the supplier acknowledges that it is critical that any article ordered must be conforming to all requirements in order to ensure it is able to perform its designed or intended purpose without causing unacceptable risk of harm to persons or damage to property. This includes protection of the article's characteristics during manufacturing and shipment. Suppliers shall notify AMT of any deviations from Contract requirements according to PQC-25 of this document and must receive approval from AMT before shipment of any affected articles.

b. Acceptance at Destination


Articles ordered on the Contract are subject to final acceptance at destination. Materials received which do not conform to the provisions as indicated on the Contract will be subject to rejection or such measures as may be deemed necessary by the Purchasing or Quality Managers or their designates. Issuance of a Discrepant Material Report (DMR) shall require corrective action and evidence shall be provided to AMT within 30 days upon notice unless other actions are agreed upon between AMT Purchasing or Quality Manager and the supplier.

c. Quality System:

The suppliers on this order must be controlled under a Quality Management System that conforms to the requirements of the current acceptable revision of the ISO 9001 or AS9100 Standards or equivalent with written approval of AMT.

For suppliers with a third party ISO Certificate, any renewal, probation or revocation of ISO Certificate requires notification to AMT Purchasing and Quality Departments within 30 days of event.

Note: Additional quality system requirements may be applied due to customer flow downs by so noting on the Contract.

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d. Calibration System:

The supplier's measuring and testing equipment used in the performance of orders for AMT shall be calibrated in accordance with ISO 10012-1 or equivalent.

e. Dimensional Test Data:

The supplier shall perform dimensional inspection to verify all characteristics and notes on the drawing/specification. The supplier shall record the actual dimensional readings. The inspection results must be kept on file and shall be made available to AMT upon request at no additional cost. All recorded data must be legible.


The items delivered on the Contract shall be controlled by the supplier/manufacture under a quality inspection system sufficiently adequate to verify that the material or service furnished meets all requirements of the Contract. An AQL of 1.0 C=O sampling plan at minimum is required per the Table I below. At a minimum the report shall contain the balloon #, drawing note/characteristic, actual reading, inspection instrument used, job/lot#, drawing # and revision.

If key characteristic(s)(KCs) are noted on the drawing or specified by AMT to be verified then these KC shall be inspected as specified and recorded on an inspection form and supplied to AMT with each shipment.

Note: Special inspection requirements may be required as identified in the supplemental PQC's later in this document and specified on the Contract.

Table I: Accept on Zero (C=0) Sampling Plan

Lot Size	Acceptable Quality Level (AQL)			
	.65	1.0	2.5	4.0
2-8	ALL	ALL	6	3
9-15	ALL	13	6	3
16-25	20	13	6	3
26-50	20	13	7	7
51-90	20	13	11	8
91-150	20	13	11	9
151-280	29	29	13	10
281-500	47	29	16	11
501-1200	47	34	19	15
1201-3200	53	42	23	18

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f. Certificate of Conformance:

A Certificate of Conformance (C of C) must accompany each shipment of material. The C of C shall be legible and at a minimum include the following information:

- Supplier name and address
- A statement that material shipped conforms to the applicable specifications and/or standards.
- The standard or process number called out on the Contract/ product drawing must be present on the C of C provided as written on the Contract/ product Drawing.
- The AMT Contract Number and line number.
- Part Number and Latest Revision Letter. (unless specified otherwise on the Contract)
- Manufacture lot number. (Traceability Information)
- Quantity shipped.
- Date Shipped.
- Identity of Quality Representative or company official.
- Signature of an authorized company representative.
- Serial Numbers, with each serial number discretely written. A range of serial numbers with a beginning and ending number separated by a dash is NOT acceptable. (if applicable)
- Mill Heat Number if material is provided by supplier.

When multiple lots of material are used in completing a shipment, the parts shall be packaged separately with a separate and complete certification package including a supplier Certificate of Conformance for each lot of material.

Where applicable, required physical and chemical test certificates are to be included in the shipment.

