



**Supplier Quality Requirements  
Material Providers**

PF # : 059-M  
Rev : 07  
Date : 07/18/18  
Pages : 1 of 8

<b>Purpose/Scope</b>	To communicate Patriot Forge Co.'s quality requirements to providers of raw material as it applies to the conditions invoked on the Purchase Order (PO).
<b>Responsibility</b>	The owner of this Spec is the Inventory Manager. The owner is responsible for ensuring that the information contained within this document is accurate and up to date and that revisions are made, submitted for review as required and issued.
<b>Related Docs:</b>	PS059 Purchase of Raw Material (internal document only), Material Purchasing Procedures, PF094 Nuclear Audited C of C Template, PF095 C of C Template, and 10CFR21 as it applies to the PO.
<b>Training:</b>	Training in this spec is required by, QA and Materials Group personnel that purchase raw material or review Material Purchase Orders.

<b>Quality Management System</b>	All suppliers are required to have an implemented quality management system in accordance with accepted international standards.
<b>Right of Access</b>	<ol style="list-style-type: none"><li>1. For purposes of inspection and expediting of the services covered by Patriot Forge Co. PO's or work thereon, Patriot Forge Co. reserves the right of access by Patriot Forge Co. personnel, their customer, and regulatory authorities to the applicable areas of all supplier facilities, at any level of the customer's supply chain, involved in the work indicated on the Patriot Forge Co. PO and to all applicable records. This includes access to Patriot Forge Co.'s supplier's subcontractor's premises.</li><li>2. Any approval by such representative shall not relieve the Supplier from the obligation to comply with the requirements of the Patriot Forge Co. PO and this document (PF059-S) in every respect.</li></ol>
<b>Purchase Orders</b>	The Patriot Forge Purchase Order communicated to the supplier will outline the applicable processes, products, and services to be provided including any relevant technical data.

Owner: Inventory Manager- R. Aitkin

Approval: Quality Manager – B. Schoenfeldt

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<b>Nuclear Safety Orders</b>	<p>When the PO designates the work to be nuclear, the following documents apply.</p> <ol style="list-style-type: none"><li>1. ASME Section III, NCA 3800 applies</li><li>2. 10 CFR 50, Appendix B applies</li><li>3. 10 CFR 21 Applies</li><li>4. ASME NQA-1, Part 1 Applies</li></ol>
<b>Quality System Records</b>	<p>Supplier shall preserve all quality system records created by and/or necessary to verify product and process conformance for a period of 10 years from completion of the PO.</p>
<b>Notification of Change</b>	<p>The supplier will notify Patriot of any change in product and/or process, changes of suppliers, changes of manufacturing facility location.</p>
<b>Approval</b>	<p>If approval of products, services, methods, processes, equipment, or the release of product is required it will be outlined on the Patriot Forge purchase order.</p>
<b>Subcontracting</b>	<ol style="list-style-type: none"><li>1. No subcontracting of operations directly related to Patriot Forge Co. PO's is allowed except with Patriot Forge Co. prior written approval.</li><li>2. Where subcontracting is permitted by Patriot Forge Co., the supplier shall pass on all of the Patriot Forge Co. PO requirements to their supplier.</li><li>3. For each Patriot Forge Co. approved subcontracted requirement performed by supplier, a Certificate of Compliance will be required (see section 7 items 1-6).</li><li>4. Supplier retains responsibility for meeting quality requirements on any subcontracted operations or services.</li></ol>
<b>Competence</b>	<p>All employees involved in processing Patriot Forge orders shall be determined to be competent by the supplier. Any qualification requirements will be specified by Patriot Forge on the purchase order.</p> <p>All supplier employees shall be aware of:</p> <ol style="list-style-type: none"><li>1. Their contribution to product or service conformity.</li><li>2. Their contribution to Product Safety.</li><li>3. The importance of ethical behavior.</li></ol>

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<b>Communication</b>	All suppliers are to communicate with Patriot Forge using e-mail, telephone, fax, or letter as appropriate to the situation.
<b>Control and Monitoring</b>	Patriot Forge analyzes supplier performance based on scrap percentage and on-time delivery. The supplier will be notified if results indicate action required on their part. Thresholds are defined annually by Patriot Forge.
<b>Source Inspection</b>	Any required inspections on the supplier's premises by Patriot Forge or its customers will be indicated on the Patriot Forge purchase order.
<b>Statistical Techniques</b>	Product acceptance shall not be based on statistical techniques.
<b>Counterfeit Parts</b>	Suppliers shall have adequate controls to prevent the use of counterfeit items.
<b>Certification from Melting Mill</b>	<p>The Original Mill Certification (OMC) package from melt source suppliers shall contain:</p> <ol style="list-style-type: none"><li>1. Certified chemistry and statement of compliance status with respect to specifications or conditions imposed</li><li>2. Scope of operations performed, i.e., melting and other in-house operations performed, including address at which they were performed</li><li>3. Mercury free statement</li><li>4. No weld repair statement</li><li>5. Statement of formal Quality Program (rev/date) in effect during processing of material.</li><li>6. The verbatim statement – “The recording of false, fictitious or fraudulent statements or entries on this document may be punishable as a felony under Federal Statutes”</li><li>7. For each Patriot-approved subcontracted operation performed by Supplier - a Certificate of Compliance which contains items 2. – 6. above.</li><li>8. <b>Note:</b> Patriot Forge Co. will provide an approved Certificate of Compliance template if the supplier does not have their own. Please request it from the Patriot Forge Co. Quality department if required.</li></ol>

