

L.L. ROWE CO.

QUALITY CONTROL

PROCEDURE	LLR Form 080
PAGE	1 of 11
ISSUED	11-01-86
APPROVED	J. JENKINS

PURCHASE ORDER – QUALITY REQUIREMENTS

1. Scope

This document encompasses all pertinent Quality requirements for Purchase Orders, to be maintained as a reference document.

2. Quality Requirements

Q1. SPECIAL INSTRUCTIONS

L.L. Rowe Company and their customer's Quality Control Department reserves the right to inspect any or all of the materials included in this order at the suppliers' plant. All purchase orders that are LEVEL ONE, SUBSAFE and/or DSS will be stamped in red on the cover page.

Q2. SOURCE INSPECTION

All items covered by this purchase order are subject to inspection at the seller's facility by an L.L. Rowe Quality representative prior to shipment. The seller shall furnish, at no cost, acceptable facilities and equipment to the L.L. Rowe representative for his inspection. The seller shall provide no less than forty-eight (48) hours advance notice to the L.L. Rowe Quality representative to permit scheduling of source inspection. Evidence at source inspection shall accompany each shipment.

Q3. GOVERNMENT INSPECTION

"The government reserves the right to inspect any or all of the materials included in this order at the suppliers plant."

Q4. GOVERNMENT IN-PROCESS INSPECTION

"All work on this order is subject to inspection and test by the Government at all times (including the period of performance) and places; and, in any event, prior to shipment. The Government representative who normally services your plant should be notified seven days in advance of the time articles or processes are ready for inspection or test."

Q5. FIRST ARTICLE INSPECTION

Prior to delivery of the article indicated by the purchase order, the supplier shall submit a first article to the L.L. Rowe Company. The first article shall represent the same material, fabrication process and/or process of the end production item. Unless otherwise specified, the quantity and acceptance of the first article shall be determined by the designated quality representative. The supplier shall notify the buyer no less than 72 hours prior to submission of first articles or production units. Acceptance of first articles shall not represent the acceptance of the production run, or relieve the supplier of the responsibility of meeting the requirements of the purchase order. First articles (of the same part number) submitted to and accepted by L.L. Rowe shall not require first article submission on subsequent purchase orders. Unless otherwise specified, however, the supplier shall certify that the subsequent articles are manufactured from the same process. Certifications shall be submitted in triplicate with each shipment of articles.

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Q6. PROCESS APPROVALS

Special processes such as welding, heat treating, liquid oxygen cleaning, electroplating, anodizing, chemical films and non-destructive testing require L.L. Rowe approval of process equipment, procedures and personnel, as applicable. This approval must be established with L.L. Rowe prior to fabrication under this contract. The seller is responsible for and must certify to special process specification compliance by all of his sub-contractors, and must maintain objective evidence thereof. All special process performed of the items covered by this purchase order shall be approved by the buyer or his delegate representative prior to manufacturing or fabrication.

Q7. CONTROL OF SUB-SUPPLIERS

The seller shall be responsible for conformance of all supplies or services procured from every tier of his sub-supplies and shall assure that the requirements of this document, purchase order and applicable drawings and specification are incumbent upon his procurement sources. Documented evidence as to the control of sub-supplies shall be maintained.

Q8. MANUFACTURING AND LOT CONTROL

The items covered by this purchase order shall be manufactured from one unchanged process and drawing and shall contain one lot, batch or heat of material.

Q9. BONDED PROCUREMENT

The items covered by this purchase order shall be applied from Government bonded and certified stores, and shall be certified as such. Where the items are covered by military or Government standards, the standard shall be made reference to on the certification. The certification shall accompany each shipment of the items covered by this purchase order.

Q10. RAW MATERIAL IDENTIFICATION

Materials shall be identified by tagging or strip marking in accordance with FED-STD-183 or 184 is applicable.

