



ABSOLUTE TECHNOLOGIES, Inc.

Supplier Purchase Order (PO) Clauses

ATIWI 7.4.2-1

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1. SCOPE

The purchase order (PO) clause requirements specified in Section 2 apply to all suppliers. The additional clauses specified in Section 3 apply as shown in the table below.

Supplier or Product/Service Type	Q12	Q13	Q14	Q15	Q16	Q17	Q18	Q19	Q20	Q21	Q22	Q23	Q24	Q25	Q26	Q27
Raw Material ¹²	X	X	X	X		X						X		X		X
Castings & Forgings	X	X	X	X	X	X	X	X						X		X
Raw Material & Case Hardening Testing				X	X	X										X
Deburr ³ & Machining ⁴				X		X	X	X								X
Nonconventional Machining				X	X	X	X	X								X
Special Processing			X	X	X	X		X								X
Hardware/ Distributor				X								X		X		
Calibration									X						X	
Chemicals & Material with Shelf-Life										X						
Maintenance & Service of Machine Tools													X			
Machine Tools											X					
Cutting Tools												X				
Inspection Equipment									X							
Manufactured Complete Components ⁵	X	X	X	X	X	X	X	X				X		X		X


¹ The additional purchase order clauses Q12-Q15, Q25 & Q26 do not apply to raw material purchased for non-production items. Raw material purchased for non-production items is designated by an ATI purchase order number that begins with the letter "T".

² PO clause Q23 does apply to raw material purchased for non-production items.

³ PO clauses Q15, Q18, Q19 & Q27 do not apply to deburr suppliers.

⁴ PO clause Q15 does not apply to suppliers performing rough machining (i.e., not machining final blueprint dimensions).

⁵ For manufacturing complete components, PO clauses Q12-Q27 are required as applicable to the processes being performed.

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2. GENERAL REQUIREMENTS

Q1. Flow Down Requirements – All requirements specified in the Absolute Technologies, Inc. (ATI) Purchase Order Clauses Q1-Q11 and the applicable product-specific clauses shall be flowed down to sub-tier suppliers. If any customer quality requirements are stated on ATI's purchase order, then those shall also be flowed down to sub-tier suppliers.

Q1a. The supplier shall ensure that all persons supporting the purchase order are aware of their contribution to product/service safety and conformance as well as the importance of ethical behavior.

Q1b. Suppliers will be measured based on their delivery (93% minimum) and quality (99% minimum or 10,000 DPPM maximum) performance.

Q2. Right of Entry – The supplier shall ensure on-site right of entry to ATI, ATI's customer(s), the respective governmental and regulatory agencies, third parties mandated by ATI or our customer(s) and contracting parties accompanying the customers' representatives, including access to documented information and the ability to conduct audits, review of quality investigations, and to verify product and processes.

- Right of entry includes access to the applicable areas of the supplier's facilities as well as related sub-tier and business partner facilities.
- Where access is restricted due to export control technical requirements or intellectual property concerns, the supplier shall facilitate allowing ATI, ATI's customer, or the regulatory agency to fulfill their mandate.
- Where required, the organization shall provide language translation services to support such reviews.
- The supplier shall also provide access to relevant data within Online Aerospace Supplier Information System (OASIS) and Nadcap databases (e.g., registration documentation, certification, audit reports and findings, corrective actions) to ATI.



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Q3. Quality System – Suppliers shall be certified by an industry recognized and accredited QMS Certification body for the associated scope(s) of work shown in the table below. The supplier shall control sub-tier procurements to the extent necessary to ensure conformance to the quality requirements of the purchase order. The supplier shall provide ATI Purchasing with current quality system certificates of registration/accreditation and report any change of quality management system (QMS) certification status to ATI Purchasing and/or Supplier Quality Engineering within 48 hours.

Organization Type	QMS Approval (minimum requirement)
Make to Print: Manufacture, inspect, test, and certify the conformance of semi-finished and/or finished products to proprietary engineering drawings.	AS9100 registration or per customer's requirements/approved supplier list (ASL)
Distributor	AS9120 registration
Special Process: As part of an organization's manufacturing scope and/or special process houses.	Nadcap or per customer's requirements/ASL
Raw Material: Manufacture, inspect, test, and certify the conformance of raw material to proprietary engineering specifications.	ISO 9001 registration
Production Shop Assist Only: Offload of planned manufacturing operations.	Per customer's requirements/ASL
External Calibration or Laboratory Service Provider	ISO/IEC 17025 or National Equivalent (e.g., UKAS, COFRAC, NIST)
Industry Standard Part	ISO 9001 registration
Castings and Forgings Produced to Proprietary Design	AS9100 registration or per customer's requirements/ASL

Q4. Notification of Nonconforming Product – The supplier shall immediately notify ATI Purchasing and Quality when it is suspected or known that nonconforming material has been produced or delivered. The notification must include a clear description of the actual or suspected nonconformance.

