

Rose Integration Purchase Order Quality Assurance Clauses

SUPPLIER QUALITY CONTROL SYSTEM. Each purchase order specifically states which of the following Quality Assurance clauses are applicable to the supplier. The supplier shall establish and maintain a system that complies with the imposed requirements.

100: QUALITY SYSTEM. The supplier shall establish and maintain a system that complies with applicable industry or regulatory standards and is deemed acceptable by ROSE INTEGRATION Quality Assurance including all renewals and/or updates. The supplier is responsible for informing ROSE INTEGRATION when there are changes to the approval status. Quality records must be retained for a period of ten (10) years and shall be made available for ROSE INTEGRATION evaluation upon request and within 24 hours.

110: CALIBRATION SYSTEM. The supplier is required to establish and maintain a calibration system that conforms to the requirements of ANSI/NCCL Z540-1 or ISO 10012-1.

120: GAGE CALIBRATION AND TEST LABORATORIES. Gage Calibration and Test Labs. must maintain accreditation to the applicable requirements of ISO/IEC 17025. For MATERIAL TESTING LABS only, Nadcap or GE S-400 certification is required. ROSE INTEGRATION must be notified if accreditation or certification expires or is withdrawn. Quality Clause 160 (Right of Access) and ten (10) year quality record retention applies.

130: PREFERENCE FOR DOMESTIC SPECIALTY METALS. Supplier agrees to comply with Defense Federal Acquisition Regulation Supplement DFAR 252.225-7014 and Alternate 1, Preference for Domestic Specialty Metals when this clause is specified in the purchase order. Use of foreign specialty metals may only be used with written authorization from ROSE INTEGRATION.

140: SOFTWARE QUALITY ASSURANCE. All non-deliverable software used in the manufacture, inspection or acceptance of product must be under configuration control.

150: NONCONFORMING MATERIAL. Authority to ship nonconforming material must be obtained through ROSE INTEGRATION. Nonconforming material shipped without prior approval is subject to return at the supplier's expense. The supplier must gain approval to ship nonconforming product via ROSE INTEGRATION approved Deviation/Waiver Form.

EACH SUPPLIER IS REQUIRED TO REPORT TO ROSE INTEGRATION IF A PRODUCT OR ARTICLE HAS BEEN RELEASED FROM THAT SUPPLIER AND SUBSEQUENTLY FOUND NOT TO CONFORM TO THE APPLICABLE DESIGN DATA.

160: RIGHT TO AUDIT SUPPLIER. ROSE INTEGRATION, its customers, the Government, Regulatory Bodies and FAA reserve the right to audit any and all systems, processes, and materials in accordance with the purchase order, contract and FAR requirements. The supplier shall grant right of access to ROSE INTEGRATION, their customer, and regulatory authorities to the applicable areas of all facilities, at any level of the supply chain, involved in the order and to all applicable records. areas of the work

170: ROSE INTEGRATION SOURCE INSPECTION AND SURVEILLANCE. ROSE INTEGRATION source inspection and surveillance of system, procedures, facilities, and parts covered by this purchase order are mandatory prior to shipment of purchased items. Use of supplier's equipment, gages and measuring and testing devices shall be made available at the supplier's facility for use by the ROSE INTEGRATION Source Inspector when required to determine conformance to contractual requirements. If conditions warrant, the supplier's personnel shall be made available for operation of such devices and for verification of their accuracy and condition.

180: GOVERNMENT SOURCE QUALITY ASSURANCE (GSQA). GSQA is required prior to shipment from the supplier's plant. Upon receipt of this purchase order, the supplier shall promptly furnish a copy to the Government inspector who normally services the supplier's plant. In the event that delivery of the items will be delayed due to GSQA requirements, the supplier shall contact ROSE INTEGRATION Purchasing immediately. Evidence of GSQA must be indicated on all shipping documents.

190: TRACEABILITY. Traceability shall be maintained from receipt of raw material through finished product. Records and material must be identified by lot number, material type specification and applicable revision identifier or date of issue, heat number, serial number, etc., as required to maintain traceability. Records shall be maintained on file at supplier's facility. If a time limit is not specified, records shall be kept for ten (10) years subsequent to completion of purchase order deliveries. Written permission from the ROSE INTEGRATION QA Manager must be obtained before destroying any documents.

200: FIRST ARTICLE INSPECTION (FAI). Submit First Article sample with report for first build, revisions, and after 2-year lapse in production. AS9102 First Article inspection is the preferred format. The supplier shall furnish first article sample(s) produced using the material, tooling, processes, and planning to be used for subsequent deliveries. The first article samples(s) shall be identified and submitted with a FAI report. The FAI report shall include the ROSE INTEGRATION drawing with numbered characteristics corresponding to an itemized layout reflecting actual readings and shall show compliance to all drawing characteristics, blueprint notes and specifications. Include the method of measurement for dimensional characteristics. For subsequent revisions to the drawing, only those characteristics, notes or specification affected by the revision require reporting. A copy of the raw material C of C is required for an initial build first article and a first article submitted after a two-year lapse in production. NOTE: Submit initial build first article prior to production run shipment unless otherwise directed by ROSE INTEGRATION QA Manager.

210: SPECIAL PROCESSES. The designated special process must be documented with methods of control in a technical plan format. The technical plan must be submitted with First Article parts for approval by ROSE INTEGRATION prior to submitting the first production order. Once approved by ROSE INTEGRATION, revisions or variations to this fixed process shall not occur unless ROSE INTEGRATION has been notified and has approved the revisions in writing.

