

Proterial Cable America, Inc

High Performance Medical Solutions Division

QP-8.4a	Procurement Quality Clauses		
Issued by: Jessica Frink		Effective Date: 5/19/2022	Rev. 02 Pg. 1 of 15
Approved: 5/13/2022 7:31 AM Reanna Banker, QA/QC Supervisor HTMF	Approved: 5/18/2022 2:07 PM Jessica Frink Quality Compliance Assurance Manager		

Purpose/Scope: This document specifies the standard Procurement Quality Clauses (PQC) as applicable and defined on HTMF Purchase Orders. The notes below shall apply to every HTMF purchase order in addition to the Purchasing Terms and Conditions and the applicable Procurement Quality Clauses below. Should conflicts or disputes arise between the PQC clauses and other requirements or specifications, the Purchase Order shall take the highest precedence.

Notes

A: Counterfeit Parts, Malpractice and Fraud/Falsification

The requirements (definitions) of the United States Federal Acquisition Regulation (FAR) 52.211-5 are hereby applied (in its current form at time of order). A link to "FARSite" is at the bottom of this note, and it is the Seller's responsibility to understand the FAR clause and to verify the current revision at the time of purchase order placement. For Level 1/SUBSAFE components/materials the FAR 52.211-9005 Conditions for evaluation and acceptance of offers for critical safety items applies (in its current form at time of order). The Seller is obligated to ensure that the material(s) being delivered are new and authentic. To exhibit that the materials are new and authentic the Seller shall, when requested, provide traceability of the material(s) back to the Original Component Manufacturer (OCM) or the Original Equipment Manufacturer (OEM), this includes mills and foundries. When requested by HTMF, it is the Seller's responsibility to provide documented traceability that presents complete and compelling support that the materials procured/provided are legitimate and not misrepresented in any manner. HTMF functions under the laws of the United States (US/USA) with the knowledge that these laws and regulations are subject to change without notice. It is the Seller's responsibility to understand the meanings and implication of fraud, falsification and misrepresentation regarding material(s) and documentation as it applies. FAR clauses can be found at: <http://farsite.hill.af.mil/>

B: PQC Location/Revisions

It is the supplier's responsibility to ensure that the latest revision of the Procurement Quality Clauses is used to fulfill the requirements of the Purchase Order.

C: Requirement Flow Down

It is the supplier's responsibility to flow down all applicable PQC clauses to their subcontractors.

D: Specialty Metals

DFARS 252.225-7008, Restriction on Acquisition of Specialty Metals and 252.225-7009 Restriction on Acquisition of Certain Articles Containing Specialty Metals are requirements on many of our contracts and are hereby flowed down to all suppliers as a requirement. All metals supplied must be sourced from a qualifying country as listed in DFARS Subpart 225.003. This includes stainless steel and titanium. If you have questions or concerns, please notify your buyer; do not supply any metals that are sourced from a country that is not listed in 225.003. DFARS clauses can be found at: <http://farsite.hill.af.mil/>

QP-8.4a	Procurement Quality Clauses	Rev. 02	Pg. 2 of 15
---------	-----------------------------	---------	-------------

Procurement Quality Clauses

Quality Clause Number	Title
001	Inspection System Requirements
002	Certificate of Conformance
003	Material Traceability
004	Identification of Limited Shelf Life Materials
005	Chemical, Physical, Mechanical Test Reports
005A	Chemical, Physical, Mechanical Test Reports for Non-Metallic Material
005B	Special Requirements for NiCu, NiCuAl & CuNi
006	Test Reports
006A	Tooling and Equipment Used for Test Reports
007	Mercury Free Clause
008	Calibration System Requirements
009	Quality Requirements for Calibration Services
010	Nondestructive Test Reports
011	Certifications for Heat Treat
011A	Heat Treat (Additional Requirements)
012	Source Inspection Option
013	Level 1/SubSafe Requirements
014	Qualified Product
015	Buy American
016	Seamed Pipe
017	Acceptable Material Substitutions
018	Control of Unclassified Government Issued for a Purchase Order
019	Effective Revisions of Specifications (GDEB Only)
020	QC Requirements (For GDEB orders Only)
021	Deviations/Non-Conformances
022	Documentation Controls/Export Controls
023	Marking Requirements
024	Finish Requirements
025	Supplier Responsibility
026	Inspection Sampling
027	Acceptance or Rejection of Rated Orders
028	Level 1 Special Traceability Requirements
029	Hazardous Material
030	Required Alloys to QQ-C-390 ASTM Substitutions
031	Nicual QQ-N-286

