

Raysons Quality Clauses

Clause #	Body text
100	<p>CHANGE OF CONFIGURATION, DESIGN, PROCESS</p> <p>The supplier shall notify Raysons of any proposed changes to design, parts, materials, fabrication methods, or processes, and obtain written approval from Raysons' Purchasing Department prior to change incorporation. The supplier shall immediately notify Raysons of changes to ownership, manufacturing or processing location. The supplier shall notify Raysons as soon as it is apparent that an interruption of 90 or more days is anticipated in the production of an item.</p>
110	<p>Raysons /CUSTOMER/GOVERNMENT</p> <p>Raysons / Customer / Government reserves the right of access to subcontractor's facility for review of quality systems, records and facilities. The right to inspect any or all work included in this order is also reserved. Verification by Raysons /Customer / Government does not absolve the supplier of the responsibility to provide acceptable product, nor shall it preclude subsequent rejection by Raysons / Customer/Government.</p>
111	<p>ITAR CONTROLS International Traffic in Arms Regulations</p> <p>The Supplier shall be a registered ITAR company and shall comply with ITAR policy and procedural requirements.</p>
120	<p>CONTROL OF NONCONFORMING MATERIAL</p> <p>The supplier or lower-tier suppliers are not authorized to disposition nonconforming materials as "repair" or "accept as is". For this purpose, material shall be defined as all material and components of the supplier and lower-tier supplier products which are under Raysons' design control. Any nonconforming materials, components or parts shall be segregated and withheld from shipment to Raysons unless negotiated in advance. When authorized to ship nonconforming material, components or parts, the supplier shall insure that the nonconforming items are identified (e.g. tagged) and specifically referenced as being nonconforming on certification statements. Materials or parts rejected by Raysons shall not be returned to Raysons without appropriate corrective action having been taken and then only with reference being made to the discrepancy report on the certification statement.</p>
125	<p>COUNTERFEIT PART(S) / ITEM(S)</p> <p>All part(s) / item(s) provided shall be new and unused unless otherwise specified in writing by the supplier. The Supplier shall assure that a process is in place to prevent counterfeit parts/items from being procured and shipped. Types of materials, parts, and components known to have been misrepresented and considered counterfeit include, but are not limited to: electronic components, electrical devices, metal alloys- plate and bar, forgings, tubing and tubing components and other structural items, solders, fluxes, adhesives, cleaning agents, catalysts, etc. In addition, falsified or forged documentation of test information reflecting legitimate manufacturers logos and information has also been identified as counterfeiting.</p>
130	<p>KEY CHARACTERISTICS</p> <p>When a Key Characteristic is identified on a print, compliance will be IAW AS9103 and this Quality Clause. Once process capability is established, recalculation should occur using the following guidelines:</p>

Clause #	Body text
	<p>A. Any change in the Key Characteristic as defined on the print B. At the next product run if over 6 months since last run</p> <p>C. A significant process change(s) has occurred such as: 1. Different/altere d/repair ed machine 2. Different/altere d process 3. Different/altere d fixtures 4. Different/altere d controlling program (CNC or other) 5. Change in material (type) 6. Different measurement method 7. Change in the operator training/certification requirement</p> <p>Note: The use of “trial” parts may not be utilized for calculating capability without prior approval.</p>
140	<p>HANDLING, STORAGE, PACKAGING, PRESERVATION AND DELIVERY A. Unless otherwise specified, preservation, packaging, handling, and shipping of items shall be in accordance with best commercial practices to prevent damage and ensure that original quality is maintained. B. Packaging shall be in accordance with MIL-STD-726.</p>
150	<p>QUALITY RECORDS A. Quality records, including raw material certifications, work instructions, inspection and test data shall be retained at the supplier facility for a minimum of seven years after shipment. B. Seller shall retain all material certifications, physical/chemical test reports, manufacturing, assembly, inspection, test results, and special process records until directed otherwise by the buyer. Under no circumstances should these records be destroyed without prior written approval. Records shall be made available upon request.</p>
160	<p>QUALITY PROGRAM REQUIREMENTS - MIL-Q-9858A The supplier shall provide and maintain a system that complies with MIL-Q-9858A “Quality Program Requirements”. Compliance with this clause in no way relieves the seller of the responsibility to furnish acceptable supplies or services as specified in the purchase document. (A Quality Program IAW ISO-9001 may be utilized in lieu of this requirement).</p>
170	<p>INSPECTION SYSTEM REQUIREMENTS - MIL-I-45208A The supplier shall provide and maintain a system that complies with MIL-I-45208A “Inspection System Requirements”. Compliance with this clause in no way relieves the seller of the responsibility to furnish acceptable supplies or services as specified on the purchase document. (A Quality Program IAW ISO-9002 may be utilized in lieu of this requirement).</p>
180	<p>QUALITY PROGRAM PROVISIONS - NHB 5300.4 (1B) The seller shall provide and maintain a system that complies with NHB 5300.4 (1B) “Quality Program Provisions.” Compliance with this clause in no way relieves the seller of the responsibility to furnish acceptable supplies or services as specified on the purchase document.</p>