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220: CERTIFICATION OF COMPLIANCE.

All parts/processes supplied by the supplier must be certified as to their compliance with all purchase order requirements.

The certification must contain, as a minimum:

1. The ROSE INTEGRATION purchase order number.
2. The ROSE INTEGRATION part number and drawing revision level.
3. Quantity supplied.
4. Supplier's name and if applicable, suppliers part number.
5. For Age Sensitive Material (Shelf Life) reference manufacture/cure date, lot/batch code, and expiration date.
Note: A minimum of 75% of the shelf life must be remaining at date of shipment.
6. Specification and revision letter or date for material specifications or special process specifications. (ROSE INTEGRATION, Military, Government, or Commercial) that appears on the PO or drawing callout.
7. Verifiable results (usually numerical results or observed visual criteria) of all testing/inspections required by PO or drawing specifications for special processes and other applicable products.
8. Certification of 100% inspection or Cpk data when Quality Clause 270 or 300 is stated on the purchase order.
9. Attached copy of authorized deviations/waivers when applicable.
10. Company representative signature and title. Computer generated signatures are acceptable.
11. STANDARD OFF THE SHELF (CATALOG) ITEMS:
Packing list type certification is acceptable provided a signed statement is included. Reference ROSE INTEGRATION PO number, manufacture name and part number (no revision level required) for each item listed.

NOTE: Statement including phrases such as "to the best of my knowledge and belief" are not acceptable. The statement "the material meets all applicable specifications, drawings, and PO requirements" (or similar statement) is not acceptable in lieu of supplying the information required in 6) and 7) above for manufactured parts and processes.

230: MATERIAL TEST REPORTS. Supplier shall include a copy of the mill test report which contains the complete chemical and mechanical test data that has been verified by the supplier as meeting the acceptance requirements of the applicable raw material specification and/or engineering drawing. It is acceptable to have actual test values or range limit data from the raw material producer.

240: GENERAL REQUIREMENTS FOR PACKAGING. All parts shall be packaged for shipment to ROSE INTEGRATION using any suitable means that will prevent damage or as specified in PO or specifications. Any part damage prior to ROSE INTEGRATION receiving dock is the responsibility of the supplier.

250: SAMPLING. ROSE INTEGRATION reserves approval authority over sampling plans used for product acceptance. All sampling plans will show measured values, and "accept" or "reject" on visual features. **(No defects are permitted.)** ROSE INTEGRATION reserves the right to require justification for sampling in lieu of 100% inspection.

260: THREADS. Specified plated thread dimensions are after plating or coating using functional gaging practice. All openings must be suitably protected against entrance of foreign material. Use suitable packaging to protect against staining.

270: THREAD INSPECTION ON ACCEPTANCE REQUIREMENTS.

SCOPE: This purchase order clause applies to all threads unless otherwise specified or excluded in writing by ROSE INTEGRATION

REF: FED-STD-H28/20

ANSI/ASME B1.3M

MIL-S-8879

ROSE INTEGRATION requires that suppliers of threaded parts possess screw thread gauging systems capable of complying with ANSI/ASME B1.3M, System 22.

The supplier will conduct variables measurement of threads for the following characteristics:

1. Pitch diameter size.
2. Functional size.
3. Major diameter.
4. Minor diameter (UNJ external only).
5. Root radius (UNJ external only).

The supplier will perform 100% inspection as described below or may sample inspect when calculated process capability index (Cpk) is maintained at 1.33 or greater with no inspection points out of control.

Cpk must be calculated for the above characteristics as follows:

THE LESSER OF : (USL – MEAN) or (MEAN-LSL)
3 SIGMA 3 SIGMA

The supplier must provide certification of 100% inspection or provide the actual calculated Cpk values for required characteristics.

Supplier gaging and statistical calculation methods must be able to demonstrate correlation with those methods used by ROSE INTEGRATION.

ROSE INTEGRATION receiving Inspection will reject lots which do not meet the Cpk requirements of 1.33 or greater for required characteristics.

280: PLATING. Supplier must certify that plating process conforms to the ROSE INTEGRATION supplied drawings and specifications, in addition to other certificate requirements.

290: Sub-Contracted Parts and Services. Supplier must obtain written approval from ROSE INTEGRATION.

300: CRITICAL TO QUALITY FEATURES (CTQ) FLOWDOWN. Item ordered may have requirements for statistical control of selected "CTQ" characteristics.

Supplier must maintain a system for control and provide Cpk data on certification. The CTQ characteristics Cpk must be maintained at 1.33 or greater. When applicable, ROSE INTEGRATION will identify CTQ characteristics on the drawing and/or in the PO comments. Contact the ROSE INTEGRATION for advice if required. Sampling inspection may only be used within the guidelines specified in Quality Clause 250. These CTQ characteristics shall be flowed down to sub-tier suppliers where applicable.

Alternate acceptance method: 100% - CTQ characteristics must be within 75% of Blueprint tolerances and centered.

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Corresponding Applicable Clause Table

Clause	Raw Material	Heat Treat	Finishing	Components	Gauges	Calibration	Tooling	Testing
100	X	X	X	X	X	X	X	X
110						X		
120					X	X		
130	X			X				
140								
150	X	X	X	X	X	X	X	
160	X	X	X	X				
170								
180			X					
190	X	X	X	X				
200				X				
210		X	X	X				
220	X	X	X	X	X			
230	X	X	X	X				
240	X	X	X	X	X		X	
250				X				
260								
270					X			
280		X	X	X				
290		X	X	X				X
300		X	X	X				