

## Kamatics Corporation

**OPERATING PROCEDURE****No. 10/2011**

<b>TITLE:</b> SUPPLIER CERTIFICATION REQUIREMENTS	<b>REVISION:</b> E	<b>DATE:</b> 3/9/2022
<b>DESCRIPTION:</b> Kamatics Method of Standardizing Supplier Certification Requirements		
Approval <i>John Martin</i>	Title Director, Quality Assurance	Date 3/30/2022
<b>PREPARED BY:</b> D. McFee		<b>ISSUE DATE:</b> 3/30/2022
<b>OTHER ATTACHMENTS:</b> Exhibit "1" - Sample Cert of Conformance (Form 10/2011-1) Exhibit "2" - Example Cert Traceability to Kamatics PO Exhibit "3" - Reference Examples For Kamatics PO & Print Location Guidelines		

**1.0 SCOPE**

This procedure provides Kamatics and their suppliers with standard documentation criteria requirements for the development and acceptance of certifications.

**2.0 RESPONSIBILITY**

- 2.1 The Director, Quality Assurance and Manager, Supplier Quality Assurance is responsible for establishing and maintaining this procedure.

**3.0 REFERENCES**

- 3.1 Not Applicable.

**4.0 DEFINITIONS**

- 4.1 CERTIFICATION: The documented result of compliance with established criteria as determined by Kamatics Corporation.
- 4.2 PROCESS SUPPLIER: A supplier who performs a series of operations in the making or treatment of a product. Various types of processing operations

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include, but are not limited to are; raw material, metal finishing, heat treatment, coating, welding, NDT, metallurgical testing, etc.

- 4.3 SUBCONTRACT MACHINE SUPPLIER: A supplier that manufactures parts, components or services for Kamatics.
- 4.4 HEAT LOT NUMBER: A number that allows for traceability of materials used in the production of a part or component.

## 5 MINIMUM PROCESS CERTIFICATION REQUIREMENTS

### 5.1 ALL PROCESS AND RAW MATERIAL SUPPLIERS

- Supplier Information (Name, Address, Phone)
- Kamatics Name
- Kamatics Purchase Order
- Kamatics B/P Requirements
- Kamatics Purchase Order Requirements (Specific Instructions in addition to B/P Requirements)
- Kamatics Part Number & Revision (1)
- Quantity of Product
- Component Serial Numbers (when referenced on the Kamatics Purchase Order) (1)
- Supplier Certification Number
- Third Party Process System Accreditations or Approvals (Nadcap, FAA, Repair Station, etc.) – If applicable
- Certification Date
- Certification Authorization Approval (Signature and Title)
- Mercury Free Contamination Statement (If applicable)

(1) Exclusion: Raw Material Suppliers

### 5.2 RAW MATERIAL (ADDITIONAL)

- Product Description (Material Type, Condition, Size, etc.)
- Material Heat Number
- Heat Treat Batch No. (If applicable)
- Applicable Process Specifications
- Quality Test Requirements (NDT, Hardness, Metallurgical, etc.)
- Chemical & Physical Analysis
- Material Country of Origin

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Date: 3/9/2022**5.3 HEAT TREAT (ADDITIONAL)**

- Product Description (Material Type, Condition, Size)
- Material Heat Number
- Heat Treat Batch No.
- Process Specifications
- Quality Test Requirements (Hardness, Metallurgical etc.)
- Hardness Requirements: 100 Percent or Approved Sampling Plan Used, including; Number of Parts, Quantity of Parts Tested & Test Coupons Accepted/Rejected, with their Actual Range of Value

**5.4 NDT (ADDITIONAL)**

- Product Description (Material, Condition, Size)
- Process & Quality Specifications
- Acceptance Criteria
- Certification Authorization Approval (Name, Signature, Stamp No. & Level 2 or 3 Title)

**5.5 PROCESS (CHEMICAL, COATING, WELDING, ETC.) - ADDITIONAL**

- Process Specification
- Specific Quality Test Requirements

**5.6 TESTING (METALLURGICAL – CHEMICAL/PHYSICAL, ETC.) - ADDITIONAL**

- Product/Sample Description (Material Type, Condition, Size)
- Material Heat Number
- Heat Treat Batch No. (If applicable)
- Test Description
- Specifications
- Test Parameters (If applicable)
- Test Results

**5.7 SUBCONTRACT MACHINE SUPPLIERS**

- 5.7.1 A Certificate of Conformance is required with each shipment; indicating all material and process sources, and identity to specific certifications, heat numbers, and test reports (Example: Sample Certificate of Conformance – [Form 10/2011-1](#)).

