REGAL
MACHINE & ENGINEERING, INC.
5200 E. 60th Street • Maywood, CA 90270
Tel: (323) 773-7462 • Fax: (323) 784-8500

Document
QSS-730

Quality System Specification

Supplier Quality Requirements

1. PURPOSE

To define requirements for quality which are applicable as defined by the supplier type.

2. SCOPE

This specification applies to the following suppliers:

PLATINUM: Suppliers that offer critical products or services such as complex parts or testing.

GOLD: Suppliers that provide unique products or services

SILVER: Suppliers that provide off-the-shelf products or standard services.

3. DEFINITIONS

3.1 **Test Laboratories.** Testing and examining of equipment and materials to determine conformance with appropriate test standards

3.2 **Calibration Services**. Evaluation and adjustment of measuring equipment that has traceability to national or international standards.

3.3 **Distributors.** Providers of standard and DFAR Country approved parts and material.

3.4 **Industrial Services**. Equipment or facility maintenance services

3.5 **Manufacturing Services**. Basic operations with minimal risk in the manufacturing process, such as: material forming, screen printing, laser marking, honing, assembly, or packaging.

3.6 **Outside Essential Processes**, Operations that require customer approval before shipping products to be processed, such as anodizing or heat treatment.

3.7 **Special Processes.** Operations that require NADCAP approval.

4. SPECIFICATION

4.1 Test Laboratories

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	All materials must be identified by a part number and revision, permanently and legibly affixed directly to the surface of each article, In the event this is not possible due to physical size or nature of material, an identification tag must be securely affixed to each article, or If articles are supplied in individual or multi-unit containers the container must reveal the appropriate identification. Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	Performance test reports must contain the signature and title of the person (or traceable inspector stamp) responsible for the tests.
C	The Quality Management System must be in compliance with ISO 9001 requirements.
D	Certification of Conformance must be provided with each shipment with the following information at a minimum: 1. Purchase Order and Line Item Number 2. Identifying nomenclature such as Item Name, Part Number, Revision, Serial Numbers (when applicable) 3. Quantity shipped 4. The Certification of Conformance must be signed by Supplier's duly authorized representative.
E	If a specific test facility was previously approved by RMEI as provided for in the purchase order, the Supplier must not change a test facility or use another test facility to meet specification/drawing requirements without prior RMEI's written approval. Critical Items must be clearly identified in test reports.
F	Supplier and their sub-tier Suppliers must furnish performance test data for tests conducted on, and identifiable to the article(s) submitted (by serial number), when applicable. Data must meet the requirements of RMEI's specifications or Purchase Order and, at a minimum, be identified with : 1. RMEI's Purchase Order Number. 2. Part number 3. Lot numbers, serial numbers, or date codes of items tested. 4. Drawing/specification and revision used 5. Type of tests performed 6 Identification number of test equipment used 7. Total quantity of items tested, quantity of items accepted, and quantity of items rejected.
G	N/A
H	N/A
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.2 Calibration Services

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	All equipment must be identified with a label, permanently and legibly affixed directly to the surface of each equipment or equipment container. The label must indicate Equipment ID Number, Calibration Date and Calibration Due Date. Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	Performance test reports must contain the signature and title of the person (or traceable inspector stamp) responsible for the tests.
C	The Quality Management System must be in compliance with ISO/IEC 17025 requirements.
D	Certification of Conformance must be provided with each shipment with the following information at a minimum: 1. Purchase Order and Line Item Number 2. Identifying nomenclature such as Item Name, Part Number, Revision, Serial Numbers (when applicable) 3. Quantity shipped 4. The Certification of Conformance must be signed by Supplier's duly authorized representative.
E	N/A
F	N/A
G	N/A
H	N/A
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.3 Distributors

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	All materials must be identified by a part number and revision, permanently and legibly affixed directly to the surface of each article, In the event this is not possible due to physical size or nature of material, an identification tag must be securely affixed to each article, or If articles are supplied in individual or multi-unit containers the container must reveal the appropriate identification. Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	N/A
C	N/A
D	Certification of Conformance must be provided with each shipment with the following information at a minimum: 1. Purchase Order and Line Item Number 2. Identifying nomenclature such as Item Name, Part Number, Revision, Serial Numbers (when applicable) 3. Quantity shipped 4. The Certification of Conformance must be signed by Supplier's duly authorized representative.
E	N/A
F	N/A
G	When nonconforming products are detected prior or after delivery, a written corrective action report must be completed addressing the problem definition, containment action, root cause determination, corrective action plan/contingency actions, implementation timing, and system/practice/procedure changes to prevent recurrence. You will be required to submit your corrective action report(s) to RMEI.
H	N/A
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.4 Industrial Services

