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MANUFACTURING PROCESS

Origination Date: XXXX

Document Identifier:	Manufacturing
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the manufacturing process.

[redacted]

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

[redacted]

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1.0 PURPOSE

This document defines the overall Manufacturing process and includes or makes reference to the procedures necessary for the process.

NOTE: The Manufacturing process includes all QC inspections and tests within it. Quality is not a separate process.

2.0 THEORY

Manufacturing operations or tasks must be conducted under controlled conditions to ensure product quality. By this we mean:

- [redacted]

3.0 PROBLEM RESOLUTION

All employees are instructed to immediately notify a Responsible Authority (RA) whenever a process or product related problem occurs that cannot be corrected according to established process controls and could affect or actually affects the quality of a production process or business operation.

It is understood that the appropriate responsible authority will occasionally not be available for support; in that event, [redacted]

- [redacted]

4.0 PROCEDURE: PRODUCTION DOCUMENTATION

4.1 All revision controlled production documents are available at the point of use and display the part number and revision of the item being produced.

4.2 In addition to this process procedure, additional production documentation may be required for a given order or production operation. Where required, [redacted]

4.3 Such documentation includes [redacted]

4.4 Records that are created for temporary retention of miscellaneous information are not required to [redacted]

5.0 PRODUCT IDENTIFICATION

5.1 Product is identified in shop areas by any of the following methods:

[redacted]

5.2 Lot traceability or individual serialization of parts is to be maintained on the paperwork (travelers, routers, etc.) as required. Supervisory staff will [redacted]

5.3 Bad (nonconforming) product that has failed an inspection or test and cannot be reworked to comply with requirements is [redacted]

5.4 Any parts or product not marked with a tag are to be considered [redacted]

5.5 IDENTIFICATION OF TRANSFER CONTAINERS

5.5.1 Whenever a portion of chemical is transferred from its original container to a smaller temporary container, [redacted]

5.5.2 Whenever a portion of chemical is transferred from its original container to a smaller permanent container, [redacted]

6.0 PROCEDURE: PRODUCT HANDLING

6.1 Work instructions and/or training will [redacted]

6.2 In all cases, Operators are [redacted]

6.3 The Company provides suitable safety and personal protection equipment for handling hazardous or toxic materials. Operators are [redacted]

7.0 PROCEDURE: PRESERVATION

7.1 Operators will [redacted]

7.2 Operators will [redacted]

7.3 Operators will [redacted]

7.4 Operators will [redacted]

7.5 FOD: Foreign Object Damage and Detection: Work instructions and training methods ensure that handling and preservation practices reduce the introduction of foreign objects (FOD) into products.

7.6 Marking and labeling including safety warnings

7.7 [redacted]

8.0 PROCEDURE: CUSTOMER AND GOVERNMENT PROPERTY CONTROL

8.1 Customer and Government Property (C&G Property) means [redacted]

This includes:

8.1.1 [redacted]

8.1.2 [redacted]

8.1.3 [redacted]

8.1.4 [redacted]

8.2 All Customer and Government furnished property shall be inspected by Receiving Inspection upon receipt according to the ***QMS-09 Receiving Procedure***. Any nonconformities or shortages will be communicated to the Customer for action.

8.3 C&G Property shall be identified [redacted]

8.4 Sensitive material, as defined by the Customer or Government, shall [redacted]

8.5 C&G Property will [redacted]

8.6 C&G provided equipment shall [redacted]

8.7 Quality shall investigate and report to the Customer or Government any cases of [redacted]

8.8 Requirements for the control of C&G property shall [redacted]

9.0 PROCEDURE: VALIDATION OF PROCESSES

9.1 Unless otherwise specified by engineering requirements, the form named Design Validation-Verification is used to record results of validation and verification activities.

9.2 Provisions for validation and verification includes:

- [redacted]
- [redacted]
- [redacted]
- [redacted]
- [redacted]

10.0 PROCEDURE: INSPECTION AND TEST OF PRODUCT

10.1 Receiving inspection is performed according to the ***QMS-09 Receiving Procedure***.

10.2 First Article Inspection

10.2.1 First article inspections are detailed inspections of every dimension and characteristic of the first completed part or of a semi-completed part and are performed when required by the Customer or management decision.

10.2.2 The Company will utilize the Customer or Government provided First Article Inspection Report to record First Article inspection results when provided.