Q11. QUALIFIED PRODUCTS (QPL)

The items covered by this purchase order shall be supplied from approved manufacturers from GOVERNMENT QUALIFIED PRODUCTS LIST. QPL which are applicable to the military or Government standard referenced by this purchase order. Certification shall accompany each shipment of the items covered by the purchase order. The certification shall specify the purchase order number and applicable Mil Spec.

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Q12. SYNTHETIC RUBBER COMPONENTS AND RAW MATERIALS

Each package of synthetic rubber components shall be marked with date of cure, part number, purchase order number, quantity, compound number, manufacturer's identification (if different than part number). Date of cure on O-Rings shipped to L.L. Rowe shall not be older than is permissible under MIL HANDBOOK 695 Synthetic rubber raw materials shall be identified with date of cure, compound, purchase order number, and manufacturer's name.

12.1 Type 1 (3 Year) Shelf Life item. The item furnished on this order shall have at least 85% of the shelf life remaining at time of delivery.

12.2 Type 1(15 Year) Shelf Life item. The item furnished on this order shall have at least 85% of the shelf life remaining at time of delivery.

Q13. SYNTHETIC MATERIALS

Materials or articles having definite characteristics of quality degradation or drift with age and/or use shall be marked to indicate the test time date or cycle the critical life was initiated or the date and test time or cycle at which the useful life will be expended. Variable data shall be recorded and maintained.

Q14. TEST REPORTS

Each shipment must be accompanied by one reproducible and legible copy of all testing performed, such as physical, non-destructive, or functional. The test reports must be identifiable with the actual test parameters and the material submitted. These reports must contain the signature and the title of the authorized representative of this agency performing the test, and must ensure conformance to specification and purchase order requirements.

Q15. PROCESS CERTIFICATION

Each shipment must be accompanied by a legible and reproducible copy of certificate containing the signature and title of an authorized representative for all processes used, such as heat treating, welding, magnetic particle inspection, penetrate inspection, ultrasonic inspection, radiographic inspection, surface preparation and treatment, etc. The certificate shall include the processing used, the specifications to which they conform, and the name of the agency that performed them if other than the seller. When parts are serialized, serial numbers, mil numbers, heat numbers must appear on the certification.

Q16. CERTIFICATION OF X-RAY

All parts requiring radiographic certifications will be submitted to Government and L.L. Rowe approved x-ray laboratory and processed in accordance with applicable L.L. Rowe and Government standards. Findings will be reported on an appropriate form, including the name of the reader and the signature and title of an authorized laboratory representative. The x-ray film and two (2) legible and reproducible copies of the report must accompany the material.

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Q17. CERTIFICATION OF MATERIAL CONFORMANCE

Each shipment must be accompanied by one legible and reproducible copy of a certification stating the items were produced: (1) from materials furnished by L.L. Rowe for the production of such items, or (2) from materials on which the seller has available for examination specific data or other objective evidence of conformance to applicable specifications. The certificate must contain the signature and title of an authorized representative of the seller.

Q18. STATEMENT OF CONFORMITY

Each shipment must be accompanied by one legible and reproducible copy of a Statement of Conformity containing the signature and title of an authorized representative of the seller stating materials meet applicable specifications, cited in the purchase agreement. The seller certifies that they have inspected the material and found it to be in accordance with the requirements of the drawings and/or specifications. Any non-conforming material shall be segregated and marked showing the details of the discrepancy.

Q19. CHEMICAL/PHYSICAL TEST REPORTS

Each shipment must be accompanied by one legible and reproducible copy of all chemical/physical test reports identifiable with materials submitted. These reports must contain the name and signature and title of the authorized representative of the agency performing the test and must assure conformance to specification requirements.

Q20. SELLER CONTROLLED PRODUCTS

One legible and reproducible copy of applicable specifications, drawings and/or catalogues is to accompany the initial shipment on this purchase order.

Q21. PROPRIETARY PRODUCTS

Seller shall notify the Buyer in writing of any changes proposed in product design, performance specifications, materials or material processes of the proprietary products as ordered hereunder, and shall obtain Buyer's approval prior to any such proposed changes.