Q5. Notification of Inability to Ship – The supplier shall notify ATI Purchasing as soon as it has been determined that supplier is not able to ship as specified. If supplier becomes aware of any risks with the supply of substances used in the production or physical makeup of products, due to laws and regulations concerning the control or use of such substances, then they shall notify ATI Purchasing within three working days.



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Q6. Changes in Product, Processes, Suppliers or Manufacturing Location – The supplier shall notify ATI Purchasing or Quality of any changes in product or process definition, suppliers, or location of the manufacturing facility.

Q7. Use of Customer-Approved Special Process Sources – The supplier shall use and direct sub-tier suppliers to use ATI's customer-designated suppliers as instructed in the customer quality requirements flowed down on ATI's purchase order. The supplier shall provide ATI Purchasing with current NADCAP certificates of registration/accreditation (as applicable) and report any change in customer approval(s) and/or NADCAP certification status to ATI Purchasing and/or Supplier Quality Engineering within 48 hours.


Q7a. All Boeing applicable hardware shall be processed in accordance with Boeing's D1-4426. Boeing hardware is defined as items that are on Boeing drawings or any item that is processed to a Boeing-owned specification (e.g., BAC, PS, etc.).

Q8. Packaging & Preservation – The supplier shall protect parts with corrosion preventative oil or suitable alternative between all operations (unless otherwise stated). The supplier shall ensure that packaging and preservation is adequate to prevent damage or deterioration during shipment to ATI. Suppliers shall develop and establish a foreign object damage (FOD) prevention program in accordance with AS9146.

Q9. Records – Supplier shall retain and maintain quality records associated with product shipped to ATI from deterioration for a minimum of ten years unless otherwise specified by purchase order within the customer quality requirements.

Q10. Hazardous Material – The supplier shall furnish applicable Material Safety Data Sheets for products designated by industry, state, or federal agencies as hazardous materials.

Q11. Release of Information – Except as required by law, no public release of any information, confirmation, or denial of the subject matter of this purchase order shall be made without prior written authorization by ATI's or its customer. Access to the information contained in this order shall be provided only to employees or suppliers "with the need to know" (for the performance of this order) and who are under obligation to hold such information in confidence.

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3. ADDITIONAL PRODUCT-SPECIFIC REQUIREMENTS

Q12. OEM's Certificates of Analysis – Mill or product certificates denoting chemical and physical properties to specification listed on purchase order shall accompany each lot/shipment. Certificates shall be provided that show full traceability from original manufacturer to distributor (if applicable) to ATI's purchase order.

Q13. Specialty Metals – For specialty metals identified in DFARS Clause 252.225-7009, material melted inside of the United States, its outlying areas or a qualifying country is preferred and (if required) will be flowed down on the purchase order.

Q14. Segregation of Product – Raw materials must be supplied in single heat lots only. Supplier must obtain approval from ATI Purchasing prior to shipping multiple heat lots. If permission is granted, the material must be shipped in separate, clearly identified containers, bundles, or skids. The supplier shall not mix material of any type. Material of different type, thickness, etc., must be shipped in clearly identified and separate containers, bundles, or skids.

Q14a. Heat Treat Batch Splits – If purchase order line items are split and processed in separate heat treat batches/loads, each batch must have separate certifications, separate containers, and unique identification. Suppliers must notify ATI prior to splitting any lot. Splits shall be made into distinct quantities to prevent mixed lots and maintain full traceability.

Q15. Certificate of Conformance – The supplier shall submit one copy of the Certificate of Conformance and/or processing certification(s) with each shipment.

Q16. Required Test Specimens – The supplier shall provide test coupons or specimens as requested by ATI's purchase order.

Q17. Required Test, Inspections & Related Instructions – The supplier shall perform or obtain tests and/or inspections and provide the resulting data to ATI Purchasing prior to shipment or with shipment of the product, as instructed on ATI's purchase order.

Q17a. Unless otherwise stated, 100%-dimensional inspection is required for suppliers performing hone, jig grind, lapping, superfinish, spline cutting, spline grinding, and thread rolling processes, except analytical inspection of splines and threads is not required to be performed 100%.



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Q17b. For all other suppliers, if sample inspection is performed, it must comply with an industry-recognized, statistically valid sampling plan ($c=0$), where one nonconformance constitutes lot rejection and 100% sorting. Final inspection in accordance with end-user requirements will be performed by ATI. Unless otherwise specified or required, and if no other sampling plan is established, suppliers shall apply Squeglia's *Zero Acceptance Number ($c=0$) Sampling Plan* at AQL 0.65.