When material is provided by a distributor, the Certificate of Conformance from the original manufacture must be provided per section g. below. The original manufacturer C of C shall meet the requirements above.


g. Material Certification:

g.1) For raw material shipments or supplier provided material in the form of bar, plate, sheet, tubing and castings the material certification shall contain the following at a minimum:

- Chemical ComContractsition - in percentages (%).
- Mechanical/Metallurgical Test - Tensile strength, yield strength, percent elongation, hardness, etc.
- Material designation.
- Specification and revision letter (to the latest revision in effect at time of shipment) that the material
- was purchased to.
- Heat Number.
- Any other requirement specified on the Contract or drawing.

g.2) For magnet material shipments, the material certification shall contain the following:

- BH Curve (Quadrant II).
- Magnetic properties – Br (Residual Induction), HcB (Coercivity), HcJ (Intrinsic Coercivity),
- BHmax (Maximum Energy Product).
- Material Lot/Heat Number.
- Any other requirement specified on the Contract or drawing.

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Material certification shall be supplied with each shipment and be legible. Certifications must be provided by the manufacturer. Distributor certifications are NOT ACCEPTABLE. If material is provided through distribution, the distributor must provide a C of C confirming that there is unbroken traceability from all intermediaries back to the original manufacturer including heat treating.

h. Lot Traceability:

All items fabricated under this Contract shall be traceable to raw materials used. All traceability and inspection records must be identifiable with raw materials, parts, or assemblies to which they are applicable and shall be available upon request or audit by AMT. The lot or batch number may be by date or supplier shop order code, and must provide the capability for a lot or batch purge in the event of determination of a nonconformity. Identification shall be per AMS478 / MIL-STD-130, or as specifically defined on drawing or Contract.

- **Raw materials** used shall be identified by lot number as well as material type, specification, heat number, etc. and shall be identifiable with the lot of raw materials used when two (2) or more parts are joined in an assembly. The seller shall prepare an Assembly Parts List identifying each in the assembly and the lot of raw material from which it was fabricated.
- **All materials fabricated** by the seller in one lot shall be identifiable to that lot when supplied to AMT. When the seller is combining material fabricated in two or more different lots to fulfill Contract requirements, these materials shall be segregated and identifiable to the lot in which it was fabricated. The seller shall request, from the buyer whose signature appears on the Contract, written authorization to submit materials fabricated in two or more lots to fulfill the total quantity of each item on this Contract.

i. Material Review:

AMT Customer's Quality organization shall retain MRB authority on dispositions for any nonconformities affecting product performance and/or drawing requirements other than scrap or rework. Nonconforming material is to be identified, segregated, and controlled to prevent its unauthorized use for shipment. It is an expected general practice for suppliers to perform root cause identification and implementation of preventative actions to recurrence.

j. OMITTED


k. Configuration Control:

Supplier shall make no change in design, manufacturing or assembly process, source of supply or manufacturing location after approval of the first article or first production run without the written approval from AMT.

l. Work Transfers - Unauthorized Facility Change:

The supplier shall give AMT written notice of any intended relocation of any production, inspection, or processing facilities. Any relocation requires written approval from AMT prior to commencement of processing, with the sole exception being development of the intended process. Process development output shall not be considered salable material, but may be use to demonstrate proof of capability. AMT reserves the right to perform a site review of the intended process prior to approval.

Written notice is also required when making changes to the source of any major component, or making any other changes which may affect product quality or reliability. Change in ownership or management representative with respect to the supplier's quality system also require written notification.

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m. Unauthorized Product Changes:

The supplier may not make any changes or substitutions to any products or services required by the contract, drawing, specification or any other applicable document without prior written approval from AMT Purchasing.

n. Altering Data on Documents:

The use of any method that caused the original data to be unreadable (i.e.: correction tape and fluids) is strictly prohibited. The sole acceptable correction method is to strike through the erroneous information, write the corrected information, and affix the signature and correction date by the responsible authority.

o. Record Retention:

The supplier shall retain all records that provide objective evidence of compliance to contract requirements pertaining to material, manufacturing processes, special processes, testing and inspection for a minimum of 10 years after final payment. There are special circumstances and customer requirements that may be longer. Special requirements will be defined in the Contract. Supplier is required to obtain AMT written approval prior to record disposal/ destruction.

p. Latest Revision:

All suppliers are responsible for supplying materials to the latest revision of any specification(s) defined on the drawing, Contract or listed/ referenced processing specification unless otherwise agreed to in writing by AMT.

q. Deviation to Contract Requirements:

A request for variance may be initiated by the Supplier prior to shipment for any deviation from drawings, specifications or other Contract requirements and must adequately describe such deviations, including a complete description of the cause and corrective action to prevent recurrence. The request for variance via a Non-Conforming Material Record shall be submitted to the AMT Buyer, who will initiate an AMT review of the request. If approved, a copy of the AMT approved request for Specification variance will be returned to the Supplier. Request shall be submitted on AMT form 8.3.1.1.2a.