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5.7.1.1 Instances in which a supplier is responsible for obtaining and using material for manufacture will require that either the packaging list OR the distributor certificate of compliance be included in the cert package. All documents included in the cert package must maintain traceability back to the mill which provided the material A heat lot number must be included on all documents to ensure traceability of the material from the mill, to the distributor and supplier. If any documents are missing or fail to include the correct heat lot number , WI-10/1010-1 shall be followed to create a certification correction request. See Exhibit 2 for reference.

5.7.2 All certifications and test reports must be submitted with the initial shipment of parts. Subsequent shipments of the same material and process identity need only include a fully completed certificate of conformance referencing prior packing list, which the original certifications were submitted under.

5.7.3 Subcontract machine suppliers contracted by Kamatics to provide additional product process operations, as specified in section 4.2, shall assure sub-tier flow-down of Kamatics certification requirements in accordance with this procedure and the following exceptions of section 5.1:

- Kamatics Name
- Kamatics Purchase Order

## 5.8 EXAMPLES

5.8.1 Reference Exhibit “1” for example of Cert of Conformance (Form 10/2011-1)

5.8.2 Reference Exhibit “2” for examples of Kamatics Purchase Order and Print Location Guidelines.

5.8.3 Reference Exhibit “3” for examples of Cert Traceability to Kamatics PO

## 6.0 LIMITATIONS

### 6.1 Not Applicable



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FOR REFERENCE ONLY  
EXHIBIT “1” – Sample Cert of Conformance (Form 10/2011-1)

Kamatics Corporation

KAMAN

SAMPLE CERT OF CONFORMANCE

SUPPLIER NAME & ADDRESS

KAMATICS P.O. NO. \_\_\_\_\_ ITEM NO. \_\_\_\_ SUPPLIER INVOICE NO. \_\_\_\_\_

KAMATICS P/N \_\_\_\_\_ REV. \_\_\_\_ DATE OF SHIPMENT \_\_/\_\_/\_\_

SUPPLIER JOB NO. \_\_\_\_\_ QTY. \_\_\_\_\_

MATERIAL & PROCESS CERTIFICATION

[SUPPLIER] CERTIFIES THAT THE PARTS NOTED ABOVE HAVE BEEN PROCESSED  
AND ACCEPTED IN ACCORDANCE WITH ALL BLUEPRINT & SPECIFICATION  
REQUIREMENTS AS FOLLOWS:

RAW MATERIAL:

KSM (KAMATICS SUPPLIED): KAMATICS SHIPPING ORDER NO. \_\_\_\_\_

VSM (VENDOR SUPPLIED):

RAW MATERIAL SOURCE: \_\_\_\_\_

RAW MATERIAL HEAT NO: \_\_\_\_\_

MATERIAL CERTIFICATION ATTACHED Y / N ; IF NO – PREVIOUSLY SUBMITTED?  
DATE \_\_/\_\_/\_\_ P/S# \_\_\_\_\_

HEAT TREATMENT:

HEAT TREAT SOURCE: \_\_\_\_\_

HEAT TREAT CERT NO: \_\_\_\_\_

HEAT TREAT CERTIFICATION ATTACHED Y / N; IF NO – PREVIOUSLY SUBMITTED?  
DATE \_\_/\_\_/\_\_ P/S# \_\_\_\_\_

ADDITIONAL PROCESSES:

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

QUALITY ASSURANCE

Form 10/2011-1 Rev. 10/08



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FOR REFERENCE ONLY

EXHIBIT “3” – Reference Examples For Kamatics PO & Print Location Guidelines

Sample PO / Print Explanation

*(To show where information required on certifications can be found)*

<u>All Suppliers:</u>	<u>Process (Chem, Coat, Weld, etc) Additional</u>
A) Supplier name, address, phone	O) Process Specification and quality requirements
B) Kamatics name	
C) Kamatics Purchase Order	
D) Kamatics blue print requirements	
E) Kamatics PO requirements	
F) Kamatics Part Number and revision	
G) Quantity of product	
H) Serial numbers when referenced	
	<u>Testing (Metallurgical- chem /physical)</u>
	<u>Additional:</u>
	P) Product description (material type, condition, size)
	Q) Material heat number
	R) Heat treat batch number, if applicable
	S) Test description
	T) Specifications
	U) Test parameters, if applicable
<u>Heat Treat Additional:</u>	
I) Material Heat Number	
J) Product description (material type, condition, size)	
K) Process Specifications & quality requirements	
L) Acceptance criteria	
<u>NDT Additional:</u>	
M) Product description (material type, condition, size)	
N) Process Specifications & Acceptance Criteria	

Ref: Operating Procedure:  
No. 10/2011



Kamatics Corporation

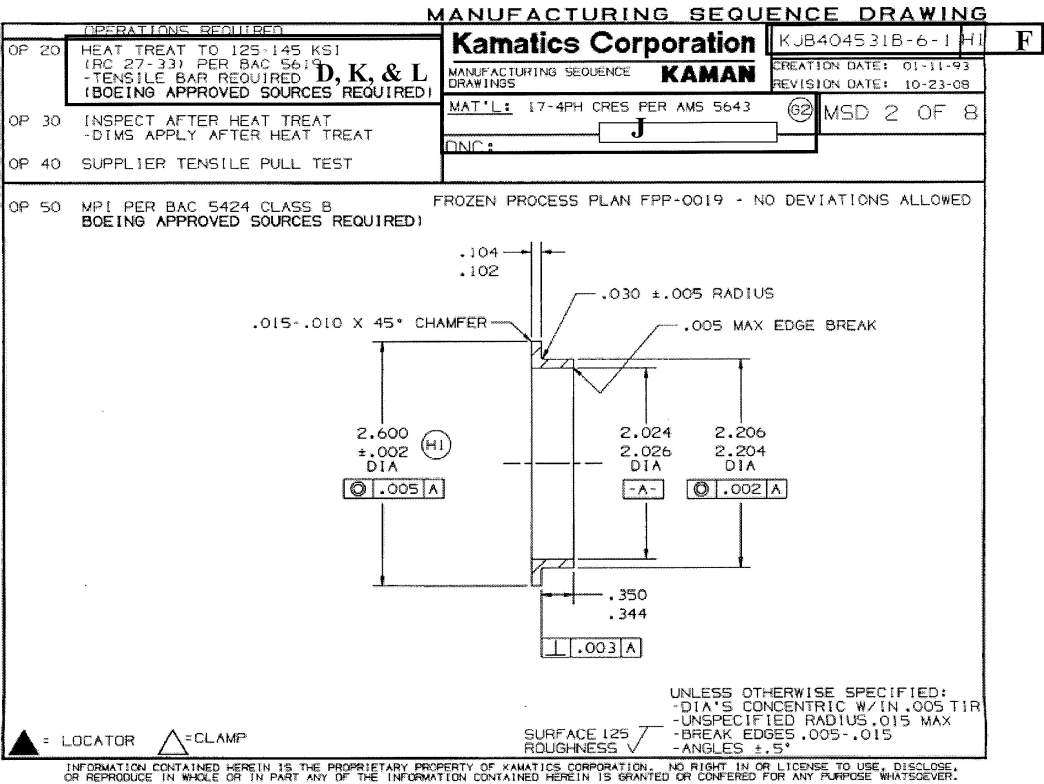
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EXHIBIT “3” Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – Heat Treat Print (Parts)

