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REVISION HISTORY			
Rev	Description of Change	Author	Effective Date
00	Original Release of this document	Rod Scherlin	6/23/21

1. Purpose

To aid purchasing with flow down of Quality Clauses to Suppliers.

2. Standard Hardware

2.1 Standard Hardware:

For standard hardware, if customer drawing or specification lists source those suppliers will be used for procurement. If there is no source control requirement, than based on product requirements, suppliers will be selected on information gathered through Engineering and Quality sources.

- Criteria for selection shall be based on the supplier's capabilities, past performance and cost of quality (quoted price verses risk of nonconforming)

3. Standard Clauses

Standard Processor Quality Clauses:


(01) Nondisclosure Agreement: Acceptance of contract acknowledges the nondisclosure of information which may be sensitive to Tolerance Masters and or our customers. Sensitive information pertains to documents which creates value when used.

(02) Quality Systems requirements: Customer Quality systems requirements flowed down in the contract are listed on the Purchase Order and must be complied with. Or if there are no Customer Quality systems flow down then Quality Systems as a minimum must be compliant to ISO 9001:2015 requirements.

(03) Inspection Equipment: Suppliers method of inspection measuring and test equipment used to verify conformance of product or processes shall be at a level to comply with ISO 9001:2015 and ISO 10012-1. With results traceable to N.I.S.T (National Institute of Standards Technology) and shall be used when product verification is done prior to shipment to Tolerance Masters.

(04) Pre-Penetrant Etch for Penetrant Inspection:

- (a) When ASTM-E1417/E1417M is the required specification for processing, Pre-Penetrant Etch is not required unless directly stated in the purchase order work instructions.

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(05) Nonconforming Material: Supplier must submit any nonconforming product for evaluation prior to shipment. Notification of suspect nonconforming product must be made within 24hrs of identification. (No Material Dispositions Are Allowed).

(a) Process Suppliers: Re-processing for processes not meeting specifications are not allowed without concurrence from Tolerance Masters prior to any re-processing.

(06) Records Retention: Retention of records related to the product or processes purchased by Tolerance Masters shall be a minimum of 20 years, and must be retrievable and legible back to original purchase order.

(07) Right of Entry: Right of entry shall be granted to Tolerance Masters customers and or regulatory agencies for verification of contracted work. Exceptions may be proprietary processes pre-approved by the customer.

(08) Out Sourcing: Supplier shall not outsource any operations without notification and prior approval from Tolerance Masters.

(09) End User, Purchasing Documents: (Defined by end user / customer, templates are maintained with/in JobBoss)

(10) ITAR/EAR Classification: This part has an ITAR/EAR classification, meaning that the part being processed or manufactured maybe used in a military application. And technical information or documentation as part of the Purchase Order shall not be released or disclosed to any foreign entity or foreign national inside or outside the United States without obtaining U.S. government license or authorization. Violations to ITAR/EAR regulations are subject to penalty and or fines under 22 U.S.C. 2778

(11) Counterfeit Materials: Suppliers shall have a Counterfeit Material Control policy which complies with requirements to AS5553 for electronic components or AS6174 for non-electronic components.

(12) Processing Operations: Any Processing operations which metallurgically changes the material properties shall require the processing steps for time and temperature to be shown on a Certificate of Conformance or Process cert.

4. Raw Material Clauses

Raw Material Quality Clauses:


(R01) Raw Material Certificate of Conformance:

Suppliers and distributors shall show the full material traceability and transfer of ownership traceability through Raw Material Heat Lot numbers and Purchase Orders with name, nomenclature and material identification.

Reports shall show clear traceability to the manufacturer(s) of the raw material including ingot source, all thermo-mechanical processing (i.e. forging, rolling, drawing, etc), Heat Treatment, Chemical processing and inspections as required by applicable specification of the raw material.

(R02) Chemical and Physical Analysis:

Chemical and Physical Analysis reports are required as per the material specification requirements.

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Material testing must be performed by an accredited Lab, and all reports traceable to the material Heat Lot.

(R03) Casting / Forging Weld Repair:

All casting / forging weld repair even if allowed by specification or furnished Drawing must be reported to Tolerance Masters and casting / forging which were repaired identified on reports and Certificate of Conformance.

(R04) Counterfeit Materials: Suppliers shall have a Counterfeit Material Control policy which complies to requirements of AS5553 for electronic components or AS6174 for non-electronic components.

5. Chemical Clauses

Chemical Quality Clauses:

Chemicals / Solutions / Solvents

(Paints, Epoxy, Hardeners, Clear Coats, Mineral Spirits, Inks, Cutting Fluids, Processing Solutions, etc.)

(C01) Documented Traceability to Manufacturer and QPL# (Qualified Products List) if applicable.

(C02) Manufactures D.O.M. (Date of Manufacture) is required to be stated on Certificate of Conformance or Product Information Sheet.

(C03) Manufactures Shelf Life Terms or Recommended Shelf Life is required to be on Certificate of Conformance or Product Information Sheet. Manufactures shelf life must have a minimum of 75% shelf life remaining at time of shipment to Tolerance Masters.

(C04) Counterfeit Materials: Suppliers shall have a Counterfeit Material Control policy which complies to requirements of AS5553 for electronic components or AS6174 for non-electronic components.

6. Calibration Clauses

Calibration Services Quality Clauses:

Calibration Services:

Suppliers of Calibration services shall maintain a Quality System in accordance with one of the following: ISO 10012, ISO 17025, ANSI Z540-1

Calibration Reports:

(CA01) The supplier shall provide a calibration report/certification supporting the calibration services performed. The report/certification shall contain, as a minimum:

(CA02) Measurement data results

(CA03) Statement certifying traceability to National Standards (NIST).

(CA04) Listing of standard(s) used to perform test(s) with last calibration performed date(s) and next calibration due dates.

(CA05) Statement of measurement uncertainty and ambient environmental conditions (i.e., ambient temperature and humidity) at time of test(s).