Clause #	Body text
190	<p>INSPECTION SYSTEM PROVISIONS - NHB 5300.4 (1C) The seller shall provide and maintain a system that complies with NHB 5300.4 (1C) "Inspection System Provisions." Compliance with this clause in no way relieves the seller of the responsibility to furnish acceptable supplies or services as specified on the purchase document.</p>
200	<p>CONTROL OF INSPECTION EQUIPMENT Inspection/calibration measuring equipment utilized in the manufacture/calibration of this item must be calibrated and traceable to the National Bureau of Standards per ISO-10012-1.</p>
210	<p>SUPPLIER QA PROGRAM REQUIREMENTS - MIL-STD-1535A This item being procured has been identified as defined in accordance with MIL-STD-1535A. The supplier shall perform all tasks associated with the applicable classification.</p> <ul style="list-style-type: none"> A. Group I Purchase B. Group II Purchase C. Group III Purchase
220	<p>GOVERNMENT SOURCE INSPECTION (GSI)</p> <p>A. All work on this order is subject to inspection and test by the Government at anytime and place. The Government Quality Representative who has been delegated NASA Quality Assurance Functions on this procurement shall be notified immediately, upon receipt of this order. The Government Representative shall also be notified forty-eight (48) hours in advance of the time articles or materials are ready for inspection or test.</p> <p>B. The Government has the right to inspect any or all of the work included in this order at the suppliers' plant. Verification by Raysons /Customer/Government does not absolve the supplier of the responsibility to provide acceptable product, nor shall it preclude subsequent rejection by Raysons /Customer/Government.</p>
230	<p>GOVERNMENT SOURCE INSPECTION Government inspection is required prior to shipment from your plant. Evidence of such inspection must be indicated on the packing sheet accompanying each shipment. On receipt of this purchase order/subcontract, promptly furnish a copy to the government representative who normally services your plants or if none, to the nearest Army, Navy, Air Force or Defense Supply Agency Inspection Office in your locality. In the event the representative or office cannot be located, contact Raysons Purchasing. Verification by Raysons /Customer/Government does not absolve the supplier of the responsibility to provide acceptable product, nor shall it preclude subsequent rejection by Raysons / Customer/Government.</p>
240	<p>RAYSONS SOURCE INSPECTION Source Inspection shall be conducted by Raysons at the supplier's facilities or where designated in this purchase order subcontract prior to shipment. The supplier shall contact Raysons supplier quality assurance representative at least five working days prior to date items will be ready for the mandatory inspection/test performance, including in process and/or final test. Required documentation for shipment must be completed and signed by the supplier-authorized quality personnel, and available for the Raysons supplier quality assurance representative. Verification by Raysons /Customer/Government does not absolve the supplier of the responsibility to provide</p>

