



Title:

# PURCHASE ORDER QUALITY INSTRUCTIONS

Form #

JE-QW-005-1

Form Rev

F

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2/1/2023

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## DOCUMENT APPROVAL

Approval	Name	Signature	Date
QA Manager	John Malczynski	<i>John Malczynski</i>	2/1/2023

### 1.0 PURPOSE

To define the quality requirements included in J&E Precision purchase orders issued to suppliers.

### 2.0 SCOPE

This instruction applies to all commodities and outside processing purchased by J&E Precision that are used in product sold to customers.

### 3.0 UNUSED

### 4.0 RESPONSIBILITIES

Suppliers are responsible for:

- 1) Implementing the applicable requirements as defined in **Section 5.0** of this document;
- 2) Implementing additional applicable requirements as called out on the Purchase Order;
- 3) Flowing down applicable requirements to sub-suppliers; and
- 4) Contacting J&E Precision QA Department for clarification of any requirements

### 5.0 IDENTIFYING APPLICABLE P.O. QUALITY REQUIREMENTS

The following requirement paragraphs apply to the respective product or service - see below for Q-Notes detailed information. Additional paragraphs identified on the Purchase Order may be invoked as determined necessary by J&E.

#### 5.1 Outside Machining, Purchased Components, & Stampings - paragraphs:

Q1, Q2, Q3, Q5, Q6, Q7, Q8, Q10, Q11, Q13, Q15, Q16, Q27, Q28, Q30, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q45, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q58, Q59, Q60, Q61, Q62, Q64, Q65, Q69.

#### 5.2 Raw Materials - paragraphs:

Q1, Q2, Q5, Q6, Q7, Q8, Q16, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q46, Q48, Q50, Q51, Q53, Q54, Q58, Q60, Q61, Q62, Q64, Q65, Q69.

#### 5.3 Hardware Suppliers - paragraphs:

Q1, Q2, Q5, Q6, Q7, Q8, Q10, Q13, Q16, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q58, Q59, Q60, Q61, Q62, Q64, Q65, Q69.

#### 5.4 Process Suppliers (including Metal Finishing, Thread Rolling, Centerless Grinding) - paragraphs:

##### NOTE: Special Process Suppliers **DO NOT** INCLUDE THE FOLLOWING:

(NDT, FPI, MPI - SEE SECT 6.6), (HEAT TREATING - SEE SECT 6.7), (TENSILE TESTING - SEE SECT 6.8)

Q1, Q2, Q3, Q5, Q6, Q7, Q8, Q11, Q13, Q15, Q16, Q27, Q28, Q30, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q45, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q62, Q64, Q65, Q69.

#### 5.5 NDT, FPI, MPI - paragraphs:

Q1, Q2, Q3, Q5, Q6, Q7, Q8, Q11, Q13, Q15, Q16, Q30, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q45, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q59, Q62, Q64, Q65, Q66.

#### 5.6 Heat Treating - paragraphs:

Q1, Q2, Q3, Q5, Q6, Q7, Q8, Q11, Q13, Q15, Q16, Q30, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q45, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q59, Q62, Q64, Q65, Q67.

#### 5.7 Tensile Testing - paragraphs:

Q1, Q2, Q3, Q5, Q6, Q7, Q8, Q11, Q13, Q15, Q16, Q30, Q31, Q32, Q34, Q35, Q36, Q37, Q40, Q45, Q46, Q48, Q50, Q51, Q53, Q54, Q56, Q59, Q62, Q64, Q65, Q68.

