



| REVISION HISTORY |             |               |                             |
|------------------|-------------|---------------|-----------------------------|
| <u>REV</u>       | <u>DATE</u> | <u>ORIGIN</u> | <u>REASON FOR CHANGE(S)</u> |
| A                | 12Feb18     | Paul Gettins  | New                         |
| B                | 5/04/18     | Daniel Crouse | Added PCN language          |

**Q-CODE Q44F QUALITY REQUIREMENTS**  
**MATERIAL/PRESSURE TEST/LEAK TEST/QCT**

With acceptance of/or receipt of product against this order the supplier agrees to allow Plexus, their customer and regulatory authorities the right of access to their facility and all applicable records. The following are the quality requirements for product purchased under Q-code Q44F. Unless a written waiver is received from Plexus, the supplier agrees to abide by the quality requirements listed below. Plexus will only give a written waiver after notifying and obtaining approval from the customer authorized person and Certified Body.

**Pre-1st Shipment** (Part Number or Revision change) - Before a product will be released for production the supplier will be required to meet the documentation and quality requirements as follows:

- A. First Article Inspection Report - All dimensions must be within print tolerance. Any dimension which is not within print specification must be approved by Plexus in writing before product can be shipped.
- B. Manufacturing Procedure Specification
- C. Manufacturing Record/Data Book
- D. Quality Control/Inspection and Test Plan
- E. Supplier Master Document List (SMDL)
- F. Material Traceability List/Location Plan
- G. Material 'Mill' Test Report/Certificate  
EN10204 Type 3.1 Material Inspection Certification must detail the following:
  - Name of Material Supplier
  - Material Suppliers part number
  - Details of the Test/Inspection Results
  - The Lot # and Date Code or Serial numbers for each shipment
  - A statement of Compliance to specification
  - Signed and dated by an authorised inspection representative independent of the manufacturing department.
- H. Pressure Testing/Examination
  - Chart Record/Read Out (Pressure/Leak/Gas/Hyperbaric Test)
  - Pressure Test Certificate/Report
  - Pressure Test Specification/Procedure
- I. Test and Calibration
  - Calibration Certificate – Test Equipment
  - FAT Specification/Procedure

- Qualification Test Certificate/Report/Results
  - Qualification Test Specification/Procedure
- J. Quality Control and Test
- Visual inspection of solder joints included as check points in product traveller / MRB.
  - Helium/Nitrogen Leak Test. Test results to be included in product traveller / MRB.
  - Earth Bond/Continuity Test. Test results to be included in product traveller / MRB.
  - FAT Test results to be included in product traveller / MRB.
  - Insulation Resistance (IR) Test Report. Test results to be included in product traveller / MRB.
- K. Handling
- Handling/Lifting/Storage/Packing/Shipping/Preservation Procedure
  - Weight Certificate
- L. Certificate of Conformance (COC) must also include the following:
- Name of Manufacturer/OEM/OCM
  - Manufacturer's/OEM's/OCM's part number when required
  - Plexus part number
  - Revision or EC level if applicable
  - Quantity
  - Purchase order number
  - Lot # and Date Code <sub>1</sub> or Serial numbers for each shipment
  - A statement of Compliance specifying compliance to the following:
    - The drawings and specifications provided by Plexus
    - The requirements of the specific PO
  - Signed and dated by an authorised representative

<sub>1</sub> The minimum-required date code format shall identify the 2-digit workweek, 2-digit year (WWYY). If the component marking contains a lot and date code, then those markings must be traceable to the COC.

All cartons, required documentation, labels, packaging and packing slips must have part number, EC level or revision, quantity and P.O. number listed on them.

**Subsequent Shipments**-The documentation and quality requirements for all subsequent shipments will be as follows:

- A. Manufacturing Record/Data Book
- B. Material Traceability List/Location Plan
- C. Material 'Mill' Test Report/Certificate  
EN10204 Type 3.1 Material Inspection Certification must detail the following:
  - Name of Material Supplier
  - Material Suppliers part number
  - Details of the Test/Inspection Results
  - The Lot # and Date Code or Serial numbers for each shipment
  - A statement of Compliance to specification

- Signed and dated by an authorised inspection representative independent of the manufacturing department.
- D. Pressure Testing/Examination
- Chart Record/Read Out (Pressure/Leak/Gas/Hyperbaric Test)
  - Pressure Test Certificate/Report
- E. Test and Calibration
- Calibration Certificate – Test Equipment
  - Qualification Test Certificate/Report/Results
- F. Quality Control and Test
- Visual inspection of solder joints included as check points in product traveller / MRB.
  - Helium/Nitrogen Leak Test. Test results to be included in product traveller / MRB.
  - Earth Bond/Continuity Test. Test results to be included in product traveller / MRB.
  - FAT Test results to be included in product traveller / MRB.
  - Insulation Resistance (IR) Test Report. Test results to be included in product traveller / MRB.
- G. Handling
- Weight Certificate
- H. Certificate of Conformance (COC) must also include the following:
- Name of Manufacturer/OEM/OCM
  - Manufacturer's/OEM's/OCM's part number when required
  - Plexus part number
  - Revision or EC level if applicable
  - Quantity
  - Purchase order number
  - Lot # and Date Code <sub>1</sub> or Serial numbers for each shipment
  - A statement of Compliance specifying compliance to the following:
    - The drawings and specifications provided by Plexus
    - The requirements of the specific PO
  - Signed and dated by an authorised representative

<sub>1</sub> The minimum-required date code format shall identify the 2-digit workweek, 2-digit year (WWYY). If the component marking contains a lot and date code, then those markings must be traceable to the COC.

All cartons, required documentation, labels, packaging and packing slips must have part number, EC level or revision, quantity and P.O. number listed on them.

Shipments of multiple lot and/or date codes must be identified separately on the DOC with the actual quantity shipped for each. Each lot and/or date code shall be independently packaged (i.e., no mixed lot/date codes within a package: reels, trays, tubes, bags, etc.).

*Material received without the completion and proper execution of the Quality Requirement allows Plexus the right to return the material as defective. For material that has been previously provided to Plexus, the requirements under subsequent shipments will be followed.*



### Product change notification

Upon acceptance of conforming product, documentation, and the requirements of this Q-code, the supplier's manufacturing process shall be considered "qualified". All changes require written approval from Plexus prior to implementation. Product or Process change notification requests (PCNs) shall be submitted to [pcns@plexus.com](mailto:pcns@plexus.com).