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PRODUCTION PROCEDURE

Origination Date: XXXX

Document Identifier:	Production
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 production process.

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

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1.0 PURPOSE

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

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

2.0 THEORY

Production 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.

[redacted]

- [redacted]

4.0 PROCEDURE: PRODUCTION DOCUMENTATION

4.1 All revision controlled production documents are [redacted]

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

4.3 Such documentation includes [redacted]

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

5.2.1 When traceability markings will be removed by a fabrication process, the marking [redacted]

5.2.2 Traceability must be accomplished by [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 [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, the [redacted]

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

6.0 PROCEDURE: PRODUCT HANDLING

6.1 Work instructions and/or training will instruct Operators on [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 required [redacted]

7.0 PROCEDURE: PRESERVATION

Preservation can include [redacted]

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 [redacted]

7.7 Special handling for [redacted]

8.0 PROCEDURE: CUSTOMER PROPERTY CONTROL

The Company [redacted]

8.1 Customer Property (Property) means [redacted] Hardware property includes:

8.1.1 [redacted]

8.1.2 [redacted]

8.1.3 [redacted]

8.1.4 [redacted]

8.2 All Customer furnished property shall [redacted]

8.3 Property shall [redacted]

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

8.5 Property will only be [redacted]

8.6 Customer provided equipment shall [redacted]

8.7 Quality shall [redacted]

8.8 Requirements for the control of 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

The Company determines what needs to be monitored and measured and the methods for monitoring, measurement, analysis and evaluation as applicable to ensure valid results when monitoring and measuring is performed and when the results from monitoring and measurement are analysed and evaluated.

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 [redacted]

10.2.2 The Company will utilize the [redacted]

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

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 [redacted]

10.4 Final Inspection

10.4.1 Final inspection is performed by [redacted]

10.4.2 100% sampling is required for final inspection unless [redacted]

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 [redacted]

10.4.7 The Responsible Authority conducts a complete visual inspection of all items being shipped. Inspection includes, but is not be limited to:

1. [redacted]
2. [redacted]
3. [redacted]
4. [redacted]
5. [redacted]
6. [redacted]
7. [redacted]

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:

11.1.1 [redacted]

11.1.2 [redacted]

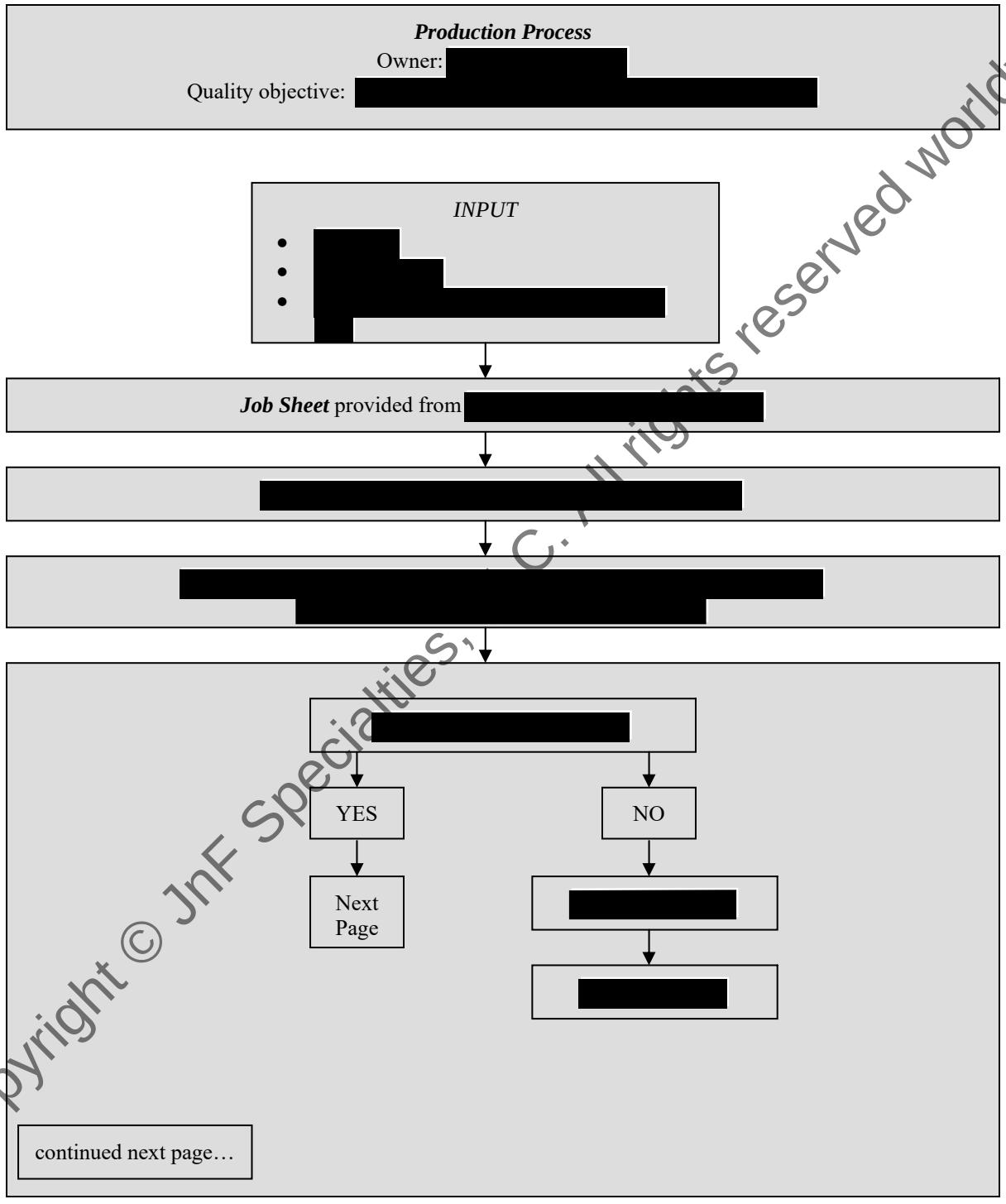
11.1.3 [redacted]

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 has been extended must [redacted]

12.0 PROCESS MAP



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