Supplier shall not ship a discrepant item reported and submitted on a request for variance until the request disposition has been provided by the Buyer of the item. Items shipped on a request for variance must be identified and segregated from other items to permit separate identification to be maintained.

Non-conforming conditions on items submitted and approved on request for variance's prior to shipment will not be charged to the Supplier's Quality Performance Record. Supplier is responsible for all costs incurred by AMT directly associated with any nonconformance determined to be the supplier's responsibility and not accepted on deviation by AMT.


r. Flow Down Of Requirements:

Supplier is responsible to flow down all requirements of Contracts and verify that any sub-level supplier that is being used to manufacture/process product meets all such requirements.

s. Marking of shipments:

Supplier shall individually mark the outside of each box shipped with the Arnold Magnetic Technologies P.O. Number, part number and the quantity of parts in the box. If the boxes are reused any previous markings must be completely removed or covered such that only the current contents of the box are visible. Lot numbers shall not be mixed within a box without sufficient identification and separation.

**See Appendix-A for supplemental Details*

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t. Preservation and Packaging:

The organization shall incorporate good commercial standard practices and methods for the preservation, packaging, and shipment of product to prevent damage during shipment to Arnold or deterioration/corrosion while in storage. Newsprint, shredded paper, or Styrofoam peanuts shall not be used for wrapping of parts or as dunnage due to its acidic nature.

Divided containers or individual packaging, etc., shall be used for material susceptible to damage from part-to-part contact, including measures to prevent part movement. Use of staples, paper clips, or other potential sources of Foreign Object Damage / Foreign Object Debris (FOD) is prohibited in packaging.

When magnetic shielding is specified all edges shall be deburred to minimize risk of injury.

**See Appendix-A for supplemental Details*

u. Foreign Object Damage (FOD) Prevention

Supplier shall establish and maintain an effective Foreign Object Damage/Debris (FOD) Prevention Program to reduce FOD using NAS412 as a guideline. Supplier shall utilize effective FOD prevention practice to protect product at all times. Suppliers shall establish methods and facilities for identifying, handling, and storing articles to ensure against contamination, corrosion, damage, deterioration and invasion of foreign objects or substances.

v. Material authenticity – counterfeit material prevention

Supplier and Supplier sub-tiers shall have in place a program to prevent counterfeit material and assure material authenticity in accordance with AS6174A.


5. SUPPLEMENTAL PQC's

The following PQC's will apply to an order when identified on the Contract:

PQC-06 First Article Inspection Report (FAIR):

A full or FAIR shall be provided in accordance with latest revision of AS9102 on a part representative of the production process used for the manufacture of the parts. When a previous FAIR has been submitted the requirement for whether or not a new FAIR is required will be in accordance with AS9102.

- Customer FAIR requirements supersede AS9102 when specified on the Contract.
- The FAIR is to be completed using Arnold Magnetics FAIR form #8.2.4.7b and reviewed using AMT's FAIR review checklist form #8.2.4.7.2 which can be obtained from the AMT Quality department. The review checklist shall become part of the FAIR submittal to AMT.
- Alternate AS9102 compliant forms or FAIR generation software may be used with the written approval of the Arnold Magnetics Quality department.
- The FAIR report shall reflect actual values and show compliance to drawing and related specifications (i.e. 100% of drawing characteristics & notes).
- All FAIR forms shall be completed electronically. Hand written FAIR's will not be acceptable.
- The supplier shall account for all drawing characteristics and notes by assigning a unique identifier to each characteristic on the drawing and including that same unique identifier on the FAIR document. The marked drawing with unique identifiers, typically referred to as a ballooned drawing, shall become part of the FAIR submittal to AMT.
- Use-as-is acceptance of FAIR hardware nonconformance's does not constitute first article approval.
- The specific part used by the supplier for FAIR must be clearly tagged / separated from the rest of the parts of the shipment.
- A copy of the FAIR documentation is to accompany the first shipment of parts.