Heat Treat Print (Parts)



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EXHIBIT "3" Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – Heat Treat PO (Bar Stock)

Heat Treat PO (Bar Stock)

C

Kamatics Corporation

Purchase Order: 46765

Rev. 1

Print Date: 11/25/08

Supplier

Joe Smith's Heat Treating

Supplier ID:1234

911 Main Street

Boston, CT 06911

A

Buyer

Morgan Fazel

Phone: 860-243-7181

Fax: 860-502-6451

E-mail: morgan.fazel@kaman.com

Delivery Address

Kamatics Corp

1330 Blue Hills Ave

Bloomfield, CT 06002

B

26 bars total

Line	Ref	Part No.	Qty	Unit	Price	Additional Cost	Line Value	Due at Kamatics	Gov
1	1	RB 3973	1,151.00	IN	\$0.0000	\$217.25	\$217.25	12	
15-6,180-200 KSI, BAC5619, 1.125D									

SHERRY PO 46947-1-1

Additional Part Info

HEAT TREAT TO 180-200 KSI COND PER BAG 5519

(BOEING APPROVED SOURCE REQ'D)

100% HARDNESS CHECK TO BE PERFORMED AT HEAT TREAT FACILITY

(REF: Ro 40-43)

CERT PER PO REQUIREMENTS

APPROX WEIGHT PER INCH = 280 LBS

\*\*\* KAMATICS TO CUT TEN SILE BAR AFTER HEAT TREAT \*\*\*

E, K, & L

Kamatics Address

Kamatics Corporation

1330 Blue Hills Ave

Bloomfield, CT 06002

860-243-9784

B

Barcode

Kamatics Supplied Material

RB1081-15-6, A, TYPE 1 OR 2, AMS5909, 1.125D

1,151 IN - PO#26621-6-11 ; G14101

Total Supplied Material: 1,151.00 IN

I & J

Raw Material PO #

Heat Lot #

Delivery Terms: Freight On Board Bloomfield

Ship Via: UPS Ground

Pay Terms: Net 30 Days

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Must Verify &  
Communicate  
Price Changes  
Prior to  
Returning  
Job!!!



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FOR REFERENCE ONLY  
EXHIBIT “3” Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – NDT PO

NDT PO

C

Kamatics Corporation

Purchase Order: 45019

Rev. 1

Print Date: 1/25/08

Supplier

Joe Smith's NDT

Supplier ID: 1234

911 Main Street

Boston, CT 06911

A

Buyer

Kathy Benton

Phone: 860-243-7181

Fax: 860-502-6451

morgan.fiszek@kamatic.com

Delivery Address

Kamatics Corp

1330 Blue Hills Ave

Bloomfield, CT 06002

B

Line	Ref	Part No	Qty	Unit	Price	Additional	Line	Due at	Gov
No.	No.	Description & Supplier P/N	Meas			Cost	Value	Kamatics	Com
1		NDT Res G KJ 89 0002 4V-02-6-3	90 EA		Shop Order 100510 \$0.9500	\$0.00	\$85.50	10/24/08	C
Customer: Tusas Motor Sanayii A.S. (TEI) Program Code: LM2000									

Per Item Inspected Per B/P (MBD BNT 5 of 5)  
Cert Per B/P  
Mat: 17-4

\*\*\* O.E. Approved Source Required \*\*\*  
(Aerospace Testing Lab)

E & H

Line Value Sub Total: \$85.50

Additional Charges: \$ 0.00

Total Order Value: \$85.50

Kamatics Corporation Rev. 3/2008 Purchase Order Conditions apply to this purchase order.

Buyer Authorized Rep.