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	acceptable product, nor shall it preclude subsequent rejection by Raysons / Customer/Government.
250	<p>FIRST ARTICLE INSPECTION</p> <p>On the initial production, a comprehensive inspection and test is required of the first article piece to assure conformance with all drawing requirements and specifications. When multi-cavity molds/dies/tools are used, the First Article Inspection is required for each cavity. The First Article Inspection for subassemblies shall include inspection of all detailed parts. A new First Article Inspection is required when: 1) A significant design or process change has been made that affects the original First Article and is applicable only to the characteristics affected by the change; or 2) The item has not been produced for a period of 12 months; or 3) A change in facilities used to produce the item has taken place. The First Article Inspection may be documented on Raysons Form #813A or the supplier's equivalent form.</p> <p>The supplier assumes full responsibility for production prior to receipt and approval of first article, piece and/or assembly from Raysons. The supplier is required to:</p> <p>A. Submit the first article and inspection results to Raysons for approval. At a minimum, inspection results shall include the actual value or dimension for each specified characteristic and drawing note.</p> <p>B. Submit the first article item to Raysons for inspection by Raysons personnel.</p>
260	<p>FIRST ARTICLE INSPECTION (AS/EN/SJC 9102)</p> <p>The organization shall perform / submit a full FAI, or a partial FAI in accordance with AS9102 for affected characteristics, when any of the following events occurs:</p> <ul style="list-style-type: none"> · Initial Production · A change in the design affecting form, fit or function of the part. · A change in manufacturing source(s), process(es), inspection method(s), location, tooling or materials that can potentially affect fit, form or function · A change in numerical control program or translation to another media that can potentially affect fit, form or function · A natural or man-made event, which may adversely affect the manufacturing process. · A lapse in production for 12 months <p>http://www.sae.org/aaqg/publications/as9102a-faq.htm</p> <p>AS9102A Form 1 AS9102A Form 2 AS9102A Form 3</p>
270	<p>MANUFACTURING LOT OR BATCH NUMBER CONTROL</p> <p>All parts on this order will be traceable to/identified with a lot or batch number. Where size and shape do not permit stamping, the smallest package shall be stamped. A lot or batch will be defined as material or parts produced by a single type, grade, class, size or composition under</p>

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	unchanged manufacturing conditions in accordance with the same drawing and/or specification revision unless otherwise defined in the P. O.
280	<p>CONTROL OF LIMITED SHELF LIFE MATERIALS</p> <p>A. Cured elastomeric items which exceed the cure date by more than 30% of the specified shelf life shall not be furnished.</p> <p>B. Uncured elastomeric material exceeding 30% of the specified shelf-life from date of manufacture shall not be furnished.</p> <p>C. “Non-elastomeric materials exceeding 25% of the specified shelf life shall not be furnished unless written approval from Raysons Purchasing is obtained.”</p>
290	<p>LEVEL 1 MATERIAL CONTROL</p> <p>The supplier shall provide a system suitable for control of Level 1 material. Before Level 1 material will be released to the supplier’s facility, a Level 1 Material Control Procedure must be submitted to Raysons for approval. The supplier will not transfer Level 1 material to other facilities without receiving approval from Raysons. The supplier will be subject to Level 1 Material Control Audits by Raysons or the Government while Level 1 material resides at that facility.</p>
300	<p>TRACEABILITY</p> <p>When parts are joined in an assembly, the seller shall prepare an “Assembly History Log” identifying each part in the assembly. Fabricated parts shall be identified with a serial number, material type, heat number, B/P and specification with applicable change letter or number. Components in the assembly shall be traceable to records of acceptance by part number, serial number and lot number of material from which the components were fabricated by the supplier, and shall accompany the parts they represent to Raysons. No two parts which have the same part number shall be identified with the same serial number unless otherwise specified.</p>
310	<p>CONTROL OF FORGINGS/CASTINGS</p> <p>The Seller shall furnish Raysons with one sample forging/casting representative of all processing used. This test forging/casting is in addition to the production quantities required.</p>
320	<p>REPAIR OF CASTINGS/FORGINGS</p> <p>Repairs to castings or forgings by welding or impregnation is not permitted without written approval from Raysons.</p>
330	<p>CONTROL OF CASTINGS/FORGINGS</p> <p>The supplier shall furnish with each shipment:</p> <p>A. Two test bars prepared to Federal Test Standard 151B of each heat as the casting supplied</p> <p>B. One spectrographic disc representing castings heat or melt supplied.</p> <p>C. Test bars and disc must be clearly and permanently marked with purchase order number, alloy identification and heat number it represents.</p>
340	<p>CONTROL OF NONDESTRUCTIVE TESTING (NDT)</p>