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	All materials must be identified by a part number and revision, permanently and legibly affixed directly to the surface of each article, In the event this is not possible due to physical size or nature of material, an identification tag must be securely affixed to each article, or If articles are supplied in individual or multi-unit containers the container must reveal the appropriate identification. Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	N/A
C	N/A
D	N/A.
E	N/A
F	N/A
G	N/A
H	N/A
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.5 Manufacturing Services

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	N/A
C	N/A
D	N/A
E	N/A
F	N/A
G	Supplied material will be inspected by RMEI in accordance with PO requirements and nonconforming material due to Supplier processes will be charged accordingly. Wrong material will be replaced at the Supplier's expense. No repair must be allowed outside of the specific specification limits unless prior written approval is obtained by Supplier from RMEI. No rework must be allowed unless prior written approval is obtained by Supplier from RMEI. When nonconforming products are detected prior or after delivery, a written corrective action report must be completed addressing the problem definition, containment action, root cause determination, corrective action plan/contingency actions, implementation timing, and system/practice/procedure changes to prevent recurrence. You will be required to submit your corrective action report(s) to RMEI.
H	Supplier must notify RMEI of changes in product and/or process definition and, where required, obtain RMEI approval.
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.6 Outside Essential Processes

Ref	PURCHASING QUALITY TERMS AND CONDITIONS
A	All materials must be identified by a part number and revision, permanently and legibly affixed directly to the surface of each article, In the event this is not possible due to physical size or nature of material, an identification tag must be securely affixed to each article, or If articles are supplied in individual or multi-unit containers the container must reveal the appropriate identification. Notwithstanding any other provision of this PO, Supplier must not procure any of the completed or substantially completed Items described herein from any other party, by subcontract or otherwise, without the prior written consent of REGAL MACHINE & ENGINEERING, INC. (RMEI hereafter).
B	N/A
C	N/A
D	Certification of Conformance must be provided with each shipment with the following information at a minimum: 1. Purchase Order and Line Item Number 2. Identifying nomenclature such as Item Name, Part Number, Revision, Serial Numbers (when applicable) 3. Quantity shipped 4. The Certification of Conformance must be signed by Supplier's duly authorized representative.
E	Inspection sampling is acceptable for this purchase order as follows: • In accordance with ANSI/ASQC Z1.4 *Sampling Procedures and Tables for Inspection by Attributes*, normal Level II, single sampling. Zero Acceptances. Critical Defect = Results in unsafe conditions for end user or noncompliance with governmental standards or regulations.100% Inspection Major Defect. = Results in noncompliance with customer fit, form or functional specifications 1% AQL Minor Defect. = Results in noncompliance with appearance or cosmetic customer requirements. 2.5% AQL Inspection and acceptance by RMEI of the first article must be required prior to the start of fabrication of a new product unless a waiver has been approved by RMEI. Supplier may request waiver of this requirement based upon: a. Objective evidence of previously approval First Article Report and IAW b, c and d. b. No change in method of manufacturing c. Facility location has not changed d. There has not been an interruption in production of more than 24 months since approval. Supplier must submit a First Article Report to RMEI demonstrating compliance with the requirements in the Purchase Order and referenced documents (refer to AS9102 and ASME Y14.41-2003 for guidance). The report must reflect 100 percent inspection verification of all drawing characteristics. The report must delineate each drawing characteristic and specify the corresponding actual measurement results.
F	N/A
G	Supplied material will be inspected by RMEI in accordance with PO requirements and nonconforming material due to Supplier processes will be charged accordingly. No repair must be allowed outside of the specific specification limits unless prior written approval is obtained by Supplier from RMEI. No rework must be allowed unless prior written approval is obtained by Supplier from RMEI. When nonconforming products are detected prior or after delivery, a written corrective action report must be completed addressing the problem definition, containment action, root cause determination, corrective action plan/contingency actions, implementation timing, and system/practice/procedure changes to prevent recurrence. You will be required to submit your corrective action report(s) to RMEI.
H	Supplier must notify RMEI of changes in product and/or process definition and, where required, obtain RMEI approval.
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

