



TITLE

SUBCONTRACTOR QUALITY SYSTEM REQUIREMENTS

PREPARED BY

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DATE

16 AUG 2016

REVISION N

ECO # 104732

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1.0 PURPOSE

The purpose of this document is to establish the minimum requirements for Nammo Talley, Inc. (hereafter referred to as Nammo Talley) Supplier's Quality System when specific requirements are not noted on the Nammo Talley Purchase Order (PO).

2.0 REFERENCED DOCUMENTS

Documents:

TQMS 2.15.07	Supplier Request for Nonconforming Product Review
MIL-STD-1916	DOD Preferred Methods for Acceptance of Product

Forms:

TDS-0656	Nammo Talley Purchase Order
TDS-2048	Quality Codes
TDS-2142	Supplier Quality System Assessment
TDS-2575	Detailed Inspection Plan (DIP)
TDS-2597	Supplier Waiver
SAE AS9102	FAI Record

3.0 RESPONSIBILITY

This document shall be interpreted and maintained by the Director of Quality.

4.0 PROCEDURE

4.1 Supplier Quality System Requirements: Requirements for the Supplier's Quality System may be specified in the note section of the Nammo Talley Purchase Order (PO); Form TDS-0656. When the PO does not identify a specific requirement for the Supplier's Quality System then the following Nammo Talley Quality System requirements become mandatory.

4.1.1 General Quality System. Nammo Talley Suppliers shall maintain a quality system that assures all products conform to contract, drawing, and specifications, whether manufactured or processed within the Supplier's facility, or subcontracted. Suppliers

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shall notify Nammo Talley in writing if manufacturing of Nammo Talley product is to be moved to a new location. Personnel performing work affecting the quality of Nammo Talley product shall have the responsibility, authority and organizational freedom to:

- a. initiate action to prevent the occurrence of any nonconformities relating to the product, process and quality system;
- b. identify and record any problems relating to the product, process and quality system;
- c. initiate, recommend or provide solutions through designated channels; verify the implementation of solutions;
- d. control further processing, delivery or installation of nonconforming product until the deficiency or unsatisfactory condition has been corrected

- 4.1.2 Work Instructions.** Nammo Talley suppliers shall provide written manufacturing and inspection instructions. The instructions shall describe the manufacturing process and inspection procedure used to produce product according to Nammo Talley approved drawings and specifications.
- 4.1.3 Records.** Nammo Talley Suppliers shall maintain records of all inspections and tests for a minimum of 11 years unless otherwise noted on the Nammo Talley PO. The records shall indicate the nature and the number of observations made, the number and type of deficiencies found and the quantities approved and/or rejected. All records shall be made available to Nammo Talley upon request.
- 4.1.4 Error Prevention System.** Nammo Talley suppliers shall have and maintain an error prevention system to preclude recurrence of product and services which deviate from drawings and/or specifications. Nammo Talley.
- 4.1.5 Calibration.** Nammo Talley supplier shall purchase and/or maintain calibration of all measuring and testing devices necessary to assure that all product conform to the purchase order requirements. While Nammo Talley, at their option, may provide all or part of these devices to the supplier, the use of Nammo Talley supplied equipment does not relieve the supplier of their responsibility to provide product in complete conformance to the PO requirements. The supplier shall immediately return all gages and fixtures when requested by the Buyer.

The supplier shall utilize a calibration system that effectively controls the accuracy of all measuring and testing devices. These devices shall be inspected and calibrated on a regularly scheduled basis to assure continued compliance with PO requirements. Calibration and recall schedules shall be made available to Nammo Talley upon request and may be subject to disapproval and subsequent revision. The standards used to calibrate the supplier's measuring and testing equipment must reflect an unbroken link to the National Institute of Standards Technology (NIST).

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4.1.6 Segregation of Material. Supplier shall establish and maintain an effective and positive control system for the identification and segregation of raw material, work in process, and nonconforming product. Bonded stores (secured locked storage) shall be used when appropriate.

4.1.7 Source Inspection. Nammo Talley, its customers, and the U.S. Government may elect to perform source inspection at the supplier's facility to confirm product conformance. The supplier shall permit access to all areas devoted to Nammo Talley product and shall cooperate with Nammo Talley personnel, its customers, and the U.S. Government allowing them to accomplish their tasks.