Clause #	Body text
	<p>Items requiring NDT shall be submitted, complete with drawing or document establishing NDT requirement, to a laboratory acceptable to Buyer. Test results shall be reported in writing to the Buyer, identifying the laboratory and the certified technician who performed and/or evaluated the tests, signed by a responsible laboratory representative. An adequate method of identifying and cross-referencing each x-ray film exposure, report and item must be provided. When parts are serialized, serial numbers must appear on the report and film with the control number.</p> <p>A. Radiographic film of each lot and/or other NDT results, including foundry control NDT, shall be inspected by Raysons at the laboratory performing the work prior to shipment. The seller shall notify Raysons when the film is ready for review.</p> <p>B. NDT reports shall be submitted with each shipment to Raysons and shall include x-ray film when radiographic inspection is required.</p> <p>C. Submittal of NDT procedures/x-ray shooting schedule is required. Approval by Raysons is required prior to NDT.</p>
350	<p>NDT CERTIFICATION PROGRAM MIL-STD-410 Personnel performing NDT must be certified in accordance with the requirements of MIL-STD-410 Nondestructive Testing Personnel Qualification and Certification. Copy of Qualification and Certification record to be submitted.</p>
360	<p>WELDING SUBMITTAL/APPROVAL REQUIREMENTS All weld schedules/procedures require Raysons approval prior to welding.</p>
370	<p>WELDING PERSONNEL CERTIFICATION Personnel performing welding must be qualified/certified in accordance with the requirements of:</p> <p>A. MIL-STD-1595A B. MIL-STD-248C</p>
380	<p>REPAIR OF WELDMENTS No repair to a weldment is permitted without approval by Raysons.</p>
390	<p>SPECIAL PROCESS CONFORMANCE When special process specifications (e.g. heat treat, soldering, welding, anodizing, chemical film treatment, NDT, etc.) are a contract and/or drawing requirement, the supplier is responsible for maintaining a system to control special processes performed at his facilities.</p>
400	<p>USE OF Raysons APPROVED SUPPLIERS The supplier is required to use Raysons /Customer/Government approved suppliers for the performance of all special processes/NDT. The use of Raysons /Customer/Government suggested/approved Suppliers does not relieve the supplier of the responsibility for product/service quality.</p>
410	<p>NONDESTRUCTIVE TESTING (NDT) CERTIFICATION</p>