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<p align="center"><b>Certificate Package – Other than Melting Mill</b></p>	<p>Certificate packages from material supplier other than melting mill shall contain:</p> <ol style="list-style-type: none"> <li>1. A Certificate of Compliance which includes:             <ol style="list-style-type: none"> <li>a. listing in-house operations performed, including address at which they were performed,</li> <li>b. identification of the formal Quality Program (rev/date) in effect during processing</li> <li>c. Mercury free statement</li> <li>d. No Weld Repair statement</li> <li>e. The verbatim statement – “The recording of false, fictitious or fraudulent statements or entries on this document may be punishable as a felony under Federal Statutes”.</li> </ol> </li> <li>2. A copy of the Original Melting Mill Certificate of chemistry and specification compliance</li> <li>3. For each change of title prior to current ownership, a Certificate of Compliance which contains items 1a) – e) above.</li> <li>4. For each Patriot-approved subcontracted requirement performed by supplier, a Certificate of Compliance which contains items 1a) – e) above.</li> <li>5. Upon request Patriot will provide an example template of a Certificate of Compliance for reference.</li> </ol>
<p align="center"><b>Product Conformance, Warranty and Disclosure of Non-Conformances</b></p>	<ol style="list-style-type: none"> <li>1. The supplier guarantees that all goods and services covered by the Patriot Forge Co. PO shall conform to the specifications, drawings, samples or other description described therein; shall be fit and sufficient for the purpose intended, merchantable, of good material and workmanship and free from defect, and that goods and services of supplier’s design will be free from defect in design.</li> <li>2. Known or suspected nonconformance with the requirements of the Patriot Forge Co. PO shall be brought to the attention the Patriot Forge Co. Quality department for review and written acceptance <i>prior to shipment</i>. Known or suspected nonconformance with requirements <i>detected after shipment</i> shall be brought to Patriot Forge Co.’s Quality department’s attention in writing as soon as possible, e.g., if linked material or related processes are found to be defective at another customer.</li> </ol>

<p align="center"><b>Marking/ Identification</b></p>	<ol style="list-style-type: none"> <li>1. Part identity shall be maintained throughout all processing.</li> <li>2. Stamp, tag, or permanently label heat#, grade identification and Patriot Forge Co. PO # on each piece or bundle. Contact Patriot Forge Co. for further clarification if required.</li> <li>3. Material received with incomplete or illegible markings will be returned to the supplier for correction at the supplier's expense.</li> </ol>
<p align="center"><b>Ingot Processing</b></p>	<p><b>Any non-conformance with the following guidelines shall be referred to Patriot for written acceptance prior to shipping:</b></p> <ol style="list-style-type: none"> <li>1. No cold cropping (sawing) without prior Patriot approval</li> <li>2. Conditioning/Grinding/Cropping as detailed on PO</li> <li>3. Surface condition shall be free of defects or holes greater than 3/8" in diameter or depth.</li> <li>4. Spout lengths shall not exceed 6".</li> <li>5. Cropping on hot-cropped ingots shall be uniformly within 20% of square to maximize forging yield.</li> <li>6. Top and bottom on cropped cylindrical ingots shall be marked as follows:</li> </ol> <div style="text-align: center; border: 1px solid black; width: fit-content; margin: 0 auto; padding: 5px;"> <span style="margin-right: 100px;">T</span> <span>B</span> </div>
<p align="center"><b>Billet Processing</b></p>	<p><b>Any non-conformance with the following guidelines shall be referred to Patriot for written acceptance prior to shipping:</b></p> <ol style="list-style-type: none"> <li>1. Billets shall have saw cut or hot cut / cropped ends.</li> <li>2. Surface Conditioning/Grinding as detailed on PO</li> <li>3. Surface condition shall be free of defects.</li> <li>4. Suitable for direct upset.</li> <li>5. Tops and to be marked accordingly.</li> </ol>

