



Q-CODE Q35C QUALITY REQUIREMENTS

For acceptance of outside processes of Tinned parts and gold removal per J-STD-001

The following are the quality requirements for product purchased under Q-code Q35C. This product is controlled by the SAE standard AS9100. With acceptance and shipment against this P.O. the supplier agrees to meet the requirements of AS9100, unless a written waiver is received from Plexus. This includes but is not limited to;

- Granting the right of access to the supplier's facilities and all applicable records to Plexus, their customer and regulatory authorities
- The retention of all records that support the manufacturing or materials used for 15 years unless otherwise specified in the purchasing specifications
- The flow down all applicable requirements to sub-tier suppliers including key characteristics and retention of all records that support the manufacturing or material used per the requirements of AS9100.

1ST SHIPMENT - THE DOCUMENTATION AND QUALITY REQUIREMENTS FOR THE INITIAL SHIPMENT AND/OR THE FIRST SHIPMENT AFTER ANY CHANGES HAVE BEEN MADE, ARE 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. The AS9102 FAIR must be complete and include the requirements.
- B. Certificate of Compliance – the Certificate of Compliance (COC) must be titled as such and shall include a statement declaring that the manufactured item has been made to the appropriate customer specification requirements per J-STD-001. The COC shall contain the following minimum information:
 - Plexus Part Number
 - Plexus PO Number and Quantity
 - Original Component Manufacturer Name, Part Number, and Date Code(s)
 - Certification to the tinning process requirements identified below.
- C. The following requirements shall be followed if applicable to the order and certified on the COC:
 - All parts must be baked 48 hours at 125°C regardless of component manufacturer's MSD level prior to processing.
 - Solder tinning material is defined by PO Item Number prefix: 'T1' for Sn63/Pb37 (eutectic), 'T2' for Sn96.5/Ag3.5 (Pb-free), 'T3' for Sn5.0/Pb93.5/Ag1.5 (high-melting point) and 'T4' for Sn96.5Ag3Cu0.5.
 - Manufacturer part numbers shall not be mixed in final component packaging.
 - Manufacturer date codes shall not to be mixed in final component packaging.
 - Original component manufacturer labels shall be returned with the completed parts affixed to the moisture-barrier bag.
 - All MSD levels parts shall be processed in accordance with MSD level listed on the component datasheet per J-STD-033.
 - Pin 1 orientation in carrier tape per component manufacturer tape-and-reel specification. Packaging medium specified by last character of PO Item Description: 'R' for T&R, and 'W' for tray. Absence of either of these codes implies that parts be returned in their original packaging.

For Gold removal per J-STD-001

- D. Certificate of Analysis – or Equivalent which shall include a statement declaring that the manufactured/materials item has been tested to the appropriate specification requirements and the following minimum information:
 - Name of Manufacturer
 - Manufacturer Item Number
 - Batch or Lot Number
 - Manufacture Date
 - Expiration Date*
 - Product Properties and Analysis Results



All cartons, required documentation, labels, and packaging and packing slips must have the Plexus part number, EC level or revision (if applicable), date code(s), quantity, and P.O. number listed on them.

ALL SHIPMENTS – THE DOCUMENTATION AND QUALITY REQUIREMENTS AS LISTED BELOW ARE REQUIRED WITH EACH SHIPMENT

- A. Certificate of Compliance – the Certificate of Compliance (COC) must be titled as such and shall include a statement declaring that the manufactured item has been made to the appropriate customer specification requirements per J-STD-001. The COC shall contain the following minimum information:
- Plexus Part Number
 - Plexus PO Number and Quantity
 - Original Component Manufacturer Name, Part Number, and Date Code(s)
 - Certification to the tinning process requirements identified below.
- B. The following requirements shall be followed if applicable to the order and certified on the COC:
- All parts must be baked 48 hours at 125°C regardless of component manufacturer’s MSD level prior to processing.
 - Solder tinning material is defined by PO Item Number prefix: ‘T1’ for Sn63/Pb37 (eutectic), ‘T2’ for Sn96.5/Ag3.5 (Pb-free), ‘T3’ for Sn5.0/Pb93.5/Ag1.5 (high-melting point) and ‘T4’ for Sn96.5Ag3Cu0.5.
 - Manufacturer part numbers shall not be mixed in final component packaging.
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All cartons, required documentation, labels, and packaging and packing slips must have the Plexus part number, EC level or revision (if applicable), date code(s), quantity, and P.O. number listed on them.

The above listed required documentation must be submitted with each shipment. Shipments received without the completion and proper execution of these Quality Requirements is considered non-conforming and Plexus reserves the right to return to the supplier at the supplier’s expense.

PRODUCT CHANGE NOTIFICATION

Product or Process change notification requests (PCNs) shall be submitted to pcns@plexus.com, please reference the details of our PCN policy and requirements in the Plexus Supplier Quality Manual [DCS 10503](#).

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REVISION HISTORY

REV	RELEASE DATE	ORIGINATOR	DESCRIPTION OF CHANGE(S)	REASON FOR CHANGE(S)
A	28Mar2023	Jorge Irizarry	New - Initial Release	MSL per J-STD-033