

ESP Quality Assurance Clauses		ESP Spares	
		QAF 070104	
Reviewed By: Mike Gray	Approved By: Donny Crow	Revision: K	Date: 10/20/23

Material supplied to fulfill a Purchase Order (PO) with ESP must be in accordance with the quality clauses specified for each line item on the PO.	
CLAUSE	DESCRIPTION
ESP 001	<p>Quality Systems</p> <p>ESP suppliers must have a Quality Management system in place that is equivalent to that described in the ISO 9001 standard. The supplier's quality system may be subject to audit by ESP representatives, or evidence of compliance may be requested.</p>
ESP 002	<p>Documentation Requirements</p> <p>Records of manufacturing and inspection demonstrating objective compliance with contract requirements shall be retained by the Supplier for a minimum period following completion / termination of the order. Records and materials must be identified by lot, batch or serial number, as appropriate. Unless otherwise specified on the PO, the minimum retention period is ten (10) years. The Supplier agrees to supply such records to ESP upon request.</p>
ESP 003	<p>Material Certification</p> <p>Material certificates are required in accordance with the P.O. or drawing and must accompany each shipment. Material certificates must identify the complete specification, properties and chemical composition of the material. Records and materials must be identified by lot, batch or serial number, as appropriate. A Certificate of Conformance may be used in lieu of a material cert only with prior consent from ESP.</p>
ESP 003A	<p>Certificate of conformance</p> <p>Certificate of Conformance is required, in accordance with the P.O. or drawing, and must accompany each shipment.</p>
ESP 004	<p>Shelf Life</p> <p>The Supplier shall clearly identify those items that have a specific shelf life. The date of manufacture and/or expiry date must be visibly marked on the item. Special handling or storage requirements (e.g., storage temperature) shall be clearly marked on the item, or included in accompanying documents.</p>
ESP 005	<p>Certification</p> <p>Suppliers shall provide written certification with each shipment that the parts or services submitted are in conformance to all requirements of the P.O. The Certificate of Conformance shall include ESP's P.O. number, part number and quantity shipped. The certificate must also include the typed or printed name, signature and title of a certifying official with the supplier.</p> <p>When raw stock is used to make a part, the supplier shall obtain a report from their source certifying that the material is as specified by ESP. Records and materials must be identified by lot, batch or serial number, as appropriate. A true copy of this report shall accompany all deliveries to the ESP whenever the material is used in the order.</p>
ESP 006	<p>Inspection & Test Reports</p> <p>Each shipment should include a true copy of the acceptance inspection and test results of the lot(s) or item(s). When quantitative limits are specified, the report shall indicate the actual values obtained. Reports shall include control identity (heat, lot, serial no.) of material or item tested. An authorized representative shall validate the report by either inspection stamp or signature.</p>

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ESP 007	<p>First Article Inspection</p> <p>The supplier is to conduct a first article inspection. This includes a 100% inspection of the article ordered, plus all component parts and subassemblies used on the article. The supplier is to submit a complete report, along with the article it represents, to the attention of ESP QA. The report is to list the characteristics and requirements called out on each drawing, the method used for measuring and testing the characteristics, and the actual results obtained for the article ordered, and each component part and subassembly.</p>
ESP 008	<p>Calibration</p> <p>Measurement and test equipment used to determine conformance to requirements shall be maintained in the best possible condition and periodically calibrated to ensure accuracy. The supplier's calibration system is to be compatible with MIL-STD-45662A or ANSI/NCSS Z-540-1. All calibrations will be accomplished IAW manufacturer's specifications.</p>
ESP 009	<p>Special Process Conformance</p> <p>Special processes used by the supplier and any sub-tier to the supplier shall be approved by ESP, or the supplier shall have a system approved by ESP that controls the process and sub-tier process. ESP reserves the right to approve the use of sub-tier organizations employed by the supplier in performance of the contract. There shall be absolutely no changes in the supplier's process or the use of the sub-tier's process without written authorization from ESP's QA Department. (Examples of a special process include: CoCr Bead Coating, TI Bead Coating, Plasma Spray, Ti NSB Coating, CoCr NSB Coating, plating, soldering, welding, brazing, and heat-treating)</p> <p>Flow Down to Sub-Tier Suppliers</p> <p>If the supplier utilizes a sub-tier supplier for any part of this P.O., the supplier shall flow down all applicable requirements of the P.O., including key characteristics, where required.</p>
ESP 010	<p>Controlled Serialization Required</p> <p>This item requires controlled serialization. Contact Buyer for serial number sequence</p>
ESP 011	<p>Equipment/Materials Packaging-Preservation</p> <p>Unless otherwise specified, the Supplier shall take reasonable precautions to ensure that all material is protected against oxidation, corrosion, contamination, deterioration, damage and/or other elements that may adversely affect the quality and/or application of the material. Machined carbon steel should be coated with rust and oxidation preventive; precision diameters and threads should be protected, etc. The packaging shall be adequate to protect both material and container throughout manufacturing, handling, transit and storage.</p>
ESP 012	<p>Corrective Action Request (SCAR)</p> <p>The Supplier shall respond within the period identified in the SCAR. The response shall identify the cause, action(s) taken for containment and prevention, and the effective point of the corrective action. The SCAR will reference the part number and serial number (or date of affectivity), where appropriate. All responses must be signed by the Supplier's authorized QA Representative.</p>

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ESP 013	<p>Source Inspection and/or ESP QA Approval</p> <p>Is required prior to shipment from the Supplier's facility. Please notify the Buyer a minimum of two (2) weeks in advance of material readiness. If source inspection is to be carried out, please have production samples, manufacturing records, test/inspection records, and material certificates available for review by ESP Quality Assurance representatives</p>
ESP 014	<p>Drawings and Documentation</p> <p>It is the responsibility of the supplier to meet all requirements of the latest issue or revision to the P.O. drawings and other applicable specifications. If needed, prior to fulfilling the P.O., the supplier shall request required drawings and documentation from ESP. The supplier shall not make any change to the design or process without first receiving written approval from ESP.</p> <p>Order of precedence:</p> <ol style="list-style-type: none"> 1. P.O. / Amended P.O. 2. Engineering Requirements 3. Engineering Drawing 4. National Standard Specification
ESP 015	<p>Resubmitted Articles</p> <p>Articles rejected by ESP, and subsequently reworked and resubmitted by the supplier, shall be segregated and identified as "resubmitted" articles. The shipping documents must reference the original rejection documentation number.</p>
ESP 016	<p>Right of Access</p> <p>The supplier shall allow our customer and regulatory authorities the right of access to facilities and records involved in the order.</p>
ESP 017	<p>Facility Relocation/Process Change Notification</p> <p>The supplier will notify and obtain written acknowledgement from ESP of their intentions to alter their facility's location, or an approved process. This would need to be accomplished 6 months prior to a relocation or process change-taking place.</p>

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ESP 018

Dimensional Inspection Report Required

The supplier is to conduct a dimensional inspection using the NORMAL sample plan below unless otherwise specified:

GENERAL INSPECTION LEVEL I (MODIFIED AC/RE=0) (Ref ASQ/ANSI Z1.4-2003)									
QUANTITY SUBMITTED	NORMAL			TIGHTENED			REDUCED		
	SAMPLE	ACC	REJ	SAMPLE	ACC	REJ	SAMPLE	ACC	REJ
2 - 8	2	0	0	3	0	1	2	0	0
9 - 15	2	0	0	3	0	1	2	0	0
16 - 25	2	0	0	5	0	1	2	0	0
26 - 50	5	0	0	13	0	1	3	0	0
51 - 90	5	0	0	13	0	1	3	0	0
91 - 150	8	0	0	13	0	1	8	0	0
151 - 280	13	0	0	13	0	1	5	0	0
281 - 500	20	0	0	20	0	1	8	0	0
501 - 1200	32	0	0	32	0	1	13	0	0
1201	50	0	0	50	0	1	20	0	0

Submit a complete report containing:

- All characteristics and requirements called out on each drawing
- The method used for measuring and testing the characteristics
- The actual results obtained for the characteristic