<p align="center"><b>Concast / Bloom Processing</b></p>	<p><b>Any non-conformance with the following guidelines shall be referred to Patriot for written acceptance prior to shipping:</b></p> <ol style="list-style-type: none"> <li>1. Concast / blooms shall have saw cut or hot cut / cropped ends.</li> <li>2. Surface Conditioning/Grinding as detailed on PO</li> <li>3. Surface condition shall be free of defects and suitable for direct upset.</li> <li>4. Where processing allows Tops, bottoms and centers shall be marked accordingly.</li> </ol>
<p align="center"><b>Handling/ Processing Restrictions</b></p>	<ol style="list-style-type: none"> <li>1. Contact with mercury, or any mercury device is prohibited.</li> <li>2. No welding or weld repair is permitted without Patriot Forge Co.'s prior written approval.</li> <li>3. Supplier shall be responsible for ensuring that the material is free from radioactive contamination.</li> </ol>
<p align="center"><b>Acceptance and Delivery Commitment</b></p>	<ol style="list-style-type: none"> <li>1. By acknowledging receipt of the Patriot Forge Co. PO (or by shipping the goods or performing the services called for by the PO), the supplier agrees to the terms and conditions of sale contained on the PO. Any additional or different terms or conditions contained in any acknowledgement of the PO by the supplier shall be deemed objected to by Patriot Forge Co. without the need of further notice of objection and shall be of no effect nor in any circumstance binding upon Patriot Forge Co. unless accepted by Patriot Forge Co. in writing. Acceptance or rejection by Patriot Forge Co. of any such additional terms or conditions shall not constitute an acceptance of any additional term or condition on any other PO's.</li> <li>2. Order must be acknowledged via e-mail to the issuer of the PO, using a duplicate of the supplier's acknowledgement document, giving definite shipment date and confirming prices.</li> <li>3. Early deliveries (more than 1 week early) shall not be shipped without written authorization by the issuer of the PO. Patriot Forge Co. shall be notified ASAP of any significant risk of, or certain delay in delivery of the service.</li> </ol>

<p align="center"><b>Required Documents - All Shipments</b></p>	<ol style="list-style-type: none"> <li>1. Every part or package of parts and all related paperwork shall be marked with a minimum of:             <ol style="list-style-type: none"> <li>a. Grade Identification, Heat #, Patriot PO#</li> <li>b. Other information as specifically identified on PO.</li> </ol> </li> </ol>
<p align="center"><b>Freight</b></p>	<ol style="list-style-type: none"> <li>1. All materials must be blocked on 4" x 4" risers on open trailers for overhead crane removal. No Coil Bunks.</li> <li>2. Seller must pay freight both ways on rejected material.</li> <li>3. If no applicable pre-existing freight agreement exists with Patriot, contact Patriot Traffic Department and/or Issuer of Purchase Order prior to acceptance of order.</li> <li>4. Seller accepts responsibility for back charges if material is unable to be unloaded or is rejected due to the above restrictions not being adhered to.</li> </ol>
<p align="center"><b>Canadian Shipments Originating in the USA</b></p>	<ol style="list-style-type: none"> <li>1. Goods being shipped by US suppliers to any Canadian division of Patriot Forge Co. MUST HAVE a Commercial Invoice with Country of Manufacture and Currency</li> <li>2. North American suppliers who have not provided a blanket NAFTA certificate must indicate on packing slip if "goods qualify for NAFTA" and where so, submit a NAFTA certificate with shipment.</li> <li>3. Shipping instructions to Canada – Canadian shipments to be cleared at Canada Customs by WG McKay Customs Brokers.</li> </ol>
<p align="center"><b>Conflict Minerals</b></p>	<ol style="list-style-type: none"> <li>1. Pursuant to section 1502 of the U.S. Dodd-Frank Wall Street Reform and Consumer Protection Act, All suppliers are required to adhere to the provisions of this document and not engage in the direct purchase of "Conflict Minerals" from the Democratic Republic of Congo (DRC). Failure by the supplier to adhere to this legislation will result in them being removed from our approved vendors list.</li> </ol>
<p align="center"><b>REACH and RoHS</b></p>	<ol style="list-style-type: none"> <li>1. Material Manufactured for Patriot Forge Co. is to comply with REACH and RoHS requirements.</li> </ol>
<p align="center"><b>Mandatory Hold Points</b></p>	<ol style="list-style-type: none"> <li>1. When required by the Patriot Forge Co. purchase order, hold points will be included in the supplier's inspection and test plan in order for Patriot Forge Co. or its customers to verify compliance to contract requirements.</li> </ol>



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Rev#	Date	Revisions	Training Required For:
0	3/17/11	New document per CAR	Sales, QA, Materials, Traffic, Material Suppliers
1	02/12/13	Complete revision, change of name and ownership.	All personnel described in Training Section
2	09/30/13	Revised to add the requirements of 7.4.2 as per BC-2	Notification only
3	09/30/14	Changed Approval to J. Lapos.	Notification only
4	01/06/15	Removed section 8 subsection 3. Revisions made to sections 11 and 12. Numerous sections reworded for clarification.	Notification only.
5	01/29/16	Added and REACH and RoHS requirement section.	Notification only.
6	09/30/16	Clarified right of access statement and added section 20- Mandatory hold points.	Notification Only.
7	07/18/2018	Added requirements for AS9100D. Removed Section Numbering.	Notification only.

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