001 INSPECTION SYSTEM REQUIREMENTS

A. HIGHER LEVEL QUALITY REQUIREMENTS

The Seller shall establish and maintain an inspection system that complies with specifications MIL-Q-9858, MIL-I-45208, ISO9001, or another acceptable standard. Satisfactory compliance with this requirement does not relieve the Seller of the responsibility to furnish acceptable parts or services as specified in the procurement documents.

B. COMMERCIAL INSPECTION SYSTEM

The Seller shall establish and maintain an inspection system to assure product compliance with drawing, specification, and purchase order requirements. Satisfactory compliance with this requirement does not relieve the Seller of responsibility to furnish acceptable parts or services as specified in the procurement documents.

002 CERTIFICATE OF CONFORMANCE

Each shipment must be accompanied by a Certificate of Conformance stating that the material supplied conforms to all purchase order, drawing, and specification requirements. The certification must identify Purchase Order #, part numbers, part names, material heat/lot numbers, serial numbers, quantities, date, Seller's company name, address & phone number, and the printed name, title, and signature of an authorized representative of the Seller. The recording of false, fictitious or fraudulent statements or entries may be punished as a felony under Federal Statutes, including Federal Law, title 18, chapter 47. HTMF encourages their suppliers to exercise awareness of Malpractice Prevention and understand how it can negatively impact an organization and result in dire long-term consequences. If you require additional information on this subject please contact our Quality Department. Transcription of certification data is prohibited. All corrections & additions to quality documents must be performed by drawing a single line through the incorrect entry, initial & date each correction or addition. DO NOT erase, obliterate or use whiteout correction fluid or tape.

The Certificate of Conformance for parts and services require a statement that dimensional attributes and characteristics have been verified and found to conform to drawing and/or specification requirements, as required by purchase order. For parts machined to HTMF prints and for Level 1 parts and military fasteners, the supplier is also required to provide attributes inspection data reflecting the inspection was conducted and that the parts are acceptable.

Note: Parts and/ or assemblies may not vary from applicable drawings, specifications, etc. in material, dimensions, configuration, process, identification, testing, certification or any other requirements without specific approval in advance, in writing, signed by HTMF Quality Assurance. Certifications that contain statements such as "is equal to", "is similar to", "to the best of my knowledge", etc. are not acceptable.

003 MATERIAL TRACEABILITY

Parts manufactured for this purchase order must be traceable to raw material used. All parts are to be segregated by heat or lot number and shipping containers identified with the applicable heat or lot number. If specified in the purchase order, parts are to be marked with the heat or lot number as described in the purchase order. A Certificate of Conformance containing the heat or lot number of materials must be supplied with each shipment.

Level 1 materials of different types (alloys), grades, or conditions shall be segregated through physical separation unless readily differentiated by attributes such as size, physical identification, or physical appearance. The method of segregation shall assure that similar appearing material of different alloys and/or material conditions are not mixed. Material requiring traceability shall be segregated from non-traceable material. Non-conforming material shall be identified and segregated from acceptable material.

If the material is supplied by the Seller, chemical, physical and mechanical test reports for raw materials must be on file and available for review by a HTMF Quality Representative upon request.

If the parts or material are supplied by HTMF the Seller shall supply a certification stating that only the parts or material furnished were used in the performance of the Purchase Order. The certification shall contain the heat/lot number of the material used and serial numbers of the parts supplied by HTMF. Identification (Traceability Markings) of this material shall be maintained throughout the manufacturing cycle. The method and location is as required by drawing. Return all excess material to HTMF. Vendor must certify that raw material furnished by HTMF has not been chemically or metallurgically treated by vendor so as to change surface or internal condition.

004 IDENTIFICATION OF LIMITED SHELF LIFE MATERIALS

The Seller shall identify each container or package of limited shelf life materials with the date of manufacture, expiration date, special storage conditions (if required), lot number, name, type, and quantity. The certification for material supplied shall also include this information.