10.2.3 Where not provided, the Company will utilize [redacted]

10.2.4 Complete the first article inspection form according to its format and submit to CCB.

10.2.5 Calibrated tools shall be used for first article inspection; however, [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.2.6 [redacted]

10.2.7 Any item failing first article inspection must be processed according to the ***QMS-14 Control of Nonconforming Product Procedure***.

10.3 In Process Inspections

10.3.1 In-process inspection is performed by [redacted]

10.3.2 In-process inspections are performed [redacted]

10.3.3 Calibrated tools shall be used for in-process inspection; however, [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.3.4 When applicable, complete the production inspection form according to its format.

10.3.5 [redacted]

10.3.6 Any item failing in-process inspection must be processed according to the ***QMS-14 Control of Nonconforming Product Procedure***.

10.4 Final Inspection

10.4.1 Final inspection is performed by [redacted]

10.4.2 100% sampling is required for final inspection unless otherwise specified by Customer contract. When sampling is permitted by Customer contract then Zero Acceptance Number Sampling Plan C=0 or ANSI Z1.4 may be used, or as specified by Customer contract.

10.4.3 Calibrated tools shall be used for final inspection; however, [redacted] under the following conditions:

1) [redacted]

2) [redacted]

10.4.4 Complete the production inspection form according to its format.

10.4.5 [redacted]

10.4.6 Any item failing final inspection must be processed according to the ***QMS-14 Control of Nonconforming Product Procedure***.

11.0 PROCEDURE: SHELF LIFE EXTENSION - Subject to Customer Review and/or Approval

11.1 Items that are subject to expiration may [redacted] for instance:

[redacted]

11.1.1 [redacted]

11.1.2 [redacted]

11.1.3 [redacted]

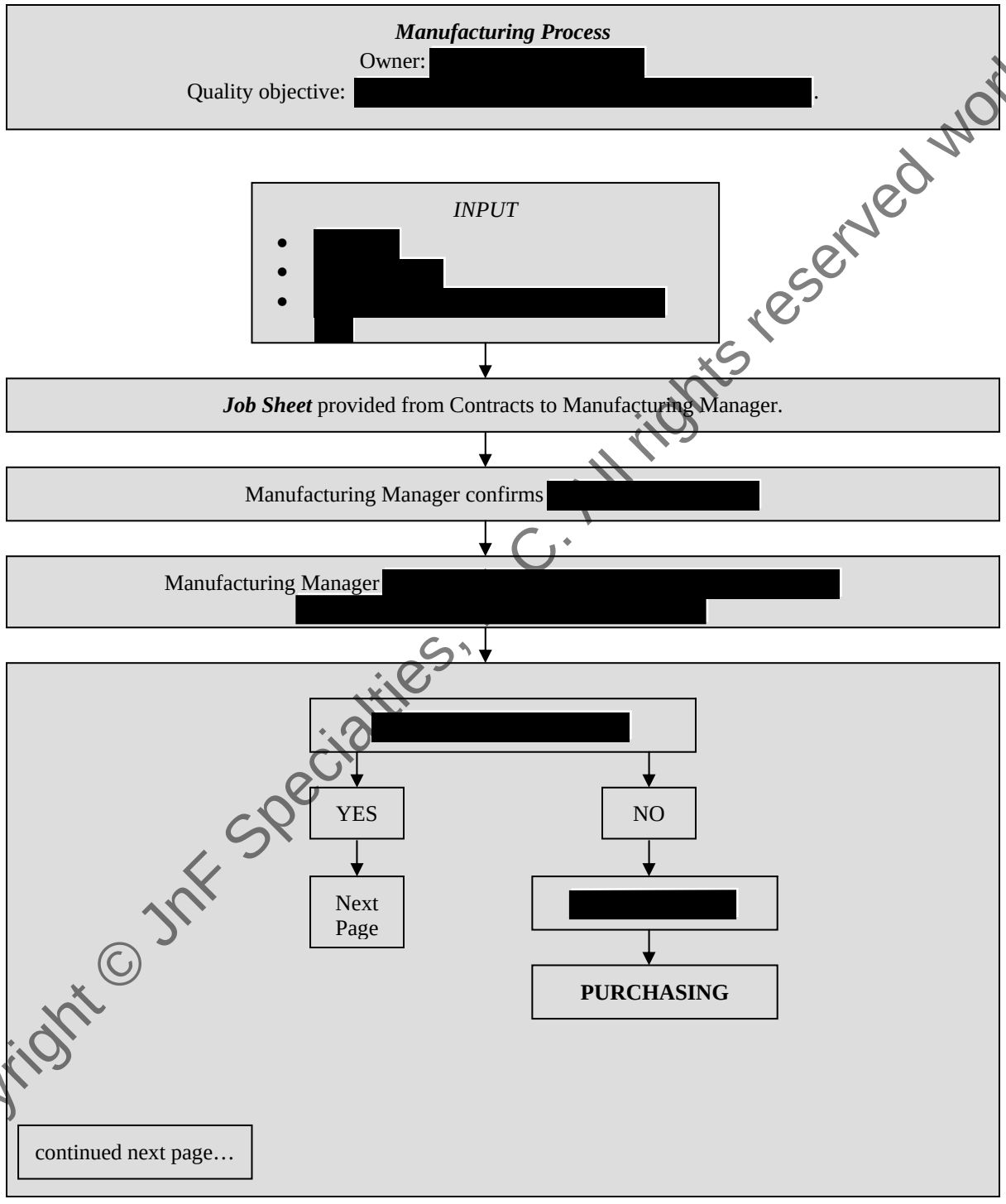
11.1.4 [redacted]