Clause #	Body text
	Each shipment must be accompanied by one legible copy of a certification (Q.C. Form #837 furnished by Raysons, or supplier equivalent) signed by a responsible representative of the seller performing the NDT. When applicable, the supplier is to maintain and have available for examination, records reflecting certification of personnel, equipment and processes.
420	<p>100% INSPECTION REQUIREMENT</p> <p>The supplier must perform 100% inspection of all items on this purchase order to ensure compliance to drawing and specification requirements. Objective evidence of such inspection must be maintained on file and available for review by Raysons.</p>
430	<p>STATISTICAL PROCESS CONTROL</p> <p>The supplier shall submit a Process Control Plan detailing how Critical to Quality (CTQ) characteristics and processes will be controlled for items under this purchase order. Raysons approval of this plan is required. Objective evidence of compliance to the Control Pan is to be maintained on file and available for review by Raysons.</p>
440	<p>INSPECTION BY SAMPLING</p> <p>The supplier may substitute sampling inspection in lieu of 100% inspection if inspection is performed in accordance with ANSI Z 1.4. Other inspection plans may be used with Raysons approval.</p>
450	<p>CERTIFICATION OF COMPLIANCE</p> <p>Each shipment must be accompanied by one legible copy of a certification containing the following:</p> <ul style="list-style-type: none"> A. Statement that material, processing, and finish of parts on this order meet all specifications and drawing requirements. B. Raysons part number and revision C. Signature & title of authorized company representative.
460	<p>CERTIFICATION OF MATERIAL</p> <p>Each shipment must be accompanied by one legible copy of a certification containing the following:</p> <ul style="list-style-type: none"> A. Statement that materials used on this order meet all specifications and drawing requirements. B. Statement that physical and/or chemical test reports or manufacturer's certification of material used are available at your facility. C. Raysons part number and revision D. Signature & title of authorized company representative.
470	<p>CERTIFICATION OF Raysons FURNISHED MATERIAL</p> <p>Each shipment must be accompanied by one legible copy of a certificate (Q.C. Form #853 furnished by Raysons, or supplier equivalent) containing the following:</p> <ul style="list-style-type: none"> A. Statement that the items supplied were made from parts or material furnished by Raysons.

Clause #	Body text
	<ul style="list-style-type: none"> B. Raysons part number and revision C. Traceability (i.e. lot number) of Raysons provided material D. Signature & title of authorized company representative.
480	<p>PROCESS CERTIFICATION Each shipment must be accompanied by one legible copy of a certification containing the following:</p> <ul style="list-style-type: none"> A. Special process specification and revision as referenced on the drawing, purchase order or packing sheet (i.e. military specification and/or Raysons process specification). B. Statement that supplier maintains and has available for examination, records reflecting certification of personnel, equipment and process. C. Signature & title of authorized company representative.
490	<p>CHEMICAL/PHYSICAL TEST Each shipment must be accompanied by two legible copies of test reports, identifiable with purchase order number, the specification including revision, material heat and/or lot number. Report must contain:</p> <ul style="list-style-type: none"> A. Original Mill Certification B. Chemical/Physical Analysis C. Typical Test Results <p>Reports must contain the signature and title of a responsible representative of the organization performing the test.</p>
500	<p>CERTIFICATION OF MERCURY EXCLUSION Each shipment made against the purchase order must contain a statement certifying:</p> <ul style="list-style-type: none"> A. The manufacturer has taken appropriate steps to ensure supplies furnished under this order contain no metallic mercury or mercury compounds. B. The dealer/distributor has taken reasonable steps to ensure that the supplies furnished under this order have not been contaminated with mercury or mercury compounds. <p>The certification (Q.C. Form #856 furnished by Raysons, or supplier equivalent) shall reference purchase order number, part number, description and quantity of this shipment.</p>
510	<p>CERTIFICATION OF MANUFACTURER The supplier (distributor) shall provide the manufacturer's name and the P.O. number under which the distributor acquired the material.</p>
520	<p>CERTIFICATION OF CALIBRATION Each item shall be accompanied by a signed certification of calibration stating that the item(s) have been calibrated and are traceable to nationally recognized standards.</p>