Kamatics Address

Kamatics Corporation

1330 Blue Hills Ave

Bloomfield, CT 06002

860-243-9704

B

Delivery Terms: Freight On Board Bloomfield

Ship Via: UPS Ground

Pay Terms: Net 30 Days

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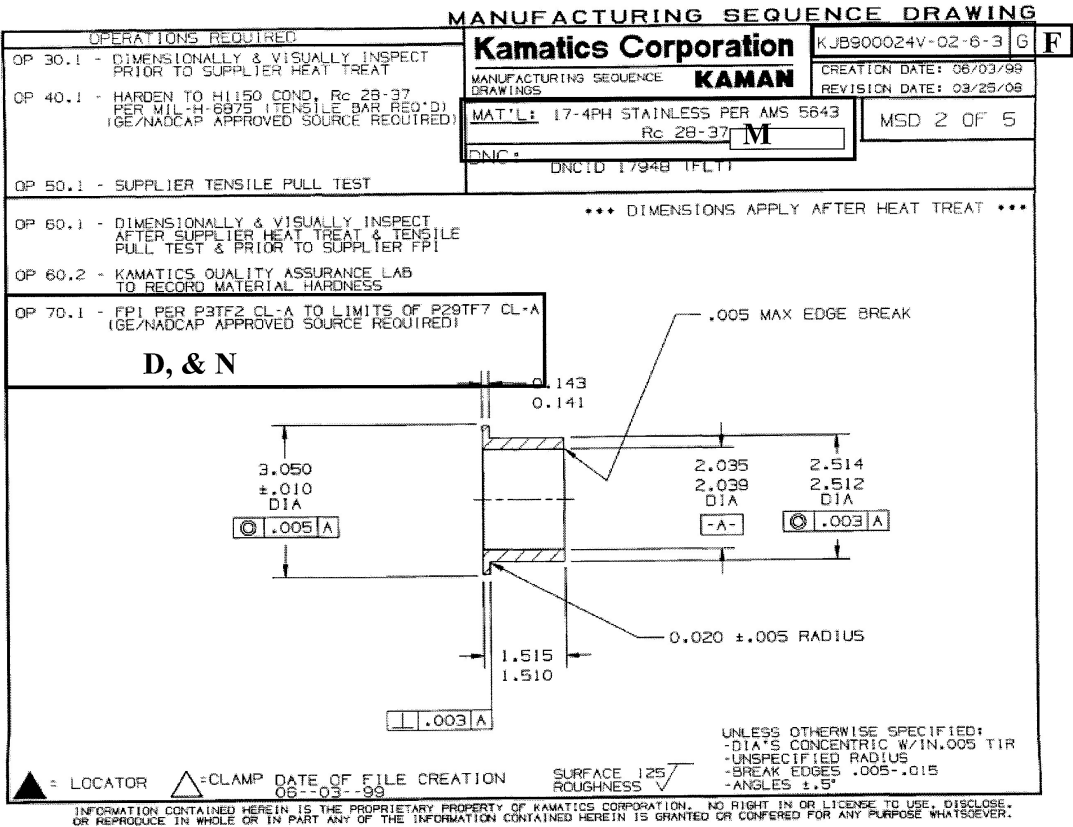
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EXHIBIT “3” Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – NDT Print