11.2 Chemicals that are purchased or prepared by the chem-lab are [redacted]

11.3 Raw material components whose shelf life [redacted]

[redacted]

12.0 PROCESS MAP



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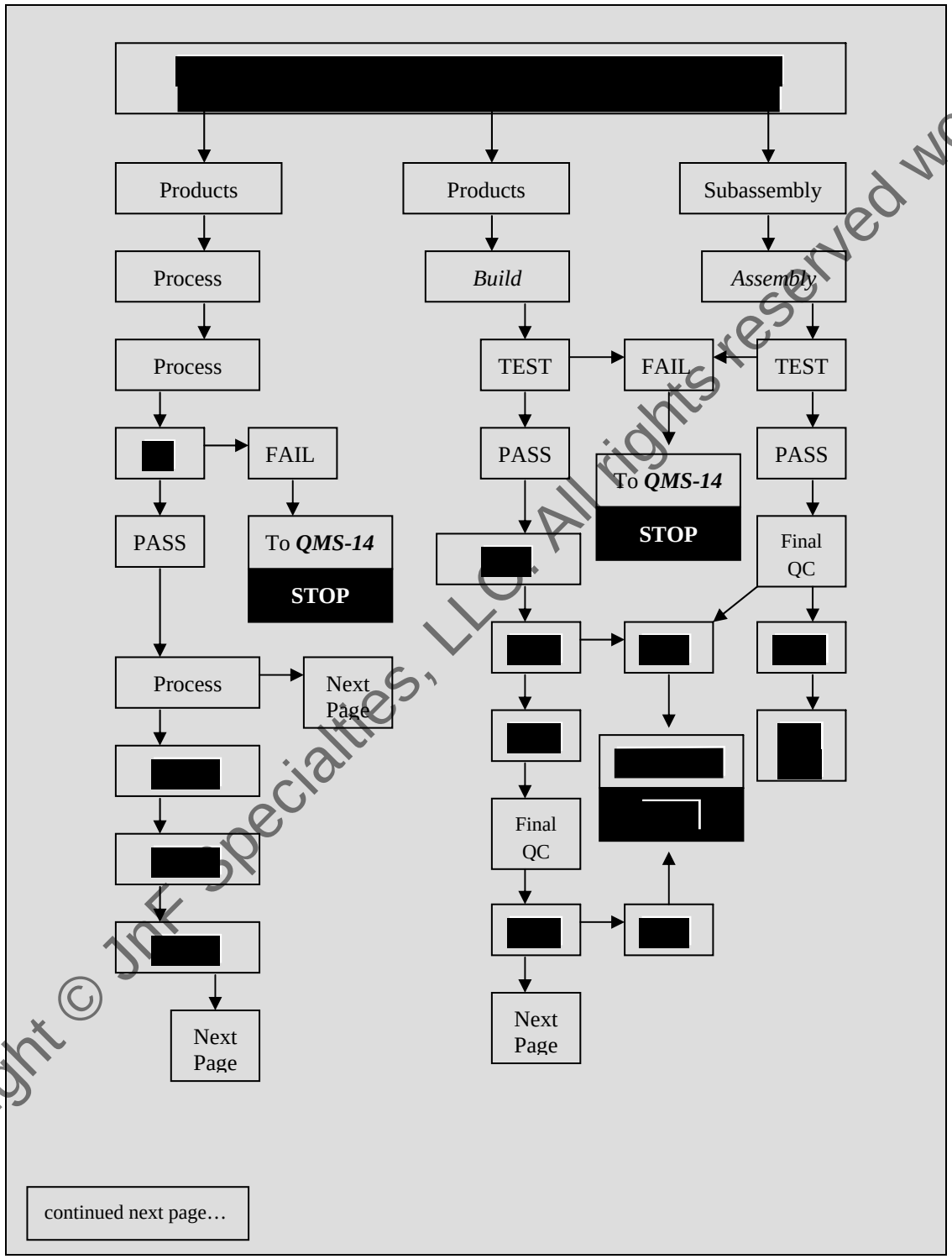