Clause #	Body text
	<p>A. The certification shall reference the National Institute of Standards and Technology (NIST) test number for the calibration standard(s) used, where applicable.</p> <p>B. The certification shall reference the NIST test number and accuracy of the calibration standard (s) used, where applicable, including as-found and as-left data for the equipment being calibrated.</p>
530	<p>MATERIAL IDENTIFICATION INSTRUCTIONS</p> <p>A. Apply part number and revision letter per applicable drawing note.</p> <p>B. Bag and tag parts.</p> <p>C. Tag parts.</p> <p>D. Identify per procurement instruction requirements.</p> <p>E. Identify parts in accordance with MIL-STD-130F.</p>
540	<p>EEE MATERIAL</p> <p>Each item on this purchase order must be identified with manufacturer and date/lot code number in accordance with applicable specifications.</p>
550	<p>STATIC SENSITIVE DEVICES</p> <p>Static sensitive devices (e.g. CMOS Integrated circuits) shall be stored, handled and packaged according to appropriate procedures to insure against damage by static induced voltages. The packaging shall be marked to insure static awareness upon receipt at Raysons</p>
560	<p>LEVEL 1 MATERIAL IDENTIFICATION</p> <p>Material on this purchase order is designated for Level 1 naval applications. It is mandatory that each piece of material be mill marked with the melt or heat number. Bar stock must be marked at both ends as a minimum. Chemical/physical material certifications shall be on the producing mill's letterhead and shall include the signature of an authorized representative of the mill, their typed name, title and date.</p>
570	<p>IDENTIFICATION OF SHELF LIFE MATERIALS</p> <p>Seller shall identify each item, package or container, with the cure date of manufacture date, expiration date and special storage or handling conditions, in addition to the normal identification of name, part or code number, specification number, type, size, and quantity. Shelf life for elastomeric items may be based on SAE ARP 5316 , Storage of Aerospace Elastomeric Seals ...guidelines.</p>
580	<p>INSPECTION AND TEST SUBMITTAL</p> <p>The supplier is required to ship one copy of the following data with each item shipped:</p> <p>A. Inspection and test data</p> <p>B. Objective evidence of 100% inspection.</p> <p>C. Objective evidence of statistical process control.</p>

Clause #	Body text
	<p>D. Test report</p> <p>Inspection/Test Reports must include the requirements of Clause 850.</p>
590	<p>PRODUCT FAILURE FEEDBACK</p> <p>The supplier shall have a system for rapid feedback to Raysons of information concerning product failure of items covered by this Purchase Order, which occur during any phase of qualification and/or acceptance testing. This feedback system shall include, as a minimum, the following:</p> <p>A. FAX notification to Raysons Purchasing within 24 hours after occurrence of failure.</p> <p>B. An outline of the failure investigation to be conducted within 5 working days of the failure.</p> <p>C. A failure analysis report which will completely describe the specific cause, the analysis method and the action taken to eliminate the cause within 30 days of the failure.</p> <p>Raysons, with its customer, reserves the right to participate in any or all of the failure analysis investigation.</p>
600	<p>SAFETY PRECAUTIONS FOR AMMUNITION AND EXPLOSIVES</p> <p>The supplier is to comply with specification DFAR 252.223-7002 “Safety Precautions for Ammunition and Explosives”.</p>
610	<p>HAZARDOUS MATERIAL IDENTIFICATION AND MATERIAL SAFETY DATA</p> <p>The supplier is to comply with specification DFAR 252.223-7004 “Hazardous Material Identification and Material Safety Data”.</p>
620	<p>LANDSCAPERS ENVIRONMENTAL AWARENESS STATEMENT</p> <p>The supplier/contractor shall provide a listing of all chemicals dispensed on Raysons property and include relevant certificates or licenses for use of these chemicals.</p>
630	<p>BUILDING CONSTRUCTION ENVIRONMENTAL AWARENESS STATEMENT</p> <p>The contractor shall provide the necessary details regarding your plan to disposal, including how and where waste will be disposed.</p>
650	<p>PREFERENCE FOR DOMESTIC SPECIALTY METALS</p> <p>The supplier is to comply with specification DFAR 252.225-7014, “Preference for Domestic Specialty Metals” Alternate 1.</p>
660	<p>Foreign Object Damage (FOD) Prevention</p> <p>The Seller shall establish and maintain an effective Foreign Object Damage (FOD) Prevention Program to reduce FOD using NAS412 as a guideline.</p> <p>The program shall be proportional to the sensitivity of the design of the product(s) to FOD, as well as, to the FOD generating potential of the manufacturing methods.</p>