Q18. Inspection Reports – A dimensional inspection report is required with shipment when required as stated on the purchase order.

Q19. First Article Inspections – First article inspections must conform to AS9102. When required per AS9102, the first article inspection report is required with shipment. Unless otherwise stated, first article inspection is not required for swaging.


Q20. Calibration Services & Inspection Equipment – Calibration certificate and/or certificate of conformance traceable to NIST is required with shipment.

Q21. Chemicals & Materials with Limited Shelf-Life – Supplier shall submit a Material Safety Data Sheet with the shipment of chemicals. If material has a limited shelf-life, then a Certificate of Conformance with the following information is also required:

- Reference to the ATI purchase order and line-item numbers
- Identifying nomenclature such as item name, part number, revision, and serial numbers
- Batch and/or lot numbers
- Manufacturer's name (if not supplier)
- Quantity shipped
- Date of manufacture
- Date of expiration
- Any special storage conditions for the material

Q22. Machine Tools – Factory inspection/test report is required with delivery and installation of machine tools.

Q23. No Substitutions – No substitutions or use of alternate part numbers or materials are allowed unless otherwise specified on the ATI purchase order.

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Q24. Maintenance & Service of Machine Tools – Maintenance or service report is required with record of work performed.


Q25. Counterfeit Material – Suppliers shall have established a documented process to mitigate the risk of use/supply of fraudulent and counterfeit items. The process shall be established to meet the requirements of AS5553 for electronic items or AS6174 for non-electronic items. For military programs, the applicable Defense Federal Acquisition Regulation Supplement DFARS for government contracts (i.e., DFARS 252.246-7007) shall also be applicable.

Q26. Vision Standards for Calibration – Unless otherwise specified, procedures shall be implemented to ensure that eye examinations, including visual acuity and color vision, as applicable, are administered by a medically qualified/trained person to all individuals performing calibration for measurement & test equipment that require visual acuity.

- Intervals shall not exceed one year.
- Individuals shall be tested in at least one eye, either corrected or uncorrected.
- Color perception testing is required one time only. Individuals shall be capable of adequately distinguishing and differentiating colors used in the calibration activity, as applicable.
- Records shall be retained for each individual.
- Vision tests may be substituted for persons compliant with minimum near vision requirements of Snellen 14/18, (20/30) or Jaeger 2, provided the equivalence is verified and documented by a licensed optometrist or ophthalmologist.

Q27. Vision Standards – The supplier shall:

- Ensure non-NDT personnel engaged in product verification and inspection activities are examined annually. Eyesight acuity requirements being a minimum of Curpax N5, Jaeger 2, or equivalent in at least one eye or when using both eyes together. These non-NDT inspectors shall also be required to pass a one-time color vision perception test as required in the process involved.
- Ensure vision tests are performed by suitably trained and qualified personnel.
- Ensure vision correcting eyewear (e.g., glasses, contact lenses) used by personnel to pass the vision examination are worn when performing product verification/inspection activities.
- Ensure the use of any tinted or darkened lenses or those that darken on exposure to light are prohibited.

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4. DOCUMENT HISTORY

Revision	Date	Description of Change	Process Leader Approval
N/C	12/22/15	New Document	Tim Bergquist
A	5/26/17	Added Q25 & revised footnote 1	A. Tovar
B	6/5/17	Added manufacture complete supplier type, revised Q12, selected Q23 & Q25 for hardware	A. Tovar
C	10/25/17	Added Q1a & changed process owner to Purchasing Manager (was Quality Manager)	N. Prum
D	12/11/17	Removed Q11a (duplicate of Q1a), revised Q13, added Q1b	N. Prum
E	12/19/17	Revised Q13	N. Prum
F	8/6/18	Added Q26	N. Prum
G	10/5/18	Revised Q13	N. Prum
H	6/5/2020	Revised Q1b	N. Prum
I	8/26/2021	Revised Q8	N. Prum
J	12/2/2021	Revised WI title, Q1b, Q3 & Q7	N. Prum
K	5/25/2023	Made editorial changes throughout. Revised para. 1, Q2, Q3, Q5, Q8 & Q26. Added Q27.	N. Prum
L	5/19/2025	Updated process owner. Revised table & foot notes in para. 1; added foot notes 3-5. Revised para. Q1b, Q19 & Q27. Added Q7a & Q17a. Made editorial changes in para. 1, Q18 & Q20.	J. Morgan
M	11/6/2025	Added Q14a for special process (heat treat) suppliers & Q17b (inspection sampling plan)	J. Morgan