Note: With the exception of O-rings and packings, material must have at least 80% of its shelf life remaining when received by HTMF.

A. O-RINGS and PACKINGS

Sellers of rubber O-rings and packings shall provide certification that the material furnished is in accordance with the applicable specification requirements. The certification shall include PO number, material description, specification number and revision, lot number and cure date. The cure date shall be no greater than seven years from the ship date.

QP-8.4a	Procurement Quality Clauses	Rev. 02	Pg. 5 of 15
---------	-----------------------------	---------	-------------

005 CHEMICAL, PHYSICAL and MECHANICAL TEST REPORTS

Each shipment must be accompanied by original mill certifications and chemical, physical and mechanical test reports required by the specification referenced in the purchase order. The test reports must bear the printed name, title and signature of an authorized representative of the agency performing the test. Electronic Signatures are not allowed without approval.

In the case of raw materials each part shall be marked with the heat and/or lot number. In the case of parts or assemblies, each part, assembly, container or package of material shall be identified with the heat and/or lot number as well as part number. Original mill certifications and test reports shall be supplied for any weld filler material used.

Change or unauthorized alterations are not allowed on another organization's document.

005A CHEMICAL, PHYSICAL and MECHANICAL TEST REPORTS FOR NON-METALLIC MATERIAL

Elastomers, adhesives, lubricants, plastics, potting materials, etc. The supplier shall furnish a copy of the Manufacturer's lot report or similar document, detailing compound Name, Date of Manufacture, Date of Expiration, Lot Number, etc. The report must reflect the printed name, title and signature of an authorized representative of the agency issuing the document. Lot numbers shall appear on all parts, materials or their packaging.

005B SPECIAL REQUIREMENTS FOR NICU, NICUAL & CUNI

Special requirements for the sulfur content of the gas and oil fuels used in firing furnaces for forging, extruding, or other hot working processes and for heat treatment of NiCu (UNS N04400), NiCuAl (UNS N05500), CuNi (UNS C70600 and C71500), and other nickel or nickel base alloys shall be limited to 30 Grains per 100 cu. ft. maximum for Gas, and 0.5% by weight maximum for Oil as require by EBSC 60-33.

All nickel-copper-aluminum alloy material (UNS N05500 / K500) used in the fabrication of parts to be supplied on this contract shall be produced by Special Metals (Huntington/Inco Alloys), Allvac or Electralloy. Material must be in accordance with QQ-N-286 revision F or G as modified by EBSC 10-110. Chem/Mech properties of QQ-N-286 NICUAL are to be provided in accordance with EBSC 76-80.

006 TEST REPORTS

Each shipment shall contain a test report, identifiable to the submitted material by part number, Heat/Lot number and serial number, confirming that the required design and operational tests have been performed and that the applicable data, including but not limited to dimensional inspection reports, hydrostatic or operation pressures, hydraulic or pneumatic flows, pressure drops, temperatures, megger readings, power, voltages, currents, frequencies, rpm loads, strengths, time, etc. have been recorded. If more than one Heat/Lot number is involved, it must clearly indicate which S/N's correspond to which Heat/Lot number. The Test report certification shall contain printed name, title, and signature of an authorized representative confirming that

the reports of the tests are on file and that the results of the tests conform to the requirements of the purchase order. The test report contents must conform to the requirements of the controlling specification, such as a NAVSEA Technical Publication, Drawing or a Military Standard.

006A TOOLING AND EQUIPMENT USED FOR TEST REPORTS

Tooling/ Equipment used to take measurements or values recorded on a Test Report or document must be listed on the Test Report or document. Listing must include tool number, calibration date and recalibration due date.

007 MERCURY FREE CLAUSE

Each shipment shall contain a certification stating that the material supplied on the purchase order shall be mercury-free and shall conform to the clauses specified herein.

DEFINITION: Mercury-Free is material that does not contain functioning mercury and is not contaminated by mercury or mercury containing compounds.

Mercury or mercury containing compounds shall not be intentionally added or come in contact with hardware or supplies furnished under this contract.

The presence of mercury in a product may be determined by checking product labeling or material safety data sheets. Chemical analysis is not required. If the mercury vapor concentration is .01 Mg/ M3 or more, the material is considered contaminated.