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	The written procedures or policies developed by the Seller shall be subject to review and audit by the buyer and/or government representative and disapproval when the seller's procedures or policies do not accomplish their objectives.
670	<p>Preference for Domestic Products, Components or Material</p> <p>The Suppliers to comply with 10 U.S.C. 2533a (Berry Amendment) all applicable products, components or materials used in the realizations of this supplied item must be grown, reprocessed, reused or produced in the United States. This applies to all subcontractor tiers. A certificate of adherence to 10 U.S.C. 2533a and DFARS Subpart 225.7002, signed by a cognizant quality representative and material certification (QC 852) stat the country of origin of all applicable products, components or materials, must accompany each shipment. It is permissible for a statement of adherence to 10 U.S.C. 2533a and DFARS Subpart 225.7002-1 to be incorporated into a general certificate of conformance (QC 851).</p>
680	<p>Use of Special Process Subprocessors</p> <p>All special processes must be performed by an approved processor. Boeing approved special processors found on the internet at: http://www.boeing.com/companyoffices/doingbiz/d14426/index.html</p>
690	<p>Employment Eligibility Verification</p> <p>The supplier is to conform to FAR 52.22-54 Employment Eligibility Verification System (E-Verify)</p>
700	<p>Counterfeit Parts</p> <p>Seller shall only produce products or purchases components/hardware direct from the original component manufacturer (OCM)/original equipment manufacturer (OEM), through an authorized (franchised) distributor or through a Raysons authorized broker. Work shall not be acquired from independent distributors or brokers without approval from the buyer in writing. The seller will comply with the requirements in AS 5553 for electronic components.</p> <p>Buyer must be notified immediately if the seller suspects they may have been supplied counterfeit parts. Work that is delivered that contains or includes counterfeit parts will be replaced, at the seller's expense, with certified genuine parts.</p> <p>Seller will flow down the above requirements to all suppliers/subcontractors to ensure they are buying hardware and electronic components from the OCM/OEM or an authorized distributor.</p> <p>All brokers providing electronic components/hardware must be authorized by Raysons. An Authorized Broker must demonstrate documented tools and procedures are in place, and functioning accordingly, to screen, detect, and ensure that components are not misrepresented.</p>
720	<p>Special Tooling Requirements</p> <p>The supplier shall maintain the identified Special Tooling so as to be compliant with Raysons process "Process for Controlling customer Supplied Tooling" (doc 904), or instead, per other customer Special Tooling requirements when identified with this clause.</p>

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730	<p>NADCAP All special processes must be performed by a NADCAP approved supplier. Documentation required with shipment.</p>
740	<p>PMR Requirement A program Management Review will be required at the outset of the agreement to procure a part or parts from the supplier and every 6 months thereafter. The reviews should alternate between Raysons and the supplier's location when possible. An appropriate team from each organization will meet to exchange knowledge of concerns, risks, lessons learned, performance expectations and quality issue resolution. The supplier shall also be prepared to support PMR(s) throughout the procurement period.</p>
750	<p>Blanket Certifications For those suppliers who have been approved for Blanket Biennial Certifications, the supplier is responsible for maintaining on file the certifications listed and have available upon request in a timely fashion. Only the certifications listed on the blanket apply, all other certifications requested via the Quality Clauses must be supplied with the shipment.</p>
760	<p>AMMO Data Card Ammo data Cards per MIL-STD-1168 to be supplied with each shipment. Initiator/Primer Lot Number format per Mil-STD-1168</p>
770	<p>Single Lot Control/Lot Homogeneity A lot, identified by a single Purchase Order, shall be manufactured from materials from a single heat, melt, or blow. A lot is defined as a quantity that has been blended, mixed, or fabricated during an uninterrupted manufacturing run by the same personnel. Each batch or lot shall be properly identified with the assigned lot number. Traceability shall be maintained by the supplier of the hardware.</p>
780	<p>Non-Conforming Material Records Submittal The Supplier shall forward to Raysons, all documents associated with any discrepancy, rejection, scrap, or any other form of non-conformance, whether incurred at receiving inspection, in-process or final acceptance, generated during the processing of purchased parts or processes; this includes flowdown to all sub=contracts used on Raysons issued purchase order. The Non-Conforming Material records are to be submitted with each shipment. If there were no non-conformances during the processing of the purchase order, the seller shall state explicitly on the Certificate of Conformance.</p>
790	<p>Failure Notification</p> <p>A. All testing must stop immediately with the test equipment and LAT hardware quarantined. The Seller must submit failure analysis rational and determine if the event is due to testing, process, or product. The LAT testing process may continue and/or release the test equipment once Raysons provides concurrence.</p> <p>B. All testing must stop immediately with the test equipment and IAT/LAT hardware quarantined. The Seller must submit failure analysis rational and determine if the event is due to testing, process, or product. The IAT or LAT testing process may continue once Raysons provides</p>

