 5th AXIS INC Automated Production Manufacturing & Machining		
Title: Purchase Order Quality Clauses	Document No.: D-02	Rev.: 2.1
Not controlled in hard copy. Document available electronically.		Effective Date: 11/21/2024

Q1 – INSPECTION AND TEST SYSTEM REQUIREMENTS

The supplier shall establish and maintain an Inspection and Test System in compliance with the requirements of AS9100, ISO 9001, ISO 13485 or equivalent quality standards. The supplier Inspection and Test System is subject to audit, verification and approval and/or disapproval by 5th Axis designated representatives.

Q2 – MRB AUTHORITY

Material review board authority is not authorized on this purchase order.

Q3 – APPROVAL & CHANGES

The supplier shall notify the buyer of any proposed changes in the design, fabrication methods, material supplier, manufacturing/processing location, which has the potential to affect the conformity of the final product supplied to 5th Axis. Suppliers with previously approved/locked down processes shall obtain written approval of changes from the buyer. Changed articles shall be clearly identified and in a different manner from the previous articles. When the buyer procures a proprietary item, the supplier shall notify the buyer of changes.

Q4 – RAW MATERIALS

Raw materials / Raw materials used to satisfy this order, shall be accompanied with documented certifications, for chemical and physical test results. The supplier shall certify to the specific requirements defined on the face of the purchase order / drawings as applicable.

Q5 – IDENTIFICATION & DATA RETRIEVAL

Where and to the extent that traceability is a specific requirement, the supplier shall apply a unique identification to the individual product, material or batch. This identification data shall be recorded on and traceable to related supplier's records (see supplier quality records)

Q6 – SUPPLIER QUALITY RECORDS


The supplier shall maintain suitable inspection and test records to serve as evidence of conformance with specified requirements. Such records shall be legible and traceable to the product involved. These records shall be maintained for a minimum period of seven (7) years from the date of final manufacture or as stated otherwise in the contract.

Q7 – SUBMISSION & RESUBMISSION OF NONCONFORMING ARTICLES OR MATERIALS

Do not send nonconforming products or materials to 5th Axis without prior written authorization. Nonconforming articles and/or materials returned by the buyer and subsequently resubmitted by the supplier shall bear adequate identification of such nonconformance, on the articles, materials, or applicable supplier's records. The supplier shall provide evidence that the cause of the nonconformance was corrected and that actions were taken to preclude any recurrence.

Q8 – ACCESS TO SUPPLIER'S FACILITIES AND RECORDS

The supplier shall grant reasonable access to all the supplier's facilities and records to representatives of 5th Axis, 5th Axis' customers, US government and/or regulatory agencies for the purpose of evaluation of supplier's conformance to all PO/Contract requirements. When applicable, the access requirement shall be flowed down by the supplier to the supplier's sub-tier sources.

 5th AXIS INC Automated Production Manufacturing & Machining		
Title:	Purchase Order Quality Clauses	Document No.: D-02 Rev.: 2.1
Not controlled in hard copy. Document available electronically.		Effective Date: 11/21/2024

Q9 – FIRST ARTICLE

The Seller shall perform a First Article Inspection (FAI) of one item from the first production lot, or for a quantity instructed by the Buyer / PO. The FAI shall consist of recorded actual drawing, specification values, and/or requirements (dimensional, test data, processes, drawing notes, etc.) and may be documented on the drawing or on a separate report form (AS9102 or equivalent). The first article item(s) shall be clearly identified by a tag attached to the item or a label applied to the bag, and a copy of the FAI shall accompany the First Article part. The Buyer reserves the right to verify any or all of the characteristics documented on the FAI report at the seller's facility.

Q10 – CERTIFICATE OF COMPLIANCE

Supplier shall provide evidence that the processes requested in this purchase order were performed by approved sources. The supplier shall maintain such evidence on file. Included with each shipment to the buyer shall be a certificate of conformance indicating as a minimum the process description, process number, name and address of the process supplier, the purchase order and part number.

Q11 – MATERIAL TRACEABILITY

Identification of each piece of material and each report is required by specification to provide traceability to heat lot or batch number

Q12 – GRAIN DIRECTION IDENTIFICATION REQUIRED

(where applicable)

Q13 – CONTROL OF SUB-TIER SOURCES


The supplier, as the recipient of the PO or Contract, is responsible for meeting all PO/Contract specified technical and quality requirements, whether the supplier performs the work or the work is performed by the supplier's sub-tier sources. When the supplier uses sub-tier sources to perform work on products and/or services scheduled for delivery to 5th Axis, the supplier shall include (flow-down) on Purchase Orders or Contracts, to their sub-tier sources, all of the applicable technical and quality requirements of the 5th Axis P.O. or Contract, including, when applicable the requirement to document and control "key characteristics" and/or "key processes", and to furnish certifications and test reports required by the applicable P.O. Quality requirements.

Q14 – SUPPLIER NOTIFICATION OF NONCONFORMING PRODUCTS DELIVERED TO 5TH AXIS.