Reference: NAVSEAINST 5100.3D

008 CALIBRATION SYSTEM REQUIREMENTS

The seller shall establish and maintain a calibration system that complies with ANSI/ NCSL Z540, ISO10012, or ANSI/ ISO/ IEC 17025 using reference standards whose calibration is certified as being traceable to the N.I.S.T. Records of calibration shall be maintained and available for review.

009 QUALITY REQUIMENTS FOR CALIBRATION SERVICES

All calibration performed for HTMF shall be accomplished in strict conformance to ANSI/ NCSL Z540 or ANSI/ ISO/ IEC 17025 in effect at the time of order. Certification of calibration is required with this order. Certification must conform to ANSI/ ISO/ IEC 17025 Paragraph 5.10 excepting 5.10.3.

In addition to the information required above, the calibration certification shall include a statement to the effect that the standards used in obtaining the results have been compared or are traceable to the NIST standards. All items calibrated shall have a tag or label applied that includes the name of the company performing the calibration, the date calibrated and the recalibration due date.

010 NONDESTRUCTIVE TEST REPORTS

Each shipment must contain a test report indicating the actual results of all required nondestructive tests performed. The report shall identify the date tested, the material by part number, part name, serial number(s), material heat number(s) and quantity. If multiple heat numbers are used, the report must clearly indicate which serial number(s) relate to which heat number(s). The report shall list the test specification, approved procedure identification, the acceptance criteria, type and method used, and the accept/ reject status of the material tested. The report shall call out the applicable revisions and amendments of all specifications and procedures listed and bear the printed name, title, and signature of the authorized representative of the agency performing the test(s). For dye penetrant test, all chemicals used must be listed with brand, type and batch numbers and must be listed on AMS2644 QPL (QPD-2644). Parts tested must be uniquely identified with a serial number. All testing must be accomplished using approved NDT procedures. Vendors must supply current Inspector vision test and qualification data covering all procedures/ tests performed, such as liquid penetrant testing, visual weld inspection, ultrasonic testing, etc. The assigned quality clause on the Purchase Order may contain multiple requirements such as 11A, 11B, 11D & 11F.

NDT testing and NDT personnel certification shall meet the requirements of NAVSEA T9074-AS-GIB-010/271, latest revision shall apply unless indicated otherwise on the purchase order. All documents must reference the applicable revision of this specification.

A: Dye Penetrant Testing Type II (Visible Dye), Method “A” (Water Washable)

1. Method “A” shall not be used on welds. Method “A” is approved for inspection of threads. This method may be used for the entire part under test. Method “A” shall be accomplished prior to welding to ensure all surfaces are inspected.

B: Dye Penetrant Testing Type II (Visible Dye), Method “C” (Solvent Removable)

1. Method “C” shall not be used for threaded surfaces. Method “C” is approved for inspection of welds. This method may be used for all but threaded surfaces. Method “C” is commonly accomplished post welding (root and final pass as applicable) or for parts without threads.

C: Dye Penetrant Testing Type III (Visible and Fluorescent Dye – dual mode), Method “A” (Water Washable)

1. Method “A” shall not be used on welds. This Method “A” is approved for inspection of threads. This method may be used for the entire part under test. Method “A” shall be accomplished prior to welding to ensure all surfaces are inspected.

D: Visual Testing of root weld (layer) in accordance with NAVSEA S9074-AR- GIB-010/278, Class A-2, para 10.3.3, Table X, Note 3

1. A Visual test of the root weld (e.g. cover on hull penetrator) at 5X magnification may be substituted for an MT/ PT inspection

E: Ultrasonic Testing of raw material prior to machining

QP-8.4a	Procurement Quality Clauses	Rev. 02	Pg. 8 of 15
---------	-----------------------------	---------	-------------

F: Ultrasonic Testing of raw material prior to machining; Longitudinal Wave method required.

G: Material Ultrasonic or Magnetic Particle Testing shall be per MIL-STD-271/ T9074-AS-GIB-010/271, acceptance criteria shall be as specified by purchase order. Revision will be latest or as referenced on Purchase Order.

011 CERTIFICATIONS FOR HEAT-TREAT

Certifications for heat-treat per specification & drawing requirements are required for this order. The certification shall include all applicable tests and inspection results as required by specification including specification number, type and class revision of specification. All material uniquely identified by lot number shall be heat treated in a single furnace load.