#### 5.8 GAGE CONTROL & CALIBRATION SYSTEM - paragraph:

Q30



	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

Q-Note	Revision	Description
Q1	-	<b>PRODUCT REQUIREMENT</b> Supplier is responsible to provide the necessary resources to deliver products that meet all J&E Precision's and customer requirements in accordance with the purchase order requirements.
Q2	D	<b>QUALITY MANAGEMENT SYSTEM</b> Suppliers shall implement a system to control product and process quality, while fostering continuous improvement, and implementing procedures for processing complaints, nonconformances and corrective actions.
Q2A	-	<b>AEROSPACE QUALITY STANDARD</b> The Supplier shall maintain a Quality Management System in accordance with AS9100, or equivalent.
Q3	A	<b>RIGHT TO AUDIT SUPPLIER</b> J&E Precision Tool, Inc reserves the right to audit the Supplier's Quality System and Products at any pre-scheduled time. J&E Precision shall give prior notification of such visits, to minimize interference with the normal operations of Supplier's plant
Q4	-	N/A (SUPERCEDED BY Q26)
Q5	-	<b>PURCHASE ORDER REVIEW</b> Supplier is responsible to implement a process by which all requirements herein are reviewed prior to acceptance of the purchase order.
Q6	-	<b>REVISION CONTROL</b> Supplier is responsible to maintain control of the latest revision of blueprints, parts list, Mylars, operation sheets, specifications and other such documents as specified in this purchase order.
Q7	-	<b>PROPRIETARY DOCUMENTS, DISPOSAL OF</b> Supplier is responsible to destroy all obsolete blueprints, parts list, Mylars, specifications and other such proprietary documents prior to disposal
Q8	-	<b>J&amp;E PRECISION ACCESS CLAUSE</b> Authorized representatives of J&E Precision, and/or its customer, government or FAA shall have the right to visit the Supplier and its subcontractors facilities at any time during the performance of this purchase order. These visits are for the purpose of ascertaining progress, making inspections, performing surveillance and witnessing tests. J&E Precision shall give prior notification of such visits, to minimize interference with the normal operations of Supplier's plant. Such visits by J&E Precision and/or its customer do not absolve the Supplier of the responsibility to provide acceptable product. Verification by J&E Precision and/or its customer does not preclude subsequent rejection of any nonconforming items.
Q9	-	N/A (COMBINED WITH Q8)
Q10	A	<b>CofC, HARDWARE SPECIFICATIONS</b> The Supplier shall furnish a certification of compliance which states the product conforms to applicable specifications as required by the Purchase Order for Standard Hardware or assemblies that include Standard Hardware (i.e., BAC, AN, NAS, STM, MIL, etc.) are to be satisfied with material of the latest specification revision level in effect and must comply with all obsolescence / replacement criteria when applicable.
Q11	-	<b>BOEING REQUIREMENTS</b> When the drawing and/or specification supplied cites Boeing Process Specification "PS" Document Number then the following requirement shall apply. The supplier and all of its sub-contractors shall use Boeing approved special processors as called out in the Boeing document D1-4426. If the source the supplier plans to use is not listed in the D1-4426, authorization must be obtained from J&E Precision Tool, Inc. prior to use. Boeing document D1-4426 is in <a href="http://www.boeingsuppliers.com/d14426/index.html">http://www.boeingsuppliers.com/d14426/index.html</a> .
Q12	-	<b>MATERIAL, APPROVED SOURCES</b> All suppliers must purchase raw materials from prime customer approved sources when applicable, i.e. D1-4426, or other approval listing. Material produced / procured outside the USA always requires the use of customer approved sources.
Q13	B	<b>SPECIFICATIONS, LATEST REVISION</b> All special processes required by the Purchase Order must be to the latest revision or superceded specification with the latest revision of the applicable process specification, unless otherwise dictated on the Purchase Order.