4.7 Special Processes

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B	Performance test reports must contain the signature and title of the person (or traceable inspector stamp) responsible for the tests.
C	The Quality Management System must be in compliance with NADCAP requirements.
D	Certification of Conformance must be provided with each shipment with the following information at a minimum: 1. Purchase Order and Line Item Number 2. Identifying nomenclature such as Item Name, Part Number, Revision, Serial Numbers (when applicable) 3. Quantity shipped 4. The Certification of Conformance must be signed by Supplier's duly authorized representative.
E	Inspection sampling is acceptable for this purchase order as follows: In accordance with ANSI/ASQC Z1.4 *Sampling Procedures and Tables for Inspection by Attributes*, normal Level II, single sampling. Zero Acceptances. Critical Defect = Results in unsafe conditions for end user or noncompliance with governmental standards or regulations.100% Inspection Major Defect. = Results in noncompliance with customer fit, form or functional specifications 1% AQL Minor Defect. = Results in noncompliance with appearance or cosmetic customer requirements. 2.5% AQL
F	Supplier and their sub-tier Suppliers must furnish performance test data for tests conducted on, and identifiable to the article(s) submitted (by serial number), when applicable. Data must meet the requirements of RMEI' specifications or Purchase Order and, at a minimum, be identified with : 1. RMEI' Purchase Order Number. 2. Part number 3. Lot numbers, serial numbers, or date codes of items tested. 4. Drawing/specification and revision used 5. Type of tests performed 6. Identification number of test equipment used 7. Total quantity of items tested, quantity of items accepted, and quantity of items rejected.
G	Supplied material will be inspected by RMEI in accordance with PO requirements and nonconforming material due to Supplier processes will be charged accordingly. No repair must be allowed outside of the specific specification limits unless prior written approval is obtained by Supplier from RMEI. No rework must be allowed unless prior written approval is obtained by Supplier from RMEI. When nonconforming products are detected prior or after delivery, a written corrective action report must be completed addressing the problem definition, containment action, root cause determination, corrective action plan/contingency actions, implementation timing, and system/practice/procedure changes to prevent recurrence. You will be required to submit your corrective action report(s) to RMEI.
H	Supplier must notify RMEI of changes in product and/or process definition and, where required, obtain RMEI approval.
J	RMEI, our customer, our customer's representative, or the government (FAA, DOD, etc.), has the right to audit your quality management system, manufacturing process, and product and/or audit the Supplier and their sub-tier Supplier facilities, if requested.
K	You cannot transfer, export, re-transfer, and re-export, any technical data, hardware or other technical tooling (e.g. documentation, software, drawings and specifications) by any means to any entity without written approval of RMEI as defined and regulated by the U.S. International Traffic in Arms Regulations (ITAR) in 22 CFR Parts 120-130. Additionally, any employee of your company who is a foreign person will not have access to such data and hardware. Please see additional requirements on the Purchase Order.
L	Complete records of all inspection work performed by Supplier must be maintained and made available to RMEI during a minimum of seven (7) years unless otherwise specified by purchase order or customer.

5. APPENDIX

Ref	SYSTEM REQUIREMENTS
A	*Terms of business and any requirements for approval of product, procedures, processes and equipment,*
B	*Requirements for qualification of personnel,*
C	*Quality management system requirements,*
D	*The title or other positive identification, and applicable issues of specifications, drawings, process requirements, inspection instructions and other relevant technical data,*
E	*Requirements for design, test, examination, inspection and related instructions for acceptance by the organization, and as applicable critical items including key characteristics.*
F	*Requirements for test specimens (e.g., production method, number, storage conditions) for design approval, inspection, investigation or auditing,*
G	*Requirements relative to* *- Supplier notification to organization of nonconforming product and* *- arrangements for organization approval of Supplier nonconforming material,*
H	*Requirements for the Supplier to notify the organization of changes in product and/or process definition and, where required, obtain organization approval,*
J	*Right of access by the organization, their customer, and regulatory authorities to all facilities involved in the order and to all applicable records,*
K	*Requirements for the Supplier to flow down to sub-tier Suppliers the applicable requirements in the purchasing documents, including key characteristics where required.*
L	*The documented procedure must define the method for controlling records that are created by and/or retained by Suppliers.*