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All FAIRs shall be written to comply with the following documents available through the AMT Quality Department.

- 1) Document 8.2.4.7b AS9102B FAIR Form
- 2) Document 8.2.4.7.2 Vendor FAIR Checklist

PQC-06a Customer Specific FAIR Documents:

Customer specific FAIR document use is required for this order. The use of any other FAIR forms will result in FAIR rejection. Contact AMT for the required customer specific FAIR template.

PQC-07 Production Part Approval Process (PPAP):

Specific PPAP requirements will be as specified on the Contract. Requirements will be determined by the cognizant Quality Engineer as required by the AMT Customer. The PPAP may include at a minimum a Control Plan, Process Flow Diagram, In-Process Characteristic controls, a Process FMEA, Gage Repeatability and Reproducibility (R&R) studies for all measuring equipment, material certifications, a Packaging proContractual, details of improvement opportunities, and documentation listing issues and concerns. If Tooling or Gauging is influential in determining part characteristics, the Control Plan must also include a Tool/Gauge Plan outlining methods for tryout, qualification and monitoring to maintain control.

PQC-08 Source Inspection:

AMT or their customers are required to perform source inspection prior to shipping from the supplier's facility. When material is ready for inspection, notify the AMT Buyer at least forty-eight (48) hours in advance. Source Inspection does not relieve the supplier of any of the requirements of this Contract nor the responsibility of rework or replacement of material found to be defective during normal acceptance procedures. The supplier's gages, measuring and testing devices shall be made available for the Source Inspector.

PQC-09 Government Source Inspection (GSI):

GSI is required prior to the shipment of any items against this Contract. Government inspection does not relieve the supplier or AMT of their obligation to provide conforming parts/services. Government inspection does not constitute acceptance. When Government Inspection is required, AMT will add to the purchasing document the following statement:


"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."

When, under authorization of the Government representative, copies of the purchasing document are to be furnished directly by the subcontractor or supplier to the Government representative at his facility rather than through Government channels AMT will add to its purchasing document a statement substantially as follows:

"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, our purchasing agent shall be notified immediately."

PQC-14 Special Process Approval Required:

All AMT or customer defined Special Processes (welding, plating, heat treating, etc.) must be performed by an AMT or AMT' customer approved source, unless other sources are defined on the Contract. Special processes, once approved may not be changed without written AMT approval.

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PQC-15 Special Process Certification:

The supplier is required to submit with each shipment a certification of all the special processes performed on the delivered part (e.g., NADCAP). The certificate must relate specifically to the part number being purchased and contain the signature of an authorized company representative.

The Certificate of Conformance shall include the quantity processed, the specification number and revision of all special processing performed. Suppliers are not permitted to out-source machining or special process operations without prior written authorization from AMT.

PQC-16 Dimensional Test Data Supplied With Each Shipment

- A. In process dimensional inspection data per PQC 4e or other specified AQL requirement shall be supplied with each shipment against this order. The data shall be representative of the parts and manufactured lot being shipped. At a minimum the report shall contain the balloon #, drawing note/characteristic, actual value, inspection instrument used, job/lot#, drawing # and its revision.
- B. 100% inspection report required for each part shipped. Each design characteristic shall have a unique identifier (typically in the form of a ballooned drawing). The ballooned drawing shall have 100% accountability for all design features and notes. At a minimum the report shall contain the balloon #, drawing note/characteristic, actual reading, inspection instrument used, job/lot#, drawing # and its revision.

PQC-17 Restriction of Hazardous Substances (RoHS):

The supplier shall provide with each delivery a C of C stating that all materials supplied are within the limits for hazardous substances as established by EU Directive 2002/95/EC. Should any material not comply, the concentration of the hazardous substance shall be reported on a chemical test report. Material supplied shall contain no metallic mercury and shall be free from mercury contamination. The supplier will be required to certify that the product is mercury free. At the discretion of AMT the material may be rejected and returned to the supplier if the concentration of the hazardous substance is over the established limits. AMT also reserves the right to request a written plan from the supplier detailing the necessary steps required to bring the material into compliance and the date when compliance will be established. Certification to meeting RoHS requirements must be included on the C of C.