	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q14</b>	-	<b>APPROVED SUPPLIERS, NORTHROP GRUMMAN</b> All suppliers of special processes must be currently approved to do so by the Northrop Grumman Qualified Supplier Document (Oasis).
<b>Q15</b>	-	<b>SUPPLIED MATERIAL, GAGES AND TOOLING</b> Supplier is responsible to maintain control of all J&E Precision's supplied material, gages and tooling. Any such material that is lost, damaged or otherwise unsuitable for use shall be immediately reported to J&E Precision's buyer. Supplier may be held financially responsible for the replacement cost of any supplied material, gauges and tooling that is lost, damaged or otherwise deemed unsuitable for use by J&E Precision
<b>Q16</b>	D	<b>PRODUCT IDENTIFICATION</b> All product shall be identified per PO and/or blueprint/specification requirements prior to delivery as applicable.
<b>Q17</b>	-	<b>SERIALIZATION</b> Serialization and traceability is required, assigned serial numbers shall be maintained throughout all manufacturing cycles and shall be identified on both the parts and all documentation at time of shipment.
<b>Q18</b>	-	<b>N/A</b> (COMBINED WITH Q19)
<b>Q19</b>	-	<b>N/A</b> (SUPERCEDED BY Q58)
<b>Q20</b>	-	<b>N/A</b> (SUPERCEDED BY Q56)
<b>Q21</b>	-	<b>FAI, REPORT</b> A First Article Inspection (FAI) report is required for each part number and/or dash number. The inspection report shall indicate the actual measurement obtained for each characteristic listed on the blueprint, parts list, and J&E Precision's manufacturing instructions (when specified on the Purchase Order). When repetitive dimensions are inspected, (i.e. holes of the same size, web thickness of the same size, etc.) record actual measurement individually, and specify locations. A First Article is required when a part has not been in production for a period of two years or longer. When an Amended FAI is required an Amended FAI report containing each of the configuration changes may be submitted instead of a full FAI report.
<b>Q22</b>	-	<b>FAI, SOURCE INSPECTION</b> When FAI Source Inspection requirement is specified on the Purchase Order, J&E Precision's and its customer's source inspector will be present during the FAI Source inspection unless waived in writing. When source inspection is specified, the supplier shall provide at least 48 hours notice to J&E Precision of the date of performance of this FAI.
<b>Q23</b>	-	<b>N/A</b> (COMBINED WITH Q21)
<b>Q24</b>	-	<b>100% INSPECTION</b> When 100% inspection requirement is specified on the Purchase Order, One hundred percent inspection on all characteristics is required. Use of sampling plans for inspection is prohibited without J&E Precision's prior approval.
	-	<b>N/A</b> (SUPERCEDED BY Q57)
<b>Q26</b>	-	<b>FAI QUALITY PLAN</b> When FAI Quality Plan is specified on the Purchase Order, A Quality Plan must be submitted to J&E Precision Tool, Inc., for approval, prior to the completion of the FAI. The Quality Plan shall address the sequence of manufacturing, processing and inspection operations that are required and shall include the identification of all gauges being proposed for use and also identify any sub-tier suppliers that will be performing controlled/special processes.
<b>Q27</b>	-	<b>GO/NOGO GAGING</b> For all close tolerance characteristics (.0015" or less), GO and NO GO gaging techniques are not acceptable.
<b>Q28</b>	-	<b>INSPECTION EQUIPMENT CAPABILITIES</b> Inspection equipment utilized must have capability to attain a measurement of 10% of tolerance being inspected.
<b>Q29</b>	-	<b>N/A</b> (COMBINED WITH Q30)
<b>Q30</b>	D	<b>GAGE CONTROL &amp; CALIBRATION SYSTEM</b> The Supplier and/or sub-tier suppliers shall maintain a gage control and calibration system in compliance with ANSI/NCSSL-Z540.3 and/or ISO 17025 or equivalent.
<b>Q31</b>	-	<b>INSPECTION STATUS</b> The inspection status of all products shall be clearly identified throughout the manufacturing process and upon delivery to J&E Precision.



	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q32</b>	-	<b>NON-CONFORMANCE, CONTROL OF</b> Supplier shall implement a system for controlling nonconforming product that identifies and segregates such material to prevent unintended use.
<b>Q33</b>	-	<b>N/A (SUPERCEDED BY Q51.)</b>
<b>Q34</b>	-	<b>DISCREPANCIES POST DELIVERY</b> Supplier shall immediately report to J&E Precision any discrepancies that may affect product that has already been delivered.
<b>Q35</b>	-	<b>CORRECTIVE ACTIONS</b> Supplier shall implement a system of corrective action for discrepancies identified by the supplier, J&E Precision or J&E Precision's customers. When J&E Precision requests written corrective action, the supplier shall document the cause of the discrepancy, corrective action taken and effective date of the corrective action. J&E Precision reserves the right to verify the effectiveness of the stated corrective action at the supplier's facility.
<b>Q36</b>	-	<b>PACKAGING AND PACKAGING REQUIREMENTS</b> The items on this order shall be packed, packaged and preserved in such a manner as to assure adequate protection from deterioration and physical damage due to material handling or shipment. The material shall arrive at J&E Precision free of nicks, dents, gouges, scratches and undue oxidation. Parts subject to oxidation shall be packaged with a suitable preservation or an oxidation inhibiting paper such as non-rust paper. Springs shall be packaged to preclude entanglement. When required by the purchase order and/or referenced documents, the supplier shall pack and package supplies to specific packing and packaging specifications.
<b>Q37</b>	-	<b>TRACEABILITY</b> Supplier agrees to ensure that materials utilized in the performance of this order, whether furnished by J&E Precision or by the supplier, will be segregated and controlled to ensure traceability and prevent them from being intermingled with any other materials.
<b>Q38</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q39</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q40</b>	<b>B</b>	<b>RETENTION OF DOCUMENTS AND RECORDS</b> Retain Quality Management System (QMS) records as identified per AS9100. The following identified quality records shall be maintained for the minimum retention periods specified below unless other wise specified,; <ul style="list-style-type: none"> <li>• <b>40 years:</b> retention time for documentation of all applicable processes of manufactured parts (including radiographs) for all safety and/or critical classified parts. This retention time also applies to radiographs of components that require serial numbers and are safety and/or critical classified parts.</li> <li>• <b>30 years</b> for documentation for all applicable processes for Manned Space Program Hardware</li> <li>• <b>10 years</b> for documentation for all other applicable processes of manufactured parts, castings or forgings except for off-the-shelf industry standard parts (including radiographs of items listed).</li> <li>• <b>5 years</b> for off-the-shelf / industry standard parts (e.g., AN, AS, MS, JAN, etc.) and casting radiographs for initial casting quality.</li> </ul> <b>Note:</b> After the retention times expire, The supplier shall not destroy such records without the written approval of J&E Precision.
<b>Q41</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q42</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q43</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q44</b>	-	<b>N/A (COMBINED WITH Q40)</b>
<b>Q45</b>	<b>D</b>	<b>SELF AUDITS</b> Supplier shall implement a system of self-audits to verify the effectiveness of the supplier's quality system and processes.
<b>Q46</b>	<b>D</b>	<b>TRAINED PERSONNEL</b> Supplier shall be responsible to provide trained personnel for the manufacture and inspection of products and services used to satisfy the requirements of this purchase order.