4.1.8 Inspection Instructions. A completed Inspection Record must be submitted with each product lot shipment. All requirements specified in the Nammo Talley PO, Drawing(s), Critical Item Fabrication Specification (CIFS), TDS-2048 Quality Codes (Q-codes) or other supplied specification(s), shall be recorded and reported. Suppliers are encouraged to obtain a Nammo Talley Detailed Inspection Plan (DIP) form TDS-2575 for documenting inspections. Supplier may use their own form until they receive a customized In- Process DIP form (TDS-2575) from Nammo Talley.

When provided by Nammo Talley, suppliers shall record inspection data on an In-Process DIP form (TDS-2575). The form must be submitted with each lot shipped, and accompanied with supplier generated data for all features sampled. The In-Process DIP must account for all features, notes, and other attributes specified in the Nammo Talley PO, Drawing(s), Critical Item Fabrication Specification (CIFS), or other supplied specification(s). When Nammo Talley engineers have received, reviewed and accepted the data contained on the In-Process DIP their signatures will signify final approval.

4.1.9 First Article Inspection (FAI). Nammo Talley Suppliers are required to perform a FAI and provide Nammo Talley with a copy of the FAI Report (FAIR) with the first shipment of product. A FAIR or Delta FAIR shall be required for:

- a) Manufacturing process, drawing/specification changed between reorders,
- b) Lapse in production as specified in procurement documentation,
- c) Change to hard or soft tooling
- d) Production of Nammo Talley product has moved to a new location

In the event that multiple purchase orders are fulfilled in one production lot, the FAIR must identify each purchase order number. Actual FAI part/components may not be required to be sent to Nammo Talley. Suppliers shall list FAI measurement data in the space provided on the DIP form TDS-2575. If the DIP form has not been finalized/approved the preferred FAI record SAE AS9102 form should be used for the FAI submission.

Unless specified by a statement on the Nammo Talley PO, commencement of full-scale production does not require FAI approval by Nammo Talley. Production may be undertaken at supplier's risk, however, Nammo Talley must be informed of and approve

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any specification deviation prior to a Supplier's full-scale production. Nammo Talley Suppliers may elect to submit samples for Nammo Talley FAI approval prior to full-scale production.

Out of specification measurements shown on the FAI report or the Detailed Inspection Plan (TDS-2575) shall be documented on a Supplier Wavier TDS-2597 per TQMS 2.15.07. Product shall be segregated until the Nammo Talley Supplier Waiver disposition provides direction.

4.1.10 Request for Deviation Waiver Request for material review action on non-conforming product shall be processed through the Nammo Talley Buyer. Supplier shall use a Supplier Wavier TDS-2597 to document a preventative action plan for any nonconforming material found either at their facility or at Nammo Talley. Nammo Talley Supplier Quality Engineers shall accept/reject supplier corrective/preventative actions plans.

- a. Supplier shall segregate suspect product. And request Nammo Talley buyer forward Supplier Wavier form TDS-2597 to document nonconformance per Supplier Request for Nonconforming Product Review, TQMS 2.15.07. Supplier shall complete required sections and return to Nammo Talley buyer.
- b. Requests for Supplier Waiver are processed through the normal Nammo Talley Material Review and corrective action requirements already established. Nammo Talley Engineers shall process the SRDW in accordance with Nammo Talley MRB documentation. The Buyer may elect to solicit price compensation for this action.
- c. Upon receipt of the disposition of the Supplier Waiver form TDS-2597 the Supplier shall fulfill any action items denoted on the Supplier Waiver. A copy of the completed Supplier Waiver shall accompany any shipment to Nammo Talley or drop shipped to an authorized drop ship location for the affected hardware. A copy of the manufacturing/ inspection documents shall accompany affected hardware documenting any additional work performed.

4.1.11 Sampling Plan. When no sampling plan is specified by the Nammo Talley PO, Drawing Critical Item Fabrication Specification (CIFS) or other procurement documents, the supplier shall utilize the most current revision of the MIL-STD 1916. Sampling shall be conducted at General Inspection level II, with Critical characteristics inspected at 100%, Majors at VL-IV and Listed and unlisted Minors at VL-II

4.1.12 Quality Codes. Quality Codes are Nammo Talley Inc. requirements imposed at the specific part number level. The Quality Codes are located on form TDS-2048 in the supplier portal. The Nammo Talley PO identifies the codes imposed on each part number/service/material etc... The quality code document is revision sensitive. It is the supplier's responsibility to ensure that the most recent version of this document is "in hand" upon acceptance of a purchase order. These are available online at Nammo Talley.com, Supplier Connection link. The applicable revision of this document directly correlates to the purchase order acceptance date.

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