Q22. EXCESS MATERIAL

All L.L. Rowe furnished excess material, scrap or otherwise is to be identified and held in a bonded area until completion of order, then returned to L.L. Rowe properly identified.

Q23. REPORT OF DISCREPANCY

For consideration by L.L. Rowe any departures from drawings, specifications or other purchase order requirements must be recorded and forwarded to L.L. Rowe for consideration. Disposition of these departures must be approved by L.L. Rowe prior to shipment.

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Q24. LEVEL ONE AND/OR SUB-SAFE SPECIAL NOTICE

The material covered by this purchase order will be used in a crucial shipboard system. The use of incorrect or defective material would create a high probability of failure resulting in serious personnel injury, loss of life, loss of vital shipboard systems or loss of the ship itself.

The following requirements must be strictly adhered to for acceptance at L.L. Rowe:

The material is intended for use in submarines and makes it mandatory that this material shall contain no non-metallic mercury contamination. Copies of analysis reports certifying chemical composition and analysis of material and absences of mercury shall be sent with each shipment. Heat/lot numbers and MIC numbers when indicated in purchase orders shall be traceable to the accompanying chemical and physical certifications.

Failure to meet any of the above requirements shall be cause for rejection.

Q25. SUPPLIER IDENTIFICATION AND TRACEABILITY REQUIREMENTS

The seller shall conform to the provisions of Reliability Procedure LLR 042 Identification and Traceability Requirements for suppliers.

Q26. SUPPLIER CALIBRATION REQUIREMENTS

The seller shall provide and maintain a calibration system that complies with Specification ANSI-Z540.1 "Calibration System Requirements".

Q27. SELLER'S QUALITY CONTROL SYSTEM

The seller shall maintain a Quality Control System approved by L.L. Rowe, and shall be subject to audit by L.L. Rowe representatives.

Q28. LEVEL I AND/OR SUB-SAFE VENDOR SUPPLIED MATERIAL

The vendor shall supply an original Mill certification for the chemical composition and mechanical properties of LEVEL I non-nuclear material per DI-MISC-81020. The cert shall require an original signature with a typed name and date **Electronic signatures are not acceptable**. Bars and/or slugs of raw material shall be permanently marked with heat/lot number directly to the bar stock on which the chemical and physical analysis was conducted.

Over-stamping per NAVSEA letter 4855 Ser04P1/011 must be accomplished prior to machining.

Q29. INSPECTION OF SUPPLIES

- a. The supplies furnished under this contract are subjected to INSPECTION SYSTEM MIL-I-45208. Therefore all suppliers and subcontractors shall comply with this requirement in its entirety.

The supplies furnished under this contract are subjected to FEDERAL acquisition REGULATION 52.246.2. Therefore all suppliers and subcontractors shall comply with this requirement in its entirety.

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Q30. SUPPLIER STATISTICAL QUALITY CONTROL

The seller shall provide and maintain sampling inspection system that complies with applicable military standards and sampling plans from MIL-STD-105, MIL-STD-414, Handbook H106, H107, H108. The system shall be subject to review and approval by the Buyer or his representative. The seller shall provide 100 percent (all) inspections unless the sampling inspection system is approved by L.L. Rowe.

Q31. PACKAGING

All parts must be packaged and handled in a manner to prevent damage in handling and transit.