	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q47</b>	<b>A</b>	<p><b>KEY CHARACTERISTICS</b>  The following requirements apply:  All key characteristic shall be placed under statistical process control.  If the supplier does not have the ability to perform as stated above, contact the J&amp;E Precision Tool, Inc. buyer immediately, prior to continuing with purchase order requirements.  At any time, the supplier may request assistance from J&amp;E Precision Tool, Inc. when conducting S.P.C. and A.Q.S. (Advanced Quality System) activities. contact the J&amp;E Precision Tool, Inc. buyer.</p> <p>Documentation requirements per key characteristic:  The supplier will provide copies of S.P.C. documentation with all parts delivered to J&amp;E Precision Tool, Inc. Documents required for each key characteristic shall be 1x-MR chart or X bar-R chart. If 21 or more parts are listed on the control charts, then upper and lower control limits along with a C.P.K. reading shall be indicated on the control chart. All charts will be identified with the date, part number, dash number, and the key characteristics.  The documentation above will be in addition to all other documentation required by the purchase order and engineering requirements.</p>
<b>Q48</b>	<b>E</b>	<p><b>EMPLOYEE AWARENESS</b>  The supplier shall ensure that persons are aware of their contribution to product conformity; their contribution to product safety; and the importance of ethical behavior. This method shall establish a frequency of communication that is appropriate to the organization and will occur annually at a minimum. Seller shall maintain records of this communication.</p>
<b>Q49</b>	-	<b>N/A (SUPERCEDED BY Q54.)</b>
<b>Q50</b>	<b>D</b>	<p><b>DPAS RATINGS</b>  Supplier is responsible for complying with any DPAS rating listed on the purchase order. For Information on DPAS see <a href="https://www.bis.doc.gov/index.php/other-areas/strategic-industries-and-economic-security-sies/defense-priorities-a-allocations-system-program-dpas">https://www.bis.doc.gov/index.php/other-areas/strategic-industries-and-economic-security-sies/defense-priorities-a-allocations-system-program-dpas</a></p>
<b>Q51</b>	-	<p><b>NON-CONFORMING PRODUCT</b>  The supplier shall notify J&amp;E Precision of the following:</p> <ul style="list-style-type: none"> <li>a) non-conforming product</li> <li>b) obtain approval for non-conforming product disposition.</li> <li>c) changes in product and/or process, changes of suppliers, changes of manufacturing facility location, and where required, obtain approval.</li> <li>d) flow down to the supply chain the applicable requirements including customer records.</li> </ul>
<b>Q52</b>	-	<p><b>NADCAP</b>  Special Processes (welding, plating, heat treating, anodizing, painting, non-destructive testing, etc.) shall be performed only by a Nadcap certified processor. Nadcap accreditation shall be noted on all applicable Certificate of Conformances. Proof of current Nadcap accreditation shall be available upon request. The Seller shall ensure the NADCAP certification has not expired. Note: NADCAP certification for one special process does not ensure NADCAP certification for every special process a supplier may perform. For processes to Industry and/or Military standards, a NADCAP certificate for the specific process is required. When a supplier is performing a process to other specifications or MOPs (instead of an Industry/Military standard), the supplier's general NADCAP certification for the type of (painting, silk screening) process performed is acceptable.</p>
<b>Q53</b>	-	<p><b>FOD</b>  The Supplier shall inspect for foreign objects/materials. All delivered products shall be free of foreign objects/materials including grease, lubricant, coatings not specified on purchase order, burrs, etc.</p>
<b>Q54</b>	-	<p><b>RESTRICTED MATERIALS</b>  The Supplier shall certify the following:</p> <ul style="list-style-type: none"> <li>a) The supplied product does not contain Mercury and/or compounds of Mercury.</li> <li>b) No ozone depleting chemicals have been used during the manufacturing of this product.</li> </ul>
<b>Q55</b>	-	<p><b>DFARS</b>  Conformance to DFARS 252.225,7014, Preference for Domestic Specialty Metal and Alternate I, is required and must be flowed down to your sub-contractors. Specialty metals that apply per the DFAR are certain steels, titanium's, and zirconium based alloys. Aluminum and most other alloys are not included.</p>