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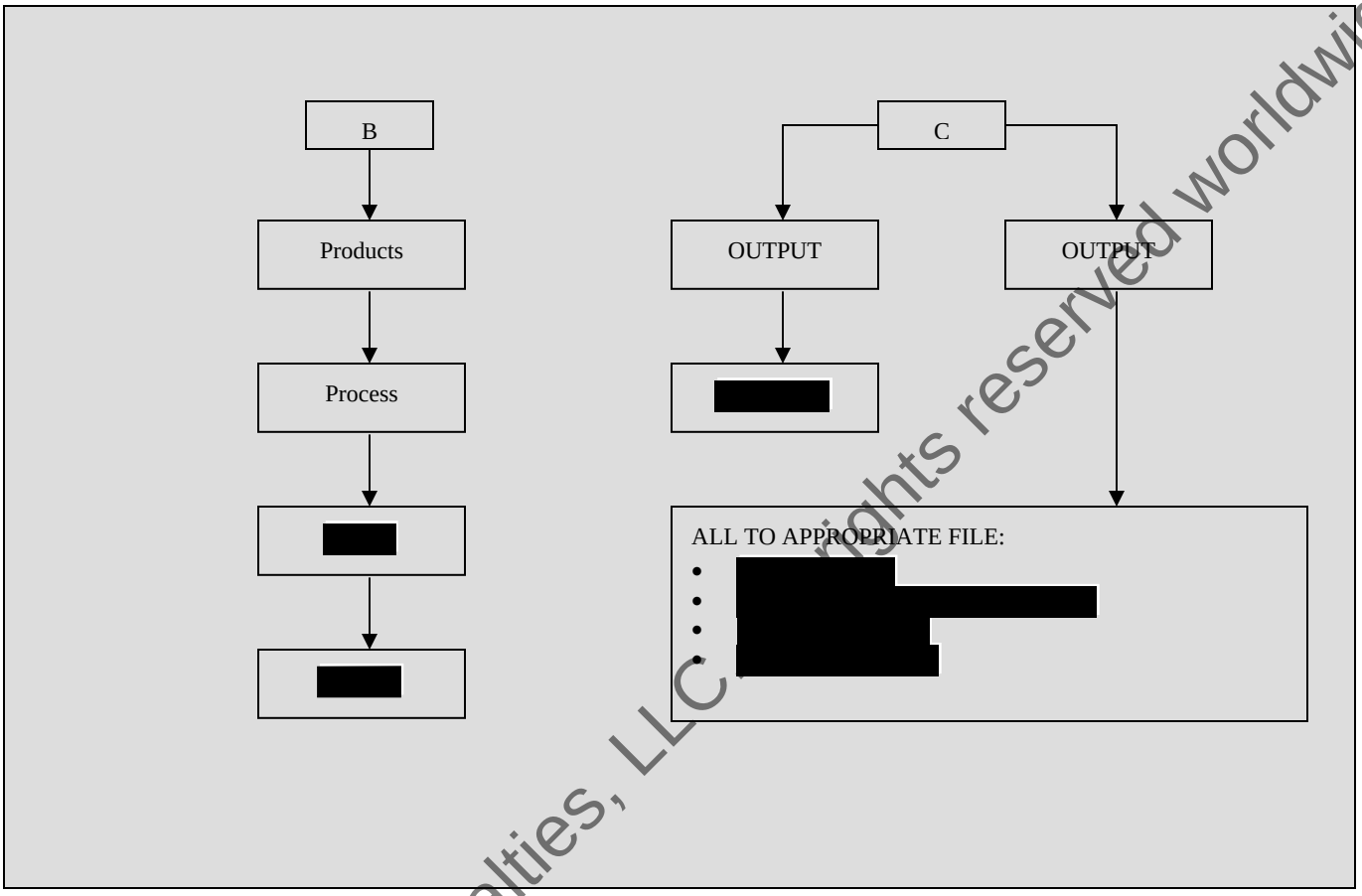

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