Q32. MOLD STANDARD: NAVSEA S9320-AM-PRO-020/MLDG

All surfaces primed shall be cleaned with acetone and thoroughly dried. Apply Primer to all molded surfaces per manufacture's TDS, only the following approved primers shall be used: AD-1146C-1 or PR-420 for metal surfaces, PR-1167 or PR-1523M for neoprene surfaces and AD-1147 for plasma coated surfaces. Primers and polyurethane shall be from the same manufacture. Primed surfaces shall be molded per the manufactures TDS within a maximum of four hours or less. Only the following approved Amber translucent polyurethane molding compounds shall be used: EN-1556 or PR-1547 only the following approved epoxy backfill shall be used: EE4183 and HD3561 or RE2039 and HD3561. Each shipment shall be accompanied with a certification for the primer, polyurethane and epoxy backfill certifying the following: L.L. Rowe purchase order#, L.L. Rowe Part#, Manufacturer of the polyurethane or primer, Item Description, Manufacture's part number, quantity, Lot#, Date or manufacture, Date of expiration and Serial numbers of parts molded with each lot#.

Q33. HEAT TREATMENT

All heat-treating will be done in accordance with L.L. Rowe procedure 003F and L.L. Rowe Form 073A attached to the purchase order or as already on file to the vendor's facility. Certification of heat-treating shall be at a minimum to include the following:

1. Description of heat-treating process performed.
2. Length of time for the process.
3. Temperature maintained.
4. Description of the material being processed and quantity and/or weight of pieces.

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Q34. MACHINE SHOP SUB-CONTRACTORS

Machine shops that are supplying material on a Level One Subsafe purchase order for L.L. Rowe shall supply their receiving inspection procedure, handling of raw stock procedure and material traceability procedure for approval prior to receipt of any stock from the mill.

Suppliers of Level One SUBSAFE material shall maintain segregation of these materials from non-subsafe level one material. The in-process hold areas shall be provided with controls to prevent co-mingling of materials. Storage areas of raw stock and partially or finished items shall be labeled with a sign that is marked Level One SUBSAFE. If parts should become co-mingled with non-level material, measures shall be taken to re-determine materials identity. These measures shall be required to be approved by L.L. Rowe prior to being taken.

Machine shops that are being supplied material by L.L. Rowe directly from the mill shall perform receipt inspection in accordance with L.L. Rowe RECEIVING INSPECTION PROCEDURE LLR 024 and RAW STOCK CONTROL PROCEDURE LLR 042. Verification test results shall be transmitted to L.L. Rowe with the first shipment of each identifiable lot of material. Heat/lot traceability shall be maintained in accordance with L.L. Rowe Procedure LLR 042. L.L. Rowe reserves the right to survey suppliers for compliance with this clause.

Use of seamed pipe is prohibited.

Q35. MERCURY FREE

Use of mercury, mercury compounds or mercury-bearing instruments and/or equipment in a manner which might cause contamination in the manufacture, assembly or test of material on this purchase is prohibited. The most probable cause of contamination are direct connected manometers, mercury vacuum pumps, mercury seals of the handling of Mercury in the immediate vicinity. Mercury switches, mercury in glass thermometers, standard cells and other items containing mercury may be used if they are located so as not to constitute a contamination hazard.

Vendor is required to certify that the above requirements are in compliance.

Q36. HARDNESS TEST

Brinell (250 Min) or Rockwell (24 Min) hardness on each item shall be tested in accordance with ASTM E 10 or ASTM E 18 as applicable. Hardness shall be checked at three locations avoiding critical surfaces. See L.L. Rowe drawings for location.

Q37. WELDING AND/OR BRAZING

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The vendor shall supply certification verifying that the operation was performed in accordance with MIL-STD-0248 and MIL-STD 278. L.L. Rowe reserves the right to inspect source supplies and services not manufactured or performed at our facilities.

Q38. MALPRACTICE, FRAUD AND FALSIFICATION AND SUSPECT/COUNTERFEIT PARTS

This requirement concerns a matter within the jurisdiction of an agency of the United States and the making of a false, fictitious or fraudulent certification that may render the maker subject to prosecution under title 18, United States Code, Section 1001. Suppliers and Sub-Suppliers shall be aware and vigilant for Malpractice and Fraud and Falsification (F&F) Failure to comply may result in the vendor being disqualified from consideration on any future orders with the L.L. Rowe Company.