Title:	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q56</b>	A	<p><b>PROCESS CofC</b></p> <p>A legible and reproducible copy of process certifications shall accompany each shipment of parts. Certifications are to include all specifications listed in the purchase order by sequence and date performed. All certifications are to be supplied as objective evidence and must document the latest revision of the applicable or superceding specification. All certifications must indicate the processor company name, full address, telephone number, Commercial And Government Entity (CAGE) code number of the facility performing each process.</p> <p>Repeating process steps is considered "rework to print" and must be approved by J&amp;E Precision prior to completion of the task. Stripping of plating/coatings/paint to repeat the plating/coating/painting process is not allowed unless approved by J&amp;E Precision prior to completion of the task.</p> <p>This requirement must be flowed down to each sub-tier Supplier of processes on each order.</p>
<b>Q57</b>	-	<p><b>SOURCE INSPECTION</b></p> <p>The product furnished under this Purchase Order or Subcontract is subject to source inspection by J&amp;E Precision and its Customer. When material will be ready for inspection (both in-process and final), notify J&amp;E Precision's Quality Assurance Department 5 days in advance (14 days outside continental United States). Acceptance of product at source is considered preliminary. Final acceptance will be at the J&amp;E Precision's facility through J&amp;E Precision's Receiving Inspection Section. The Supplier is required to provide all requisite equipment, records, reports, etc., to facilitate the work of the Source Inspector(s), and to verify any physical or functional specifications as may be requested by him/her in the course of the inspection. A copy of the Source Inspection Report verifying acceptance of the item(s) and properly validated by the inspector's stamp or signature shall accompany the shipment to the J&amp;E Precision's facility. J&amp;E Precision's Quality Assurance Department may waive Source Inspection via PO amendment, e-mail or letter.</p>
<b>Q58</b>	A	<p><b>MATERIAL CERTS</b></p> <p>The Supplier shall submit a manufacturer or mill inspection/test report that states the material type and shows the physical and chemical properties by reference to melt, cast, heat, etc., and signed by its authorized representative (or by the agency performing the tests) with each shipment. Non-metallic material shall only require a chemical properties inspection/test report. All certifications must be documented to the latest revision of the applicable or superceding specification as applicable.</p>
<b>Q59</b>	A	<p><b>CofC, PURCHASED PRODUCT</b></p> <p>The Supplier shall furnish a certification of compliance which states the product conforms to applicable specifications as required by PO, drawing or specification signed by an authorized representative of the agency supplying the product with each shipment. This requirement may appear as a separate deliverable line item on the PO. When applicable: batch, lot, heat number, x-ray, heat treat chart, etc. shall accompany the shipment.</p>
<b>Q60</b>	C	<p><b>COUNTERFEIT PARTS</b></p> <p>The Supplier is hereby notified that the delivery of suspect/counterfeit, salvaged, remanufactured or reclaimed components, parts and/or materials is of special concern to J&amp;E Precision &amp; our Customers. To mitigate the possibility of the inadvertent use of these components, parts and/or materials, The Supplier shall only purchase components, parts and/or materials procured directly from the Original Component Manufacturer (OCM)/ Original Equipment Manufacturer (OEM)/ Original Source, or through an authorized franchisee/distributor chain. Procurement through an independent distributor or broker is NOT authorized, unless first approved in writing by J&amp;E Precision's Buyer.</p> <p>Regardless of the source of procurement, the Supplier shall provide original manufacturer documentation that authenticates traceability of the components of the applicable original manufacturer.</p>
<b>Q61</b>	-	<p><b>SUBSTITUTIONS</b></p> <p>Part and/or Materials substitution is not allowed.</p> <p>If unable to fulfill purchase order with specified part number, immediately notify J&amp;E Precision's Buyer.</p>
<b>Q62</b>	-	<p><b>ITAR</b></p> <p>The information contained herein is confidential and/or proprietary and could be subject to U.S. Export laws and / or controlled by the US International Traffic in Arms Regulation (ITAR) 22 CFR part 120-130. This information which includes all other attached documents is intended solely for the purpose of fulfilling the requirements of this purchase order. Any additional disclosure, dissemination, reproduction or forwarding of this information for any other purpose without written permission from J&amp;E Precision Tool, Inc. is strictly prohibited. J&amp;E Precision Tool, Inc. takes no responsibility, either direct or indirect, for any unauthorized dissemination of such data or materials.</p>