PQC-18 Superceded by PQC-17

PQC-21 Non-Conventional manufacturing methods:


Unless required by the drawing, specification, or Contract, the supplier may not use EDM, ECM, laser or abrasive water jet cutting or drilling, flame spray coatings, or any other non-conventional manufacturing method without written approval from the AMT Buyer.

PQC-27 Customer Specific Flow Downs:

Inclusion of this PQC indicates customer specific flow downs have been included on the Contract.

PQC-30 DFARS 252.225-7008-7009-7012 Applies:

Per DFARS 252.225-7008-7009-7012: If the metal or component(s) for this order contain "Specialty Metals" then these "Specialty Metals" must be MELTED in the United States or in a Qualified Country as defined in the Defense Federal Acquisition Regulation Supplement 225.003(9). This requirement applies to every sub-tier under Contract with your company. The vendor supplier C of C must show compliance to DFARS.

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PQC-31 ITAR:

This document, which includes any attachments and exhibits hereto, may contain information subject to International Traffic in Arms Regulation (ITAR) or ExContractrt Administration (EAR) of 1979, which may not be exContractrted, released, or disclosed to foreign nationals, inside or outside the United States, without first obtaining an exContractrt license.

PQC-32 Shelf Life (of age sensitive components)

The supplier shall assure that all limited life components used or contained within provided assemblies are within their respective shelf life at the time of installation or use. The supplier shall record and maintain documented evidence of compliance with this requirement for each of the limited life components and consumables used for each assembly. This documented evidence is not required to accompany shipment of assemblies; however, it shall be retained and shall be made available upon request.

PQC-33 REACH Compliance:

All goods provided shall be compliant to REACH regulations. The supplier shall bear full responsibility for continuous monitoring of the publication and updates of the European Chemicals Agency list of Substances of Very High Concern (SVHC) and immediately notify AMT if provided goods will contain greater than 0.1% by weight or substances restricted under Annex XVII of REACH. (SVHC list is viewable at <http://echa.europa.eu/web/guest/candidate-list-table>). Notification that goods will contain SVHCs shall include the name and weight of the substance(s) and the weight percentage present, if greater than 0.1% by weight of the delivered good. Presence of SVHCs less than 0.1% by weight of the delivered goods does not need to be reported. Unreported SVHCs present above the threshold or substances restricted under Annex XVII of REACH, may result in Contract cancellation and/or return of goods. Compliance to REACH shall be included on the C of C.

PQC 34 Serialization:

Each part, component, or assembly furnished on this Contract shall be identified with a distinct serial number. Serial number shall not be duplicated on one part, component, or assembly number when manufactured in sequential lots. Marking of serial number shall be per AMS 478 / MIL-STD-130, or in the applicable specification.

PQC 35 Elevated AQL Inspection levels

When PQC 35 is specified the minimum AQL's listed below shall be followed:


Specification	AQL Level
Tolerance range greater than .004	2.5
Tolerance range less than or equal to .004	.65
Any angle tolerance range less than 1 degree	.65
Any critical characteristics	100%
Visual Inspections	100%

Per C=0 Sampling Plan

PQC 36 Material Validation

The supplier shall ensure and provide documented evidence that critical parameters and key characteristics of metallic raw materials are validated by a NADCAP accredited or A2LA approved, independent laboratory (a source other than original Mill source) on first receipt from each supplier or distributor of raw materials and on an annual basis thereafter.

The validation documents must certify that the chemical composition, element analysis, maximum impurity levels, microstructure, and physical properties of the material conform to the design specification. (Example; material and or test specifications indicated on order)

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PQC 37 Hardness Validation

When a hardness value is specified on the engineering drawing, industry material specification (AMS,ASTM, etc.) or any Contract flow down, a re-validation (second hardness verification) shall be performed and documented prior to shipment to AMT. The re-validation performed shall be performed by qualified parties impartial and independent of the original verification.

