



Terms and Quality Requirements

Quality Management Seller is required to maintain a Quality Management System (QMS) that conforms to the class definitions listed below.

Class 1 - Full ISO Certification - Seller maintains ISO 9001 certified and registered with an accredited ISO registrar.

Class 2 - Customer Approved / Specified for Special Process - Seller must maintain a QMS approved by the specific customer and must maintain current customer approval for specific special process defined by this PO.

Class 3 - ISO / Mil-I-45208 / Mil-Q-9858 Compliant - Seller must maintain a QMS structured within the guidelines of ISO-9001, Mil-I-45208, Mil-Q-9858, or a generally accepted Industrial Quality Standard. Seller will be considered "Compliant" to one of the noted quality standards, but may not be fully certified by an auditing party.

Class 4 - Fabrication, Company Supplied Material - Seller must be able to perform manufacturing and inspection process that meet the requirements of provided drawings and technical data. Seller must provide inspection reports for the scope of work as defined by PO.

Class 5 - Distributor - Seller must maintain a QMS that provides adequate controls over materials traceability and documentation as defined by Purchase Orders.

Class 6 - Special Process - Seller must be able to perform special processes to supplied parts in accordance with the specifications defined by the PO and provide certified documentation of the conformance to the specification. Seller must maintain a QMS that provides for measurement and testing in accordance with the process specifications. Seller shall maintain current revision levels of process specifications and where appropriate, the revision levels shall be documented upon applicable quality records either provided to Tank Tigers or Seller maintained. Seller must provide inspection reports for the scope of work as defined.

Class 7 - No QMS Required - Used for non-production related materials or services.

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Q-101 Final Acceptance Items furnished under this purchase order will be at Tank Tigers. Tank Tigers shall have the right to use sample inspection methods for acceptance of shipments. If the sample is unacceptable, the Buyer shall have the right to return all or part of the lot for credit or replacement.

Q-102 Non-Conforming Material Seller will notify Tank Tigers of nonconforming product, processes or services. Seller will before shipment obtain authority to ship discrepant material. Tank Tigers will not accept discrepant material shipped without prior approval.



Q-103 Surveillance/Customer Right of Entry Tank Tigers, its customers and regulatory authorities reserve the right to conduct inspection and surveillance of the sellers' procedures, facilities, and products. The right of entry provides the seller, customers, and regulatory agencies to determine and verify the quality, records, and material at any place, including the plant of the subcontractor. Customer verification of product is not to be used as evidence of effective supplier quality control and does not absolve the requirement for conforming product or preclude subsequent rejection by the customer.

Q-104 Manufacturing Inspection and Test Plans The seller shall prepare a manufacturing and inspection test plan showing operational sequence, inspection and test points. The manufacturing and inspection test plan shall include any other pertinent control media for the items to be fabricated per this purchase order. The inspection and test at each control point shall be clearly identified. A legible and reproducible copy of the plan shall be submitted to Tank Tigers quality department before start of production.

Q-105 Inspection Data Sheets Final inspection dimensional data check sheets required for each part number produced. 100% Inspect is required.

Q-106 Tooling Seller must accomplish complete inspection of tools in accordance with the data provided per this purchase order. Certificate of Conformity must accompany tools as directed in the quality requirements.

Q-107 Source Inspection Source inspection may be required as stated on the purchase order. This must be accomplished before shipment of product. Evidence of Tank Tigers source or authorized agent must be shown on all documents when required.

Q-108 Certificate of Conformity (C of C) Certificate of conformity stating all items supplied meet purchase order specification requirements. C of C to include PO number, part number, tool number, serial/lot number, quantity, process performed with revision level and heat/lot number as applicable. Unless specified, all work to be performed to the latest specification revision level. C of C must show signature of authorized official.

Q-109 Standard and Commercial Hardware A reproducible copy of original manufacturer certification must accompany each shipment. Traceability must be original to manufacturer's certification

Q-110 Chemical Test Report A reproducible copy of original manufacturer certification of a chemical test report must accompany each item on purchase order. Test reports must show signature and title of authorized company official. Traceability must be maintained from material to test report.

Q-111 Mechanical Test Report A reproducible copy of original manufacturer certification of a mechanical test report must accompany each item on purchase order. Test reports must show signature and title of authorized company official. Traceability must be maintained from material to test report.

