



<b>POS</b>	<b>Purchase Order Supplement</b>		
<b>Issued by: Quality</b>	<b>Effective Date: 12/29/2016</b>	<b>Rev. B</b>	<b>Pg. 1 of 2</b>
Approved: 12/29/2016 1:45 PM - Jacqui Williams		Approved: 12/28/2016 1:36 PM - Kathie Fitzpatrick	

**PURCHASE ORDER SUPPLEMENT**

The following supplementary provisions as noted on the purchase order shall be applicable to the furnishing of the goods and services covered by the attached purchase order. The Seller in accepting this order agrees to be bound by the paragraphs specified on the purchase order and comply with the required provisions in all respects. SKILD Manufacturing reserves the right to schedule and perform an onsite audit.

A test report is required with material to show actual content to stated specification.

**1** Certification of conformance is required for each shipment. The C of C shall contain the following information; Purchase Order number, Supplier's name and address, Specification number or Drawing and revision, Material identification, date, Serial number (if applicable), Specification requirements, Special Process specification for any outside processing (i.e.: Heat Treat, Plating, NDT), Actual test results including individuals and averages, Batch, heat lot number or lot number, as applicable and signed by an authorized agent. All MPI materials provided for magnetic particles must certify that it meets the requirements of ASTM E1444, AMS 3044

**1A** Specialty metals must be melted in the United States or a qualifying country, or they can be melted anywhere but must be "incorporated in an article manufactured in a qualifying country" per the requirements stated in DFARs 252.225. The clause allows a qualifying country to manufacture parts from metal that was melted anywhere, provided it meets specifications, but a United States company can only use metal that was melted in the United States or a qualifying country.

**2** Receipt of supplies and services applying to this order is interpreted as certification by you and/or your suppliers, if applicable, that you have conformed to the requirements of this purchase order. Your records or your supplier's records must contain test results and quality data in sufficient detail to substantiate conformance to requirements, a copy of which will be sent to Skild Manufacturing upon special request.

**3** **Supplier's Quality Control** system must conform to ISO 9000 or AS 9100.

**4** Supplier's Calibration System must conform, at a minimum, to ISO 10012 (traceability to NIST is required). For all suppliers or sub-tiers performing calibration on NDT equipment their calibration process must conform to ASTM E1444, ISO 10012, ISO 17025, ANSI Z540 requirements.

**5** **All referenced specifications** shall be interpreted to mean compliance with the revision in effect on the date which this order was entered unless otherwise noted.

**6** **Material, packaging, equipment, and/or gaging** furnished by Skild Manufacturing shall be returned with each shipment. Material furnished under this order shall also be free from contamination.

**7** **Supplier's Calibration/Material Testing Lab System** must conform to ANSI Z540 / ISO 17025.

**8** Personnel with responsibility for performing work that affects product conformity must be qualified especially when responsibility includes any testing considered to be a special process.

**9** **Skild Manufacturing**, its customers, and any regulatory authorities reserve the right of access to a supplier's facility when it has been deemed necessary. This includes applicable areas of the facility as any applicable records. necessary. This includes applicable areas of the facility as any applicable records.

**10** **Personnel with responsibility** for performing work that affects product conformity must be qualified especially when responsibility includes any testing considered to be a special process.

**11** **Quality System Requirements for Approved Suppliers:** Suppliers must maintain a Quality System complaint to ISO 9001 or AS9100 unless the supplier is required to be used by our customer

must maintain a Quality system complaint to ISO 9001 or AS9100 unless the supplier is required to be used by our customer.

**12** **Special Process Certification:** Supplier shall provide with each shipment a certification for all special processes performed, such certifications shall include:

- a. Skild Manufacturing purchase order number
- b. Skild Manufacturing part number and revision level
- c. Specification including revision letter to which material or parts were processed (see note below)
- e. Quantity Attention: In the event actual quantities don't match the purchase order quantity contact your buyer **immediately** upon receipt of order.
- f. Any test results required by specification
- g. Special process information when applicable, i.e. time and temperature used to process, technique cards, etc.

**13** **Single Lot Control:** The supplier shall maintain Single Lot Control for each PO line. All material used for each PO line shall consist of the same origin of material (heat, batch, resin, etc.) If multiple lots are required to complete the order, the supplier shall contact SKILD Manufacturing and request adding additional PO lines. Product shall be clearly identified with corresponding line item of purchase order.

**14** **Product and or Process changes:** must be approved by Skild Manufacturing prior to implementation. In the event of a manufacturing or assembly process change notification must be submitted to Skild Manufacturing for approval. Supplier must notify Skild manufacturing of process changes affecting quality. (Note: failure to comply or receive permission to deviate may result in material being rejected at returned at Suppliers expense.

**15** **Nonconforming Material;**

Suppliers shall begin containment action upon discovery/notification of a product nonconformance. If the product escaped their facility and have been shipped to Skild Manufacturing, the supplier shall notify Skild Manufacturing.

For product that has been found or suspected discrepant prior to shipment to Skild Manufacturing, all requests for approval for repair or to be "used as is" must be submitted to Skild Manufacturing following a material deviation request and material must be held at the supplier's address pending documented approval from Skild Manufacturing prior to further processing and/or shipment of nonconforming material.

Failure to respond to a corrective action request may result in penalties up to and including suspension or removal from Skild Manufacturing approved supplier list.

16 Exemption from this requirement may be granted from Skild Manufacturing. Prior to approval, supplier must provide objective evidence to ensure applicable records and test data can be retrieved from archives upon request within a reasonable period of time.

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:

Time Period	Description
40 years from time of manufacture	Flight safety, critical / major rotor parts (i.e. turbine and compressor disks, hubs, shafts, free turbine couplings and turbine disk side plates), serialized major engine (cast / fabricated) cases (i.e. inlet, fan, compressor, intermediate, diffuser, combustion, turbine and exhaust cases) and main shaft bearing supports, which are not integral to a major case.
30 years	Manned Space Program Hardware
10 years	All other parts except off-the-shelf industry standard parts.
5 years	Off-the-shelf / industry standard parts (e.g. AN, AS, MS, JAN, etc.)

Radiographs: The supplier shall retain radiographs.

Time Period	Description
40 years	Flight safety, Critical / major rotor parts (i.e. turbine and compressor disks, hubs, shafts, free turbine couplings and turbine disk side plates), Serialized major engine (cast / fabricated) cases, (i.e. inlet fan, compressor, intermediate, diffuser, combustion, turbine and exhaust cases), and main shaft bearing supports which are not integral to a major case and engine components traceable by Engineering Drawing / Quality Assurance Data required serial numbers.
10 years	Castings or parts where the purchase order, engineering drawing or specifications require serial number traceability.  Castings or parts where the purchase order, engineering drawing or specifications do not require serial number traceability, shall be retained only if no other inspection record is retained that documents completion and final acceptance of radiographic inspection.
5 years	Military hardware - turbine airfoil (blades) casting radiographs for initial casting quality.  Military hardware - Radiographs of airfoils for the presence of foreign material need not be retained provided an inspection record is retained that documents completion and final acceptance of radiographic inspection.