PQC 38 Age Sensitive Material


The supplier is required, when age sensitive material is specified on the Contract, to submit with each shipment a certificate attesting to the conformance of the material(s). Age sensitive materials shall be identified and packaged in accordance with the applicable procurement specification. Product shall, as a minimum, be identified on each container or certification with the following:

- a) manufacturer's name
- b) batch number
- c) storage temperature
- d) comContractund/spec number
- e) date of manufacture
- f) manufacturer's recommended expiration date (if applicable)
- g) shelf life, cure date, retest date (if applicable)
- h) comContractund number, etc. so as to indicate useful life of the material (if applicable)

Any applicable special storage requirements shall be defined.

Material that has an expiration date shall have a minimum one year, or 80% of specified life if shelf life is less than one year, at the time of delivery to AMT unless otherwise stated on the Contract.

(end of document)

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Appendix A
(Packaging Details)




Symbols Used test



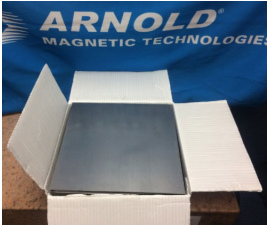
BOX



Boxes can be any size or shape




SHIELDED BOX




Shielded boxes are metal lined




MAGNETS


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! Only one part number per box permissible



**Shielded boxes shall contain only one part number.
Shielded boxes cannot be used for overpack.**

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PN 2

PN 1

PN 3




PN 3


PN 1

PN 2

Shielded boxes shall contain only one part number




Paperclip Test




PN 2

PN 1

PN 1







PN 2

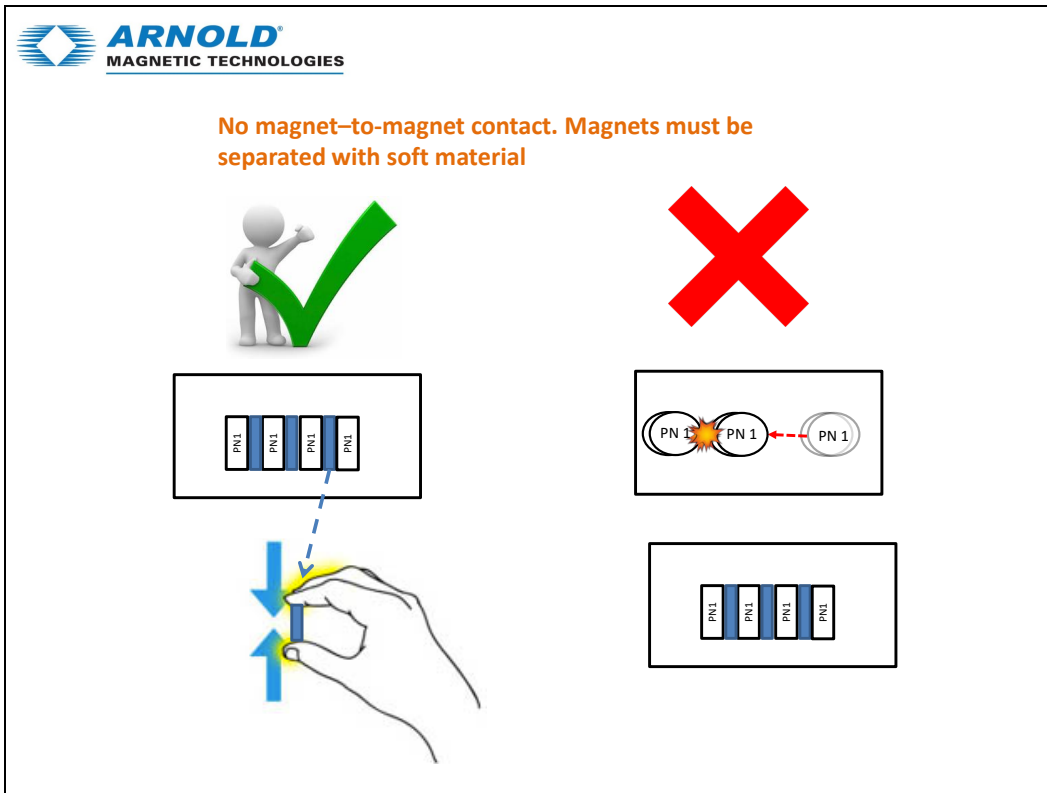
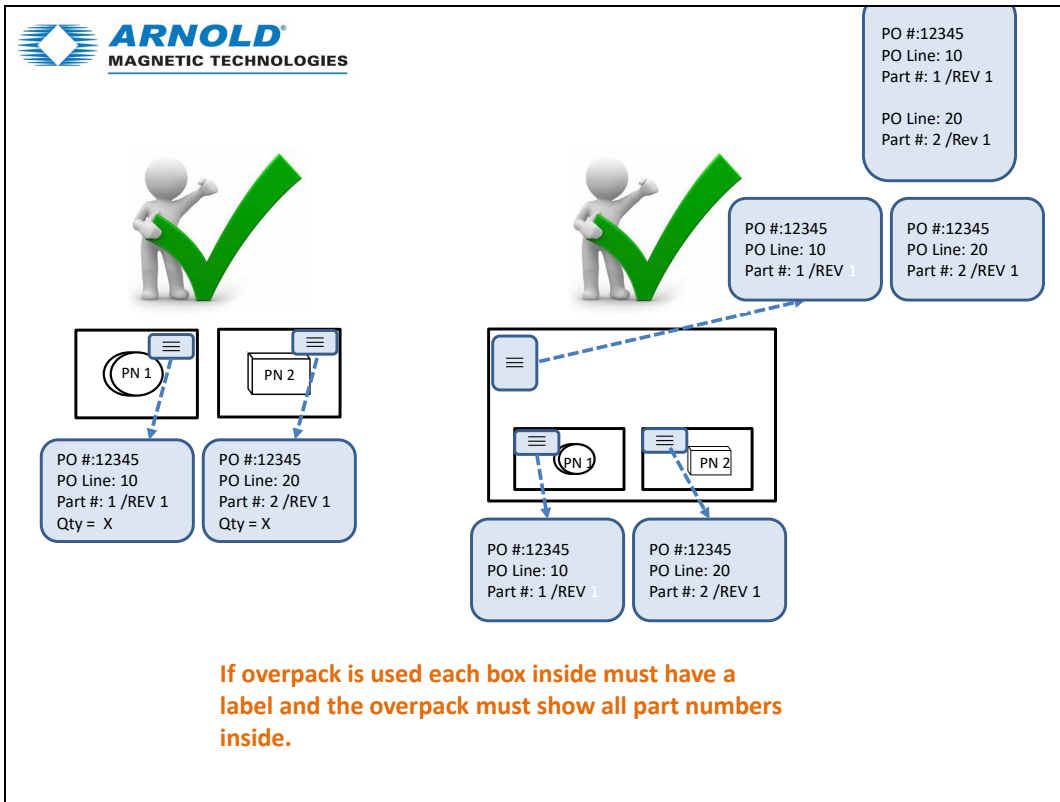
PN 1


PN 1



A paperclip must not stick to the outside of the box

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Packing Materials








Use of newsprint is forbidden

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Revision Log					
<u>REV</u>	<u>DATE</u>	<u>SUBMITTED</u>	<u>APPROVAL</u> (Proc. Owner)	<u>APPROVAL</u> (Quality)	<u>DESCRIPTION</u>
19	01JUN2018	C.Smith	M Carney	E. Bourne	Added new section 4a defining product safety requirements IAW AS900D. Added clarification for FAI requirements.
20	14FEB2019	F. LaFranco	M. Carney	E. Bourne	<ul style="list-style-type: none"> - Added PQC 38 - 4,e) Added requirements of the Inspection report - Removed Document 8.2.4.7.3(PQC-6) - Removed The PQC's in parenthesis in section 4
21	29OCT2019	M Carney	M. Carney	E. Bourne	Updated section s. Added Section t and u. PQC-28 now included in section S PQC-29 moved to General Requirements section u. Added appendix A.
22	20OCT2021	B Borowiec	B Borowiec	E. Bourne	Add Counterfeit Material, standardized all references to the PO as "Contract", updated Work Transfers, Document Alteration, and other content updates.