

**SUPPLIER REQUIREMENTS**

The Supplier Requirements contained herein are an integral part of the CRANE Purchase Order when incorporated by reference and shall be in addition to and not in derogation of Purchase Order requirements. Compliance with these requirements does not relieve the supplier of his responsibility for furnishing material and services to CRANE Instrumentation Technologies (dba Hoke Inc.). Acceptance of and payment for material and services will be withheld pending receipt of all required acceptable data and/or documentation.

**CLAUSE 1 GOVERNMENT SOURCE INSPECTION**

Government Source Inspection is required prior to shipment from your plant. Upon receipt of this order, promptly notify the Government Representative who normally services your plant so that appropriate planning for Government Inspection can be accomplished. FAR Clause 52.246.2 applies.

**Clause 1a GOVERNMENT REVIEW OF PERFORMANCE**

During performance of this order, the Supplier's Quality Control Inspection System and Manufacturing processes are subject to review, verification and analysis by authorized Government Representatives. Government Inspection or release of material/product prior to shipment is not required unless the Supplier is notified otherwise. The Supplier shall provide a copy of the Purchase Order to the Government Representative upon their request.

**CLAUSE 2 QUALITY PROGRAM AND INSPECTION REQUIREMENTS**

2a	NCA 3800 *, Section III (ref 24, 26)	2i	AD MERKBLATT WO/TRD-100 (optional)
2b	MIL-I-45208A	2j	EN 10088-1, As Applicable
2c	ISO-9001 Current Rev.	2k	Copper Nickel (Monel) MIL-E-21562
2d	10CFR Part 21, latest edition	2l	SS316L/316L-MIL-E-19933
2e	10CFR Part 50, Appendix B, latest edition	2m	PED [97/23/EC] Annex I – 4.3
2f	ANSI 45.2, latest edition	2n	DFARS 252.225.7001 and 225.872-1
2g	MIL-STD-45662/ISO-10012, latest edition		

(\*) Note: When clause 2a is invoked, the material manufacturer shall certify the material to the applicable ASME Boiler & Pressure Vessel Code; Section II; Part A, B or C material specification.

**CLAUSE 3 CERTIFICATION**

All certifications must include the following as a minimum:

1. Identify the company submitting the certification to include full address.
2. Identify the CRANE PO No., Item No., CRANE Part Number, and Quantity in that particular shipment.
3. The date certification is issued.
4. Signature or initials of a duly authorized company representative identifying the person by name and title within the company.
5. In the event that revision is made to any certification, the revision must be noted in a conspicuous place and dated.
6. Other requirements may be as specified by Purchase Order.

**NOTE 1: At least one (1) copy of certification must be submitted with shipment.**

**NOTE 2: All invoked procedures, specifications and standards shall be to latest revision or issue level unless otherwise specified.**

**Clause 3a** Certificate of Compliance shall accompany each shipment and include a statement that all Purchase Order requirements have been met. The Certification may also reference compliance with the applicable specification and drawing revision level, and that supporting data and material certification

are available upon request. When clause 24 or 26 is invoked, the Certification shall state compliance with the supplier's Quality Manual Revision and Date as approved by CRANE.

- Clause 3b** The original mill Certification of Raw Material must accompany each shipment and denote the actual chemical and physical test results for each lot, mill heat number supplied, and country of origin. The certification must reference an **applicable material specification and revision level** when stated in the Purchase Order. NOTE: Mechanical testing is not required for **commercial** brass.
- Clause 3c** Certification that material conforms to specification requirements and includes cure date for all rubber, synthetic or natural.
- Clause 3e** Certifications for Special Processes (heat treating, nondestructive testing, finishes, etc.) must be submitted with shipment. This is in addition to any other required certification.
- Clause 3f** Certification to be in accordance with EN10204/3.1b.
- Clause 3j** Certification to be in accordance with EN10204/2.2.
- Clause 3k** SS316 Material to be 0.03% Carbon MAX.
- Clause 3l** Material to be in compliance with EN 10088-1.1
- Clause 3m** For commercial brass material the original mill material test report or an independent material test analysis certificate shall be provided with the shipment of material. This test certificate shall report the chemical and physical actual test results, or the chemical lot average test results only for the heat or lot of material provided, certify the material to meet the applicable material specification, indicate the company that performed the test, and be signed and titled by a duly authorized company representative

**CLAUSE 4** **TEST/INSPECTION DATA**

- Clause 4a** Inspection and/or test data with actual readings for all quantitative measurements must accompany each shipment and be identified by part and serial numbers as required.
- Clause 4b** Inspection and/or test data required by Para. 4a shall be submitted to CRANE for approval prior to release for shipment.

**CLAUSE 5** **CRANE SOURCE INSPECTION**

CRANE Source Inspection/Test is required prior to shipment from your plant. Notify the CRANE Purchasing Department 72 hours in advance when material is ready. Prime Contractor personnel shall have the option to accompany CRANE personnel.

**CLAUSE 6** **FIRST ARTICLE INSPECTION**

CRANE First Article Inspection/Test is required prior to shipment from your plant. Notify CRANE Purchasing Department 72 hours in advance when material is ready. Prime Contractor personnel shall have the option to accompany CRANE personnel.