“Suspect/counterfeit” parts are parts that may be of new manufacture, but are misleadingly labeled to provide the impression they are of a different class or quality or from a different source than is actually the case. The term “suspect/counterfeit parts” also includes refurbished parts, with or without false labeling, that are represented as new parts or any parts that are designated as suspect by the U.S. Government, including but not limited to parts listed in alerts published by the Defense Contract Management Agency under the Government Industry Data Exchange Program (GIDEP) For further details go [http://supplier.huntingtoncalls.com/sourcing/appendix/A append/App A-DoD Contracts-20140303.pdf](http://supplier.huntingtoncalls.com/sourcing/appendix/A%20append/App%20A-DoD%20Contracts-20140303.pdf)

Q39. THREADS

All threads shall be formed by cutting. Cold forming of threads is not acceptable. These threads shall be checked with go and no go gages to determine interchangeability and measured for conformance to H-28.

Q40. USE OF OZONE DEPLETING SUBSTANCES

The restriction on use of Class 1 ozone depleting substances for MIL-P-116:

- a. In accordance with requirements of the 1993 Defense Authorization Act, no Department of Defense Contract Award after 1 Jun 93 may include a specification or standard that requires the use of a Class 1 Ozone depleting substance unless the inclusion of such specification or standard is certified and approved.
- b. MIL-STD-2073 incorporates MIL-P-116 preservation requirements. Several of the cleaning materials listed/referenced in MIL-P-116 are Class 1 ozone depleting substances (ODS). The government does not require the use of the following ODS: O-T-620 or MIL-T-81533. When MIL-P-116 is cited as applicable in the contract, the contractor shall be responsible for the selection of an appropriate cleaning process, and at contractor’s option may use either an ODS

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or NON-ODS cleaning/preservation substance. Preference shall be given to the use of cleaning processes that do not require the use of ODS, when practical.

Q41. O-RING SURFACE FINISH

All 32 finish requirements shall be in accordance with ANSI/ASME B46.1 roughness, waviness, lay, flaws and error of form shall be compared visually or tactilely with a roughness specimen that is typical for that machined surface. The vendor is responsible to supply finishes which are free of all defects, scratches, voids, blow holes, dents, flaws and are free of imperfections (flawless).

Q42. SUBPART 25.1-Buy American Act-Supplies

A) 25.100 Scope of Subpart.

This subpart implements the Buy American Act (41 U.S.C. 10a – 10d) and Executive Order 10582, December 17, 1954. It applies to supplies acquired for use in the United States, including supplies acquired under contracts set aside for small business concerns, if-

- (a) The supply contract exceeds the micro-purchase threshold; or
- (b) The supply portion of a contract for services that involves the furnishing of supplies (e.g., lease) exceeds the micro-purchase threshold.

B). General

- (a) Specialty Metals Restrictions-Qualifying country are listed in DFARS 225.003 and are Australia, Austria, Belgium, Canada, Denmark, Egypt, Finland, France, Germany, Greece, Israel, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, Turkey, United Kingdom of Great Britain and Northern Ireland.
- (b) The Buy American Act restricts the purchase of supplies that are not domestic end products. For manufactured end products, the Buy American Act uses a two-part test to define a domestic end product.
 - (1) The article must be manufactured in the United States; and
 - (2) The cost of domestic components must exceed 50 percent of the cost of all the components.
- (c) The Buy American Act applies to small business set-asides. A manufactured product of small business concern is a U.S.-made end product, but is not a domestic end product unless it meets the component test in paragraph (a)(2) of this section.
- (d) Exceptions that allow the purchase of a foreign end product are listed at 25.103. The unreasonable cost exception is implemented through the use of an evaluation factor applied to low foreign offers that are not eligible offers. The evaluation factor is not used to provide a

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APPROVED	J. JENKINS	J. JENKINS	J. JENKINS	J. JENKINS	J. JENKINS	J. JENKINS
REVISION	M	N	O	P	Q	
REVISED	07-11-14	08-06-14	8/04/15	1/08/16	02/04/16	
APPROVED	R. McManus	R. McManus	J. Schommer	J. Schommer	J. Schommer	

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preference for one foreign offer over another. Evaluation procedures and examples are provided in Subpart 25.5.