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	<p>concurrence. A Failure Review Board (FRB) containing members from the Seller, Raysons (and possibly Raysons' customer) may be established to investigate and determine the appropriate course of action.</p>
800	<p>Special Processor Changes Changes in location and/or different Supplier (sub-tier) for special processes are not allowed from what was performed on the previous production lot. Supplier change request must be submitted to Raysons for written approval.</p>
810	<p>Special Processes – Raytheon All Special processes from suppliers and sub-tiers must be performed by Raytheon approved suppliers.</p>
820	<p>Special Processes – JPL All special processes from suppliers and sub-tiers must be performed by JPL approved suppliers.</p>
830	<p>Special Processes – Pratt & Whitney All special processes from suppliers and sub-tiers must be performed by Pratt & Whitney approved suppliers.</p>
840	<p>Special Processes – United Launch Alliance (ULA) All special processes from suppliers and sub-tiers must be performed by ULA approved suppliers.</p>
850	<p>Pure Tin Compliance Please provide certificate from the following: All products on the PO that require solder, platings, coatings, and claddings shall comply with the following:</p> <p>A. Material composition less than 97% tin by weight.</p> <p>B. Tin alloy with a composition of greater than 3% lead by weight.</p> <p>C. Please contact Raysons Buyer immediately if either: (1) there is a conflict between the need for tin/lead and the manufacturer's part number stated on Raysons drawing, (2) the manufacturer's part number is not available (do not substitute without prior approval).</p>
860	<p>Process Change Control The supplier shall not permit changes to the manufacturing/assembly processes, materials, and procedures (including changing sub-tier suppliers). any changes require approval by Raysons Procurement and Quality prior to implementation. The approval process may require re-qualification of the hardware (at the supplier's cost) prior to implementation of the change. Such approval does not affect or waive applicable and/or acceptance requirements. Depending on Raysons' customer flowdown, a First Article may be required prior to the production and/or manufacturing of parts or processes. The supplier shall also include the document number and</p>

Clause #	Body text
	revision number of the applicable manufacturing work instructions on the Certificate of conformance or Certificate of Inspection.
870	<p>Delegation of Product Verification Each delegated supplier is responsible for the following:</p> <p>A. Provide notification of a change in ownership, management, or location of supplier's facilities.</p> <p>B. Maintain quality system approval with the parameters of the organization's quality management system requirements.</p> <p>C. Make available a current list of their delegated suppliers for the customer and/or regulatory agency reviews.</p>
880	<p>Serialization Requirements – Raysons Supplies SN Serial numbers are required to be assigned to the parts, assemblies and end items on this purchase order. A serial number control system shall be in place that prevents the same serial number from being used more than once. A list of all serial numbers shall be provided with each shipment of the product. Supplier shall identify the serial numbers of serialized sub-assemblies contained in the deliverable end items. Records must be contained by the supplier.</p> <p>Serial numbers are to be provided by Raysons and serialized parts must be shipped in sequential order – not mixed.</p>