**CLAUSE 7** **TEST ANALYSIS SPECIMEN**

The supplier shall submit one test specimen of material used in the manufacture of parts or per heat lot of material used for chemical / physical testing as specified by CRANE.

- Clause 7a** Non-TÜV approved suppliers of Stainless Steel or Brass Forgings shall be required to submit a

**(Optional)** pre-forged and a 1/4 stamp coupon with each heat lot of material for physical testing and verification, to meet AD-MERKBLATT WO Requirements, when this clause is specified as applicable on the Purchase Order.

**CLAUSE 8 FORGING REQUIREMENTS**

Certifications for material and nondestructive test reports must accompany each shipment of forgings and original mill material certification and must contain the following as a minimum:

**REQUIRED DATA:**

- |  |   |
|--|---|
| 1. One (1) Chemical Analysis (Mill)    | *4. Precipitated Carbide Statement (Microstructure)   |
| 2. Two (2) Physical Analyses (Forging) | *5. Hot Forged and Water Quenched Statement           |
| *3. Macrostructure of Forgings         | 6. Carbon levels not exceeding 0.03% (316SST/304SST). |

**\* NOT REQUIRED FOR ANY FORGED PRODUCTS PREVIOUSLY APPROVED**

**NOTE: Items 1-5 are required for first time product submissions. All succeeding procurements shall contain items 1, 2 & 6.**

**NOTE: For brass forgings, only one (1) physical test is required. Testing is only necessary if required by CRANE Purchase Order.**

**CLAUSE 9 MACHINED PARTS**

Parts covered by this Purchase Order must be free of burrs, ragged edges and contaminants when viewed under 10X magnification and be in conformance with CRANE workmanship standards.

**CLAUSE 10 QUALITY PLAN**

**(Optional)** The supplier shall submit to CRANE a Quality Plan for approval prior to the start of manufacturing. The plan shall identify the Inspection Operations and controls from procurement through shipment and should reference applicable supplier operations.

**CLAUSE 11 GOVERNMENT PROPERTY**

All Government Property received and used in the performance of CRANE Purchase Order requirements shall be processed, controlled, and maintained in accordance with Appendix B of the FAR.

**CLAUSE 12 TRACEABILITY**

Parts and assemblies manufactured must be traceable to material, special process certification and Inspection/Test data throughout the entire manufacturing cycle. In the event that an operation removes traceability markings refer to the drawing for re-marking instructions. If the drawing does not provide re-marking instructions contact CRANE for further instructions.

**CLAUSE 13 RECORDS**

Records of inspection, test and other Quality Assurance activities shall be retained for a minimum of 7 years and be filed in a manner that will allow access within 24 hours.

**CLAUSE 14 PROCESSING OF NON-CONFORMITIES**

The supplier does not have the authority to perform Material Review on any supplies that do not conform to contract requirements. Non-conforming supplies must be reported to CRANE Purchasing. Under no circumstances shall supplies be shipped without prior disposition from CRANE Quality Assurance.

**CLAUSE 15 CRANE FURNISHED MATERIAL**

The supplier shall visually inspect CRANE furnished material for accountability and damage from shipment and notify the buyer immediately of any non-conformance. The supplier shall certify on the Certification of Compliance as follows:

**"The material used for this order is the material furnished by CRANE and no unauthorized substitutions have been made."**

**CLAUSE 16 FURNISHED GAGES, INSTRUMENTS, AND/OR SPECIAL TOOLING**

It is the supplier's responsibility for the accountability and safe keeping of all CRANE furnished gages, instruments, and tooling, while in their possession.

**CLAUSE 17 FRAUD OR FALSIFICATION**

This Purchase Order and activities hereunder are within the jurisdiction of the Department of Energy and/or the Department of the Navy. Any knowing and willful act to falsify, conceal or alter a material fact, or any false, fraudulent or fictitious statement or representation in connection with the performance of work under this order may be punishable in accordance with applicable Federal Statutes.

The seller agrees that all employees engaged in the performance of this Purchase Order shall be, if they have not been previously, informed in writing prior to their commencing performance of work under this order that there is a risk of Federal criminal penalties associated with any falsification, concealment or misrepresentation in connection with the performance of work under this order.

**CLAUSE 18 SUBCONTRACTING**

No subcontracting is permitted on this order without prior notification and approval by change order from CRANE.

**CLAUSE 19 RIGHTS OF ACCESS**

For the purpose of inspection and/or expediting, the seller shall give the purchaser free access to his facilities. Purchaser reserves the right to be accompanied by the representative of any regulatory, government or licensing body, and further reserves the right to witness, verify and audit all phases of the design, inspection, manufacturing, testing, and documentation process as necessary to ensure compliance with purchase documents.

**CLAUSE 20 MERCURY FREE or RoHS STATEMENT**

Certifications must include a "Mercury Free or RoHS Statement". When clause 2a or 2b is invoked, a Mercury Free or RoHS certification must be provided from each organization that received the material.

**CLAUSE 21 REPAIR WELDING**

No welding or repair welding shall be performed without CRANE's prior approval.

**CLAUSE 22 MANUAL CHANGES**

Suppliers that are NCA-3800 qualified by CRANE shall report Quality Manual Program changes to CRANE Quality Assurance for acceptance and approval prior to implementation.

**CLAUSE 23 MATERIAL SPECIFICATION, HMS-1**

CRANE Material Specification, HMS-1, current revision, attached or currently in suppliers' possession, shall remain valid until revoked, canceled, or withdrawn by CRANE.

**CLAUSE 24 QUALITY MANUAL PROGRAM STATEMENT – SCHMOLZ + BICKENBACH USA INC., GREER, SC**

Schmolz + Bickenbach USA, Inc. shall provide Certification of Compliance (CoC) for the material supplied against this order identifying the CRANE PO number and the manufacturer's Mill Heat number stating "The material supplied against this order complies with all CRANE Purchase Order requirements and is supplied in accordance with Schmolz + Bickenbach USA, Inc. Quality Manual Revision 8, Dated 11/2/11 as approved to NCA-3800 by CRANE." or previous Quality Manual Revision and Date approved by CRANE.

- Hexagonal Material shall be manufactured by UGITECH Italia S. r. l., Schmolz + Bickenbach with Material Certification (CMTR) to the above-mentioned Quality Manual and with attached Material Certification (CMTR) from UGITECH Groupe, Schmolz + Bickenbach to the above-mentioned Quality Manual.
- Round Material shall be manufactured by UGITECH Groupe, Schmolz + Bickenbach with Material Certification (CMTR) to the above-mentioned Quality Manual.
- Material shall only be supplied from Schmolz + Bickenbach USA, Inc., Greer, SC Distribution Center approved by CRANE.

Any revision made to the identified and approved Quality Manual Programs above shall be submitted to the Quality Manager, CRANE or designee for review and approval to NCA-3800 Code requirements prior to implementation (ref clause 22).

**CLAUSE 25 MATERIAL CERTIFICATION TO ELECTRIC BOAT SPECIFICATION EB2P756 – SPECIFICATION EFFECTIVITY INDEX**

The material supplied for this order shall be certified to the latest approved material specification revision as listed in Electric Boat Specification EB2P756. The material supplier shall log onto the Electric Boat website ([www.gdeb.com](http://www.gdeb.com)), click on Suppliers, Supplier Order Info., then find and click on the latest update of EB2P756 Spec Effectivity Index. Read the text instruction that is shown at the beginning of the specification under items A) and C).

**The material certification for the order shall be certified by the material manufacturer to the latest listed revision of the material specification with two exceptions:**

1. When the latest approved revision and all earlier listed revisions back to the revision to which the material is certified are listed with an interchangeability code of "\*" (asterisk), then the material specification revision to which the material is certified shall be acceptable. (con't)
2. When a specification is not listed, then the material shall be certified to any issued revision of the material specification.

**CLAUSE 26 QUALITY MANUAL PROGRAM STATEMENT – WYMAN GORDON FORGINGS INC.**

Wyman Gordon Forgings Inc. shall provide Certification of Compliance (CoC) for the material supplied against this order identifying the CRANE PO number, Mill Heat number and Wyman Gordon Heat number stating that the material supplied against this order complies with all CRANE Purchase Order and Drawing requirements and is supplied in accordance with Wyman Gordon Quality Manual Revision I, Dated February 06, 2013 (or previous Quality Manual Revision and Date approved by CRANE). Material and subcontracted services shall only be supplied from Wyman Gordon NCA-3800 qualified and approved suppliers or those that are qualified by the ASME.

Any revision made to the approved Quality Manual Revision and Date shall be submitted to the Quality Manager, CRANE or designee for review and approval to NCA-3800 Code requirements prior to implementation (ref clause 22).

**CLAUSE 27 Requirement to Inform Employees of Whistleblower Rights.**

252.203-7002 Requirement to Inform Employees of Whistleblower Rights.

As prescribed in 203.970, use the following clause:

Requirement To Inform Employees of Whistleblower Rights (SEP 2013)

(a) The Contractor shall inform its employees in writing, in the predominant native language of the workforce, of contractor employee whistleblower rights and protections under [10 U.S.C. 2409](#), as described in subpart 203.9 of the Defense Federal Acquisition Regulation Supplement.

(b) The Contractor shall include the substance of this clause, including this paragraph (b), in all subcontracts.

**CLAUSE 28 Level 1 Requirements**

- Material handling and segregation,
- Positive Marking per MIL-STD-792,
- Traceability maintenance,
- Receipt inspection sampling plan,
- Verification of documentation (OQE),
- Adequate record retention,
- On-going supplier monitoring and maintenance,
- Internal audits.

**CLAUSE 29 Foreign Object or Debris (FOD)**

Product to be free of any foreign objects or debris.

**FOOT NOTES:**

<sup>1</sup>- Not Applicable on Market Spot Buys of Raw Material

**APPROVED BY:**

Bruce Crabtree  
Quality Manager

**DATE:**