NDT Print







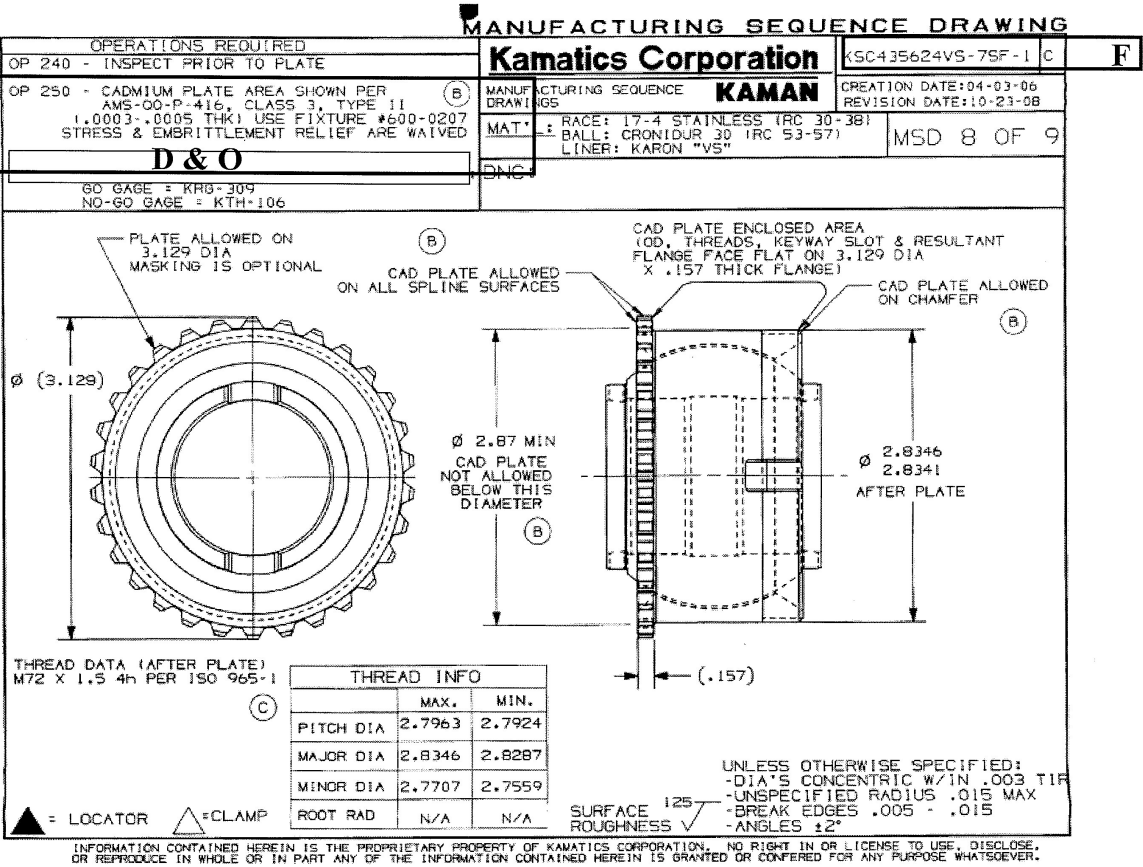
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EXHIBIT “3” Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – Plate Print

Plate Print



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EXHIBIT “3” Continued – Reference Examples For Kamatics PO & Print  
Location Guidelines – Testing PO

Testing PO

C

Kamatics Corporation		Purchase Order: 46598		Rev. 1	Print Date: 11/25/08			
Supplier Joe Smith's Testing Lab Supplier ID: 1234 711 Main Street Boston, CT 06911		Buyer Carolyn Jackson Phone 800-243-7181 Fax 800-502-6451 morgan.fizek@kamat.com		Delivery Address Kamatics Corp 1330 Blue Hills Ave Bloomfield, CT 06002				
Line No.	Ref. No.	Part No.	Qty.	Unit Price	Additional Cost	Line Value	Due at	Conf.
1	1	Acidine Ref. Form Testing	5	\$0.0000	\$203.00	\$203.00	11/24/08	
		F (when available)	G	EA				
<p>Corrosion resistance testing per ASTM-B-117. Ref: MIL-87L-5541F monthly testing. Note: Processing panels using a 6 degree rack. All test reports must state that you are process panels using a 6 degree rack. Please contact George Stehr at (860) 769-3230, if any corrosion is found before. S&amp;O P O R D E R N O . ( M O N T H O F N O V E M B E R ) PLEASE RETURN YELLOW CASE *IMMEDIATE RETURN AFTER TESTING*</p> <div>E, H, P, Q, R, S, T &amp; U</div>								
Kamatics Corporation Rev. 3/2008 Purchase Order Conditions apply to this purchase order.						Line Value Sub Total	\$203.00	
						Additional Charges:	\$ 0.00	
						Total Order Value:	\$203.00	
Authorized Rep.								
Kamatics Address Kamatics Corporation 1330 Blue Hills Ave Bloomfield, CT 06002 800-243-9704						Delivery Terms: Freight On Board Bloomfield Ship Via: FedEx (First Overnight) Pay Terms: Net 30 Days		

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