011A HEAT-TREAT (w/ ADDITIONAL REQUIREMENTS)

When heat treatment is required or performed, a record of the heat treatment is required. Records of heat treatment shall include, as a minimum: specific times and temperatures, quantity of items and item name, date of heat treatment, and the material identification that provides positive traceability to objective quality evidence. This data must be cited on a document generated by the heat-treating facility and must contain a mercury free statement.

012 SOURCE INSPECTION OPTION

HTMF, its customer(s), and/or the Government reserve the right to inspect and/or test all or any of the materials and associated documentation covered by this purchase order at the supplier's facilities or their sub-tier supplier's facilities at any time.

013 LEVEL 1/ SUB-SAFE REQUIREMENTS

The material covered by the purchase order will be used in a crucial shipboard system. The use of incorrect or defective materials and/or procedures may create a high probability of failure, resulting in serious personal injury, loss of life, loss of vital shipboard systems, or loss of the ship itself. Therefore, the following guidelines must be met:

- Special controls and handling shall be instituted to ensure receipt of correct material. This includes proper segregation of conforming material from non-conforming material, segregation of items with different identity and traceability & control of the material through all your processes.
- The requirements of HTMF SOP (QP-8.2.3a, Level 1 requirements) must be met.
- If raw material is to be supplied, the requirements in DI-MISC-81020 form a part of this order. Reference at quicksearch.dla.mil.
- Non-Level 1/ SUB-SAFE items that have a direct bearing on Level 1/ SUB-SAFE parts, such as Test Specimens for Tensile Testing or Material Certification shall be treated the same as Level 1/ SUB-SAFE parts or material.

QP-8.4a	Procurement Quality Clauses	Rev. 02	Pg. 9 of 15
---------	-----------------------------	---------	-------------

014 QUALIFIED PRODUCT

Manufacturers of products supplied must be on the Qualified Product List (QPL) and supply certification. Any supplier that makes any changes to a product on the QPL, such as changes to the material, chemical content, dimensions, testing, process, etc., not specifically authorized by the certifying agency, shall not deliver the affected product as a QPL item without proof of recertification.

015 BUY AMERICAN

Supplies/Raw Materials procured on this purchase order must comply with Defense Acquisition Regulations System (DFARS) 252.225-7001 Buy American Act. DFARS clauses can be found at [252.225-7000 Buy American Act - Balance of Payments Program Certificate. \(osd.mil\)](https://www.osd.mil/252.225-7000-Buy-American-Act-Balance-of-Payments-Program-Certificate)

016 SEAMED PIPE

Due to the potential high pressure that may be experienced in the mission profile environment, the delivery of seamed pipe is prohibited. Suppliers shall only deliver seamless pipe on HTMF purchase orders.

017 ACCEPTABLE MATERIAL SUBSTITUTIONS

Commercial specifications that are equivalent or have replaced Military/ Federal specifications must first be approved by HTMF prior to substitution.

018 CONTROL OF UNCLASSIFIED GOVERNMENT DOCUMENTS ISSUED FOR A PURCHASE ORDER (PO)

When this clause is invoked, the documentation distributed with the PO is to be handled and secured in a manner as defined herein. Documentation associated with this PO cannot be viewed by anyone that is not a US citizen or a Lawful Permanent Resident of the US/ USA without permission flow-down from the US Department of State.

The documentation that was distributed by HTMF, or for HTMF by another government agency, does not carry a US security classification; however specific notifications on the drawing provide knowledge regarding handling.

If the document has a "Distribution Statement 'B, C, D, E, or F", *example* –DISTRIBUTION STATEMENT D: Distribution authorized to Department of Defense and U.S. DoD contractors only- (or similar wording) the document should be filed from view when not in use. Putting the hardcopy document in a folder, file, draw, etc.; so, it is not visible, is sufficient provided the building is secured. If the building is open to the public then it is recommended the document be stored in a manner that is not accessible to the public providing at least one barrier (locked file, room, etc.). If the document is electronic it must be stored in a protected manner providing at least one barrier from public access.