When the supplier has determined that the nonconforming product(s) have been delivered to 5th Axis, the supplier shall notify 5th Axis within twenty-four (24) hours of the initial discovery. The supplier shall use receipt acknowledgement e-mail or other positive notification method. The notification shall include the supplier's name, 5th Axis PO/Contract number, part number and description, affected quantity and serial numbers (if known), dates delivered (if known), brief description of the nonconforming condition.

Q15 – REQUIREMENTS FOR QUALIFICATION OF PERSONNEL

Where applicable, only qualified/certified personnel shall be used based on process specification requirements (NDT, etc.). Records shall be maintained of the personnel qualifications/certifications.

 5th AXIS INC Automated Production Manufacturing & Machining		
Title:	Purchase Order Quality Clauses	Document No.: D-02 Rev.: 2.1
Not controlled in hard copy. Document available electronically.		Effective Date: 11/21/2024

Q16 – DELEGATED AUTHORITY OF INSPECTION FOR RAW MATERIAL

Where applicable, 5th Axis authorizes the supplier to perform receiving inspection on all raw materials, purchased by 5th Axis, which were shipped directly to the supplier from another 5th Axis supplier. When the order is complete, the supplier shall ship the original packing slip and material certification to 5th Axis with the order.

Q17 – CONTROL OF ITAR REQUIREMENT

The supplier shall hereby acknowledge that any information exchanged between 5th Axis and the supplier may include documents which contain technical data, export of which is restricted by the INTERNATIONAL TRAFFIC IN ARMS REGULATIONS (ITAR). Disclosure to foreign persons without prior U.S. Government approval is prohibited. Violations of these Export Laws and Regulations are subject to severe Civil and Criminal penalties.

Q18 – HARDWARE/COUNTERFEIT PREVENTION PROGRAM

The supplier shall comply with the requirements of AS5553, AS6174 and/or AS9120. Distributors or brokers that supply non-electrical standard parts (Hardware), like fasteners, nuts, washers, springs, o-rings, inserts, and pins, must be shipped in a sealed OCM (Original Component Manufacturer) container, which contains the name of the OCM, Part Name/Number, and a Heat/Lot/Control Number at a minimum. If that is unavailable, the original OCM Certification must be included with the shipment.

Q19 – CALIBRATION STANDARDS

The supplier shall comply with the requirements of ANSI/NCSL Z-540-1 and ISO/IEC 17025:2005. All standards used in the calibration process shall be traceable to the National Institute of Standard (NIST). A Certificate of Calibration is required for all items calibrated.

Q20 – SPECIAL PROCESSES

Certifications for 5th Axis subcontracted processes such as Heat Treating, Phosphate Coating, Chrome Plating, and Anodizing, etc., are required as part of the supporting documentation on parts certified under this Purchase Order and required with each shipment.

Q20 – DFARS COMPLIANCE

All raw materials used must be sourced from a DFARS qualifying country. An updated list of qualifying countries can be found at Defense Federal Acquisition Regulation Supplement (DFARS) 252.225-7002.



Title:	Document No.:	Rev.:
Purchase Order Quality Clauses	D-02	2.1
Not controlled in hard copy. Document available electronically.		Effective Date: 11/21/2024

Quality Clause Applicability Matrix

OSP ITAR	OSP	FAB ITAR	FAB	MATERIALS	HARDWARE	TOOLING SUPPLIES EQUIPMENT	CALIBRATION	TEST
Q1	Q1	Q1	Q1	Q1	Q1	Q1	Q1	Q1
Q2	Q2	Q2	Q2	Q2	Q5	Q13	Q2	Q2
Q3	Q3	Q3	Q3	Q4	Q6		Q3	Q3
Q5	Q5	Q5	Q5	Q5	Q7		Q5	Q5
Q6	Q6	Q6	Q6	Q6	Q8		Q6	Q6
Q7	Q7	Q7	Q7	Q7	Q10		Q7	Q8
Q8	Q8	Q8	Q8	Q8	Q11		Q8	Q10
Q10	Q10	Q9	Q9	Q10	Q13		Q10	Q13
Q11	Q11	Q10	Q10	Q11	Q14		Q13	Q15
Q13	Q13	Q11	Q11	Q13	Q15		Q15	Q17
Q14	Q14	Q13	Q13	Q14	Q18		Q19	
Q15	Q15	Q14	Q14	Q15				
Q17	Q20	Q15	Q15					
Q9 When required	Q9 When required	Q17						
		Q4 or Q16 When required	Q4 or Q16 When required	Q12 or Q16 When required				

OSP = Outside Special Processing (i.e. Heat Treat, Phosphate Coating, Chrome Plating, and Anodize, etc.)

FAB = Fabrication

Machining (CNC, Turning, Screw Shop, etc.);
EDM;
Diamond Turn;
Grinding
Waterjet / Laser Cut forms.
Specialized Raw Material (Made to Print)
Specialized Extrusions, Castings, etc.

Raw Material:

Stocked Material from a Distributor or OEM Manufacturer

Hardware:

Stocked Hardware Item from a Distributor or OEM Manufacturer

Equipment:

Maintenance Supplies, Manufacturing/Inspection Software Licenses, etc.

Tooling:

Manufacturing/Inspection Tooling

Supplies:

Packing Material (Foam, Bubble Wrap, Plastic Bags)