Title:	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q63</b>	-	<p><b>GOVERNMENT SOURCE INSPECTION</b></p> <p>Government Source Inspection (GSI) is required for item(s) on this Order. Upon receipt of this Order, the Supplier shall promptly contact J&amp;E Precision's QA Department to set-up timeframe of when the part(s) will be ready for GSI. J&amp;E Precision's QA Department will contact the Government Representative to set it up.</p>
<b>Q64</b>	-	<p><b>PRODUCT AND PROCESS CHANGE APPROVAL</b></p> <p>Supplier shall obtain approval from J&amp;E Precision of changes in product and/or process definitions.</p>
<b>Q65</b>	-	<p><b>SUPPLIER SUB-TIER CONTROL</b></p> <p>The Supplier is responsible for insuring all items produced from its subcontractors conform to all requirements of the purchase order. Supplier shall ensure all applicable provisions of this document are flowed down to its subcontractors, including the use of AS9102 for first article inspection when applicable.</p>
<b>Q66</b>	-	<p><b>CofC FOR NDT, FPI, MPI</b></p> <p>A certification of compliance is required and shall include the following:</p> <ul style="list-style-type: none"> <li>a) J&amp;E PURCHASE ORDER NUMBER</li> <li>b) APPLICABLE NDT, FPI, and/or MPI SPECIFICATION WITH LATEST REVISION LEVEL</li> <li>c) HEAT LOT NUMBER:</li> <li>d) QUANTITY TESTED, ACCEPTED, REJECTED, AND REASON FOR REJECTION</li> <li>e) INSPECTOR'S NAME</li> <li>f) INSPECTOR'S CERTIFICATION LEVEL WITH DATE OF EXPIRATION</li> <li>g) DATE OF INSPECTION</li> </ul>
<b>Q67</b>	-	<p><b>CofC FOR HEAT TREAT</b></p> <p>1) A certification of compliance is required and shall include the following with each shipment of material:</p> <p>2) The certification shall list the following:</p> <ul style="list-style-type: none"> <li>a) SUPPLIER INFORMATION (NAME, ADDRESS, PHONE)</li> <li>b) J&amp;E PURCHASE ORDER NUMBER</li> <li>c) PART NUMBER &amp; REVISION</li> <li>d) QUANTITY</li> <li>e) SUPPLIER CERTIFICATION NUMBER</li> <li>f) SUPPLIER CERTIFICATION DATE</li> <li>g) SUPPLIER CERTIFICATION AUTHORIZATION APPROVAL (NAME &amp; SIGNATURE WITH TITLE)</li> <li>h) MATERIAL TYPE &amp; SIZE</li> <li>i) MATERIAL HEAT LOT NUMBER:</li> <li>j) HEAT TREAT BATCH NUMBER</li> <li>k) PROCESS SPECIFICATIONS WITH LATEST REVISION LEVEL</li> <li>l) QUALITY TEST REQUIREMENTS (HARDNESS, METALLURGICAL ETC.)</li> <li>m) HARDNESS REQUIREMENTS:</li> <li>n) NUMBER OF PARTS</li> <li>o) QUALITY OF PARTS TESTED</li> <li>p) TEST COUPONS ACCEPTED / REJECTED, WITH ACTUAL RANGE OF VALUE.</li> <li>q) HEAT TREAT PROCESS STEPS (INCLUDING TIME, TEMPERATURE, FURNACE I.D., ATMOSPHERE, ETC)</li> </ul> <p>IF ANY INFORMATION IS NON-APPLICABLE, PLEASE INDICATE "N/A".</p>
<b>Q68</b>	-	<p><b>TENSILE TEST</b></p> <p>1) A certification of compliance is required and shall include the following with each shipment of material:</p> <ul style="list-style-type: none"> <li>a) SUPPLIER INFORMATION (NAME, ADDRESS, PHONE)</li> <li>b) J&amp;E PURCHASE ORDER NUMBER</li> <li>c) PART NUMBER &amp; REVISION</li> <li>d) SUPPLIER CERTIFICATION NUMBER</li> <li>e) SUPPLIER CERTIFICATION DATE</li> <li>f) SUPPLIER CERTIFICATION AUTHORIZATION APPROVAL (NAME &amp; SIGNATURE WITH TITLE)</li> <li>g) MATERIAL TYPE &amp; CONDITION:</li> <li>h) HEAT TREATED TO (HT VALUE).</li> <li>i) MATERIAL HEAT LOT NUMBER</li> <li>j) HEAT TREAT BATCH NUMBER</li> <li>k) TEST DESCRIPTION</li> <li>l) SPECIFICATIONS WITH LATEST REVISION LEVEL.</li> <li>m) TEST PARAMETERS (IF APPLICABLE)</li> <li>n) TEST RESULTS</li> </ul> <p>(IF ANY INFORMATION IS NON-APPLICABLE, PLEASE INDICATE "N/A".)</p>



Title:	<b>PURCHASE ORDER QUALITY INSTRUCTIONS</b>	Form #	Form Rev	Form Date
		JE-QW-005-1	F	2/1/2023

<b>Q69</b>		<p><b>CONFLICT MINERALS</b></p> <p>J&amp;E Precision requires that Suppliers shall certify that minerals used in the processing of items listed on this Purchase Order, are "Conflict Fee" IAW the Dodd-Frank Wall Street Reform and Consumer Protection Act OF 2010.</p> <p>Definition: The definition of "conflict minerals" refers to gold, tin, tantalum, and tungsten, and includes the derivatives of: cassiterite, columbite-tantalite, and wolframite, regardless of where they are sourced, processed or sold. The U.S. Secretary of State may designate other additional minerals in the future.</p> <p>Note: The U.S. Securities and Exchange Commission ("SEC") adopted rules to implement reporting and disclosure requirements related to "conflict minerals," as directed by the Dodd-Frank Wall Street Reform and Consumer Protection Act of 2010. The rules require manufacturers and Special Processors to disclose whether the products they manufacture or apply contains "conflict minerals" that originate from any location described as the "Conflict Region", which is situated in the eastern portion of the Democratic Republic of the Congo (DRC) and surrounding countries.</p>
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<b>REVISION RECORD</b>			
Revision	Change Description	Rev By	Rev Date
A	AS RELEASED	010EL	11/4/2013
B	REVISED Q40	010EL	4/29/2014
C	REVISED Q60, CHANGED DOCUMENT NUMBER FROM JE-QW-742	127JM	11/7/2017
D	Remove para 4.1, 4.3 and 4.4 and remove numbers for 4.2 to become 4.0; Delete section 5 and renumber section 6 to section 5; add Q48 to all of section 5; Remove section 5.1 Purchased Office Supplies and Perishables and renumber remainder of sections; REVISED Q16 to add "per PO and/or" Change Z540-1 to Z540.3 and ISO 10012-1 to ISO 17025 in Q30; Remove requirement for once per year minimum from Q45; REVISED Q46 to add "and services" Add Q48 and Q50 for new AS9100 requirements	127JM	1/9/2018
E	REVISED Q13 to add "unless otherwise dictated on the Purchase Order" REVISED Q48 to add "This method shall establish a frequency of communication that is appropriate to the organization and will occur annually at a minimum. Seller shall maintain records of this communication"	127JM	3/26/2018
F	5.8 "GAGE CONTROL & CALIBRATION SYSTEM" section added	127JM	2/1/2023