An active firewall is considered a protective barrier from the internet. A secured folder on an internal file server that eliminates public access is a protective barrier. These unclassified documents shall not be distributed electronically to others without HTMF knowledge to ensure proper controls are maintained. To share files securely it must be transmitted over official email channels (personal emails are not secure and should never be used) and sent via a secured file transfer system such as Kite, and password protected. Information may be mailed by regular US Postal Service first class or any commercial mailing service.

Management of unclassified documents after intended use is complete: Unclassified documents marked with Distribution Statements B, C, D, E, or F shall be destroyed by any method that will prevent disclosure of contents or reconstruction of the document. When local circumstances or experience indicates that this destruction method is not sufficiently protective of the information, local authorities may prescribe other methods but must balance the additional expense against the degree of sensitivity.

If the document has an ITAR stamp or statement (aka Export Control) the document cannot be viewed by anyone that is not a US citizen or a Lawful Permanent Resident of the US/ USA without permission flow-down from the US Department of State. The document controls established for Distribution Statement unclassified documents apply.

The supplier is obligated to maintain compliance with DOD Directive 5230.24. It is the supplier's responsibility to understand the DOD Directive and to verify the current revision at the time of purchase order placement. [distribution statements and reasonsSept2018.pdf \(dtic.mil\)](#)

019 EFFECTIVE REVISIONS OF SPECIFICATIONS (GDEB ORDERS ONLY)

The effective revisions of invoked specifications shall be determined as follows:

- a) When a revision is cited in the purchase order, only that revision shall be used. However, where the supplier has a need to use an alternate revision, that revision may be used without further approval when it is within the range of revisions listed for the same specification and designated with a interchangeability code of an * (Asterisk)

Where the specification revision is not within the range of revisions listed for the same specification as described above, a VIR requesting authorization to use the same alternate revision is required.

- b) When a revision is not cited in the purchase order, any revision listed in EB2P756 may be used.
- c) When a specification is not cited in either the purchase order or EB2P756, any issued revision may be used

(Note: When EB2P756 ([eb2p756VA.pdf \(gdeb.com\)](#)), the NSSN/SSGN specification effectivity index, is referred to above, the supplier may use any version which has been provided by the buyer, not to be dated any earlier than 6 months prior to the date of the applicable purchase order.)

020 QC REQUIREMENTS (FOR GDEB ORDERS ONLY)

Electric Boat Corporation specification EB2678 (latest revision) unless indicated otherwise on the PO, applies to all procurement of materials, parts, etc. for General Dynamics Electric Boat products, this document is available at the following website:

[EB2678N.pdf \(gdeb.com\)](#)

021 DEVIATIONS/ NON-CONFORMANCES

Deviations or Nonconformances from the purchase order requirements are not allowed without specific prior approval. Configuration Control IAW MIL-STD-973.

In the case of conflicts within procurement data the following order of precedence applies:

- Applicable VIRS or deviations/ Waivers, as applicable
- Supplements/ Modifications to the contract/ Purchase order
- Purchase order exclusive of other references
- Appendices/ Exhibits/ Attachments
- Drawings & Specifications
- Other plans or documents referenced in the customer order

All requests for departure from requirements are to be accompanied by root cause analysis and preventative corrective action to preclude recurrence. If not available at the time of submittal data is to be provided with 14 days.

022 DOCUMENTATION CONTROLS/ EXPORT CONTROLS

All Objective Quality Evidence pertaining to parts, process and/or services is required to be maintained on file no less than eight years.

NOFORN – Documents are subject to special export controls and each transmittal to foreign governments of foreign nationals may be made only with prior approval of the Naval Sea Systems Command.

Distribution of documentation and communications are restricted due to export controls. As items are critical technology no further distribution is authorized without written approval.

WARNING - This document contains technical data whose export is restricted by the Arms Export Control Act (Title 22, U.S.C., Sec 2751, et seq). or the Export Administration Act of 1979, as amended, Title 50, U.S.C., App. 2401 et seq. Violations of these export laws are subject to severe criminal penalties. Disseminate in accordance with provisions of DoD Directive 5230.25.

DESTRUCTION NOTICE - Destroy by any method that will prevent disclosure of contents or reconstruction of the document.

EXPORT CONTROL - Suppliers providing product from other countries must comply with ITAR (International Traffic in Arms Regulations) controls and regulations.

023 MARKING REQUIREMENTS

Marking to be completed IAW MIL-STD 130 as instructed per PO and/or applicable part drawing notes.

024 FINISH REQUIREMENTS

Finish to be completed IAW PO and applicable part drawing notes.

025 SUPPLIER RESPONSIBILITY

The supplier is responsible for the performance of all inspection & test requirements specified herein as necessary to ensure supplies & services conform to prescribed requirements.

The purchase order is the primary document and takes precedence when conflicts, ambiguities or disputes arise including over all existing specification & drawing requirements. When issues cannot be resolved contact the HTMF Quality Department to address any concern(s).

Forged product must be supplied by an approved source. For a list of approved sources of forged material go to http://www.gdeb.com/suppliers/10_quality/Forging_Suppliers/.

CUNI (Copper Nickle) castings must be supplied by and approved source. For a list of approved sources of CUNI castings, go to [General Dynamics Electric Boat \(gdeb.com\)](http://www.gdeb.com)

Suppliers are responsible for ensuring the integrity of all material. Alloy identity lot sample testing is one method to insure the statistical probability of ongoing compliance to specification.

HTMF requires their suppliers exercise awareness of Malpractice Prevention and understand how it can negatively impact an organization and result in dire long-term consequences. If you require additional information on this subject please contact our Contracts or Quality Dept.

Supplier shall insure that no counterfeit parts are used or supplied to HTMF. Refer to EBSC 60-87 for details of controls and flow down notification to sub tier suppliers.

The Certificate of Conformance for parts and services require a statement that dimensional attributes and characteristics have been verified and found to conform to drawing and/or specification requirements, as required by purchase order. For parts machined to HTMF prints and for Level 1 parts and military fastener the supplier is also required to provide attributes inspection data reflecting the inspection was conducted and that the parts are acceptable.

026 INSPECTION SAMPLING

Inspection sampling IAW MIL-STD-105/ANSI Z1.4 general inspection level II, AQL 1.0 for level parts & 4.0 for all others. Level parts require 100% marking & document verification. Inspection includes all required drawing notes and a final visual.

027 ACCEPTANCE OR REJECTION OF RATED ORDERS

This is a rated order certified for national defense use and you are required to follow all provisions of the Defense Priorities and Allocations System (DPAS) Regulation (15 CFR 700).

The DPAS Rating(s) for this request for quotation/purchase order are specified at the line item level and may vary by line item.

A Seller shall accept and fill rated orders regardless of any other rated or unrated order that have been accepted. Rated orders can only be rejected for the reasons specified in 15 CFR 700.13(b) and 15 CFR 700.13(c).

Further flow down of the priority ratings may be required. Seller agrees to schedule the materials described herein abiding by the DPAS priority rating stated in this request for quotation/purchase order.

Seller is required to acknowledge its acceptance or rejection of any resulting purchase order in writing (hard copy), or in electronic format, within fifteen (15) working days after a receipt of a DO rated order and within (10) working days after receipt of a DX rated order by completing and submitting the purchase order acknowledgement, which indicates suppliers receipt and acceptance of a DPAS rated order. If the order is rejected, the seller must give reasons in writing or electronically for the rejection in accordance with 15 CFR 700.13(d).

Any supplier who places or receives a rated order should be thoroughly familiar with, and must comply with, the provisions of this regulation.

028 LEVEL 1 SPECIAL TRACEABILITY REQUIREMENTS**General**

The traceability requirements in this section apply to all outside vendors (ex. Heat Treat, Plating, NDT, etc.)

Material Handling and Storage

Level 1 materials of different types, grades or conditions are physically separated in a controlled area unless readily differentiated by size, ID, or appearance. Materials must be separated from different alloy or grades that appear similar and Level 1 materials are always segregated from non-Level 1 materials.

Non-conforming material must be segregated, marked and stored away from acceptable product.

Marking Requirements for Raw Materials and Finished Product

Permanent marking is required on all Level 1 material, separately furnished or in assemblies.

The permanent marking must be legible, not affect form, fit, function and provide the following information, listed in the order of precedence. Additional marking to that required below is permitted where required by the purchase order or specifications therein.

QP-8.4a	Procurement Quality Clauses	Rev. 02	Pg. 14 of 15
---------	-----------------------------	---------	--------------

- (1) The kind of Material: The specific material designator in accordance with the purchase order.
- (2) Traceability Code: A code that provides positive traceability to the unique OQE of the piece of material including homogeneous heat, melt, or batch and inspection information. This unique code is either assigned by HTMF or is the material heat number.
- (3) The Supplier's Name, Trademark, or Symbol. If all the marking cannot be applied due to space limitations, the Supplier shall request permission of the Purchaser via a VIR of the marking that will be applied using the order of precedence above, and state the reason why all the markings cannot be applied.

When the marking on a part or piece of material is removed by the manufacturing process, the marking is transferred to another location on the piece. If the marking cannot be transferred to another location, it is restored after the completion of the operation. Items too small to mark or items that continually have their marking removed by the various manufacturing operations making it impractical to maintain, can be controlled by the use of totes, bags, and/or boxes identified with the proper traceability information provided the identity is maintained at all times. Items in the same package must be of the same homogenous lot. When removing any material from the package, all material is labeled or tagged with all the markings on the package, unless being removed from the package for immediate installation.

When material is worked or heat-treated, resulting in changes to its mechanical properties, the mechanical properties shall be re-determined, and the material shall be uniquely re-identified to provide traceability to the final heat treatment and mechanical properties of material in its final condition.

Marking is accessible to permit identification without disassembly, except for justifiable situations when alternative methods (e.g., tagging, assembly records, etc.) of identification shall be used to identify these materials.

Marking of fasteners manufactured from hardened material by vibro-etching or integral marking is permitted provided the marking is in an unstressed area. All Level 1 fasteners shall be marked with the kind of material, Supplier traceability code and Manufacturer's name, trademark or symbol. Permanent marking is not required for other hardware located within the pressure boundary that is too small to mark, however, certification statements relating to these small items must be supplied.

In all cases, all documentation must indicate the proper traceability code or raw material heat number and must provide accountability throughout the manufacturing process, including number of pieces cut/accepted/rejected/tested, etc.

Loss of Traceability

Items where the traceability marking is lost shall be considered nonconforming material until appropriate tests have been performed that can absolutely identify the heat from which the item was produced. This requirement is not applicable to items that are uniquely identifiable by their size, configuration and uniqueness of material.

The method of re-establishing traceability shall be approved by the HTMF Purchaser for each incident where traceability is lost. This information shall then be submitted on a VIR to EB by HTMF for final approval.

029 HAZARDOUS MATERIAL

Products and materials considered hazardous as defined by applicable laws and regulations require Material Safety Data Sheets to include full product descriptions.

030 Required Alloys to QQ-C-390 ASTM Substitutions

QQ-C-390 REVISION B, ALLOY C90300 IS ACCEPTABLE FOR QQ-C-390 REVISION B, ALLOY C92200.

WHERE QQ-C-390 REVISION B IS SPECIFIED, THE FOLLOWING SUBSTITUTIONS MAY BE UTILIZED.

ASTM-B61 ALY C92200

ASTM-B584 FOR TY I CASTINGS ALLOY REMAINS UNCHANGED

ASTM-B271 FOR TY II CASTINGS ALLOY REMAINS UNCHANGED

ASTM-B505 FOR TY III CASTINGS ALLOY REMAINS UNCHANGED

031 NICUAL QQ-N-286 FITTING

AT THE OPTION OF THE MANUFACTURER, ITEMS DETAILED ON EB 2621 *----- STANDARD DRAWINGS MAY BE FABRICATED FROM SPECIFIED MATERIAL, CLASS A, EXCLUDING PLATE, OF ANY FORM OR CONDITION MEETING THE FOLLOWING MINIMUM

REQUIREMENTS:

TENSILE STRENGTH, PSI = 130,000

YIELD STRENGTH AT .2 PERCENT OFFSET, PSI = 85,000 ELONGATION IN 2.00 INCHES = 15 PERCENT

FOR NON-WELDED FITTINGS; SPECIFIED MATERIAL, EXCLUDING PLATE, MAY BE OF ANY CLASS, FORM OR CONDITION MEETING THE ABOVE MECHANICAL PROPERTIES.

*(AS REFERENCED IN PART DESCRIPTION)