Q43. 52.225-13 Restriction on Certain Foreign Purchases,

As prescribed in 25.110(a), insert the following clause:

Restriction on Certain Foreign Purchases (July 2000)

- (a) The contractor shall not acquire, for use in the performance of this contract, and supplies or services originating from sources within, or that were located in or transported from or through, countries whose products are banned from importation into the United States under regulations of the Office of Foreign Assets Control, Department of the Treasury. Those countries are Cuba, Iran, Iraq, Libya, North Korea, Sudan, the territory of Afghanistan controlled by the Taliban, and Serbia (excluding the territory of Kosovo).
- (b) The contractor shall not acquire for use in the performance of this contract and supplies or services from entities controlled by the government of Iraq.
- (c) The contractor shall insert this clause, including this paragraph (c), in all subcontracts.

Q44. Deep Submergence System: NAVSEA SS800-AG-MAN-OD/P-9290

The material supplied on this order shall be used in a deep submergence system.

Material Control Division <(B)> applies to this material.

Q45. International Traffic In Arms Regulations (ITAR):

This clause is only applicable to any technical data, defense articles or defense services provided to seller by LL Rowe under this order. Seller shall fully comply with U.S. Government export control laws and regulations, including the International Traffic in Arms Regulations (ITAR) at 22 CFR Parts 120-130, in connection with the performance of this order.

This provision incorporates, as though printed herein in full, the definitions set forth at 22 CFR Part 120. In particular, Seller should carefully note the definitions of the terms technical data (22 CFR 2 120.10), "defense article" (22 CFR 120.6), and "defense service" (22 CFR 120.9), all of which are incorporated into and made a part of this provision, as though fully set forth herein. By accepting this order, Seller acknowledges notification that, in connection with the performance of this order.

1. technical data that Seller obtains;

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2. technical data that Seller develops;
3. defense articles that Seller obtains or fabricates; and
4. defense services that Seller performs may only be disclosed to, handled by, or performed by on behalf of one or more of the following classes or individuals:
 - A. citizens of the United States;
 - B. lawful permanent residents as defined by 8 USC 1101(a)(20). I.e. “green cardholders;”
 - C. protected individuals as defined by 8 USC 1324(a)(3); or
 - D. foreign nationals for whom a current and directly relevant license or approval has been obtained from the U. S. Department of State, which license or approval is directly relevant to the work to be perform under this order.

Seller shall ensure that all the licenses or approvals required by the ITAR are obtained before handling or disclosing any technical data or defense articles, or providing or receiving any defense service in connection with the performance of this order.

Seller represents and warrants that it is and will, for the duration of this order, remain in full compliance with the ITAR. Seller further warrants and represents that is has advised its employees and consultants who are performing work in connection with this order or who have access to technical data or defense articles relating to this order of their obligations regarding compliance with the ITAR.

Seller shall be responsible for ensuring that the requirements of this provision are flowed down to any of its suppliers or subcontractors that will receive from Seller or provide to Seller technical data, defense articles or defense services in connection with the performance of this order. The requirements of this provision are in addition to any other of Sellers requirements at law or under contract to keep confidential LL Rowe information or equipment in Sellers possession or control.

Q46. ORDER OF PRECEDENCE:

This purchase order and amendments takes precedence in conflicts and disputes including existing specification requirements as well as drawing requirements.

Q47. UNCLASSIFIED DOD DOCUMENT SECURITY

Vendor agrees to ensure that all unclassified DoD information it receives or produces in support of DoD activities is protected in accordance with the Security of Unclassified DoD Information on Non-DoD Information Systems document (see website). Also vendor agrees that all personnel working on this contract have been briefed to the aforementioned document.

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