Q-112 Certification of Special Processes A reproducible copy of original manufacturer certification of each process on purchase order. Such as, but not limited to, heat treat, welding, surface preparation and treatment, paint, pressure test, bonding, etc.



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Certification must include applicable specification with revision, signature, and title of authorized company official.

Q-113 Certification of Non-Destructive Testing A reproducible copy of original manufacturer certification of test reports performed per purchase order. Such as, Magnetic Particle, Penetrant, Eddy Current, Ultrasonic, or Radiographic inspection. Certification must include applicable specification with revision, signature, and title of authorized company official.

Q-114 Identification All material to be identified by tagging or rubber stamping in compliance with the end customer's requirements with the following: part number with revision, date of manufacturing, current Tank Tigers purchase order number and quality stamp of approval.

Q-115 Key Characteristics Statistical Process Control is required on the purchase order for key characteristics or process parameters identified by drawing or specification. The seller is responsible for a control plan, appropriate process control charts, and submitting the data with shipment to Tank Tigers.

Q-116 Traceability - Outside Processing Traceability between material and records must be maintained from receipt of material to completion of purchase order requirements. Records must be identified with part number, purchase order number, and date of receipt.

Q-117 Subcontractor Approval – Controlled Processes The subcontractor shall be approved by Tank Tigers. When such approval is required by specification, the seller will assure that their approval is current. Such approval does not grant inspection authority. The subcontractor shall notify Tank Tigers QA immediately when their approval is withheld or if their system or specification is disapproved when performing work for Tank Tigers to that system or specification.

Q-118 Forging and Castings The seller must furnish two (2) test bars produced from the same heat lot material as production. Test bars must be permanently identified as required per specification.

Q-119 Material Verification The seller shall be responsible for periodic material verification. Test results will be available to Tank Tigers as necessary.

Q-120 Counterfeit Parts The seller shall have a counterfeit parts program that meets the requirements of AS9110 and/or AS6174.

Q-121 Control of Work Transfers If the seller intends to transfer work to an approved sub-contractor, Tank Tigers must be notified in writing to include part number of items transferred and delivery schedule.

Q-122 Sampling Unless otherwise stated, all sample inspections require prior approval from the customer and will be per ANSI/ASQC Z1.4, single sample, Level II, at a 1.0% AQL. Accept = 0, Reject = 1.



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Q-123 Proprietary Material The disclosure of proprietary material for any purpose is prohibited without written consent of Tank Tigers.

Q-124 Packaging Unless otherwise required in the specification, drawing, or purchase order, items must be packaged per standard commercial methods to preclude damage during shipment.

Q-125 Domestic Material Raw material must be procured from a source within the USA. Certifications of this material must state the location of raw material source.

Q-126 Time and Temperature / Sensitive Material Shelf life information is required. Seller shall submit a Certificate of Conformance or label the containers with the manufacturer's name, type of material, date of manufacture, and shelf life. All materials received shall have 80% of its original shelf life remaining upon receipt at Tank Tigers unless otherwise stated on the purchase order.

Q-127 Provider / Suppliers The seller shall use customer designated or approved external providers including process sources when stated on the purchase order.

Q-128 Flow Down Requirements The seller will flow down to external providers the applicable requirements and customer requirements.

Q-129 Change Notification. The seller will notify Tank Tigers Quality Assurance of changes to the processes, products, or services, including changes of their external providers or location of manufacture and obtain Tank Tiger approval.

Q-130 Record Retention Seller is required to retain records for a minimum of seven (7) years after completion of contract.

Q-131 Personnel Supplier will ensure personnel associated with the PO are aware of their contribution to product or service conformity, contribution to product safety and the importance of ethical behavior

Q-132 Specific Authority Seller will not have specific authorities such as MRB, unless such stated by the Purchase Order.

Q-133 Documentation Package Seller will deliver all reports, tear down, test results, drawings, certification as required in determination of serviceability with the delivered product. All documentation shall be in English and legible.

Q-134 Product Malfunctions and Defects Seller shall immediately contact Tank Tigers Quality Assurance of discoveries of delivered product malfunctions, defects or unairworthy conditions.

Q-135 Corrective Action (RCCA) Seller is required to submit root cause/corrective action (RCCA) upon request from buyer. RCCA shall include tools used e.g., 5-whys, fishbone, process analysis, etc., to determine RCCA. A five-point corrective action is required.

Q-136 Tooling Seller is required to use, maintain and store tooling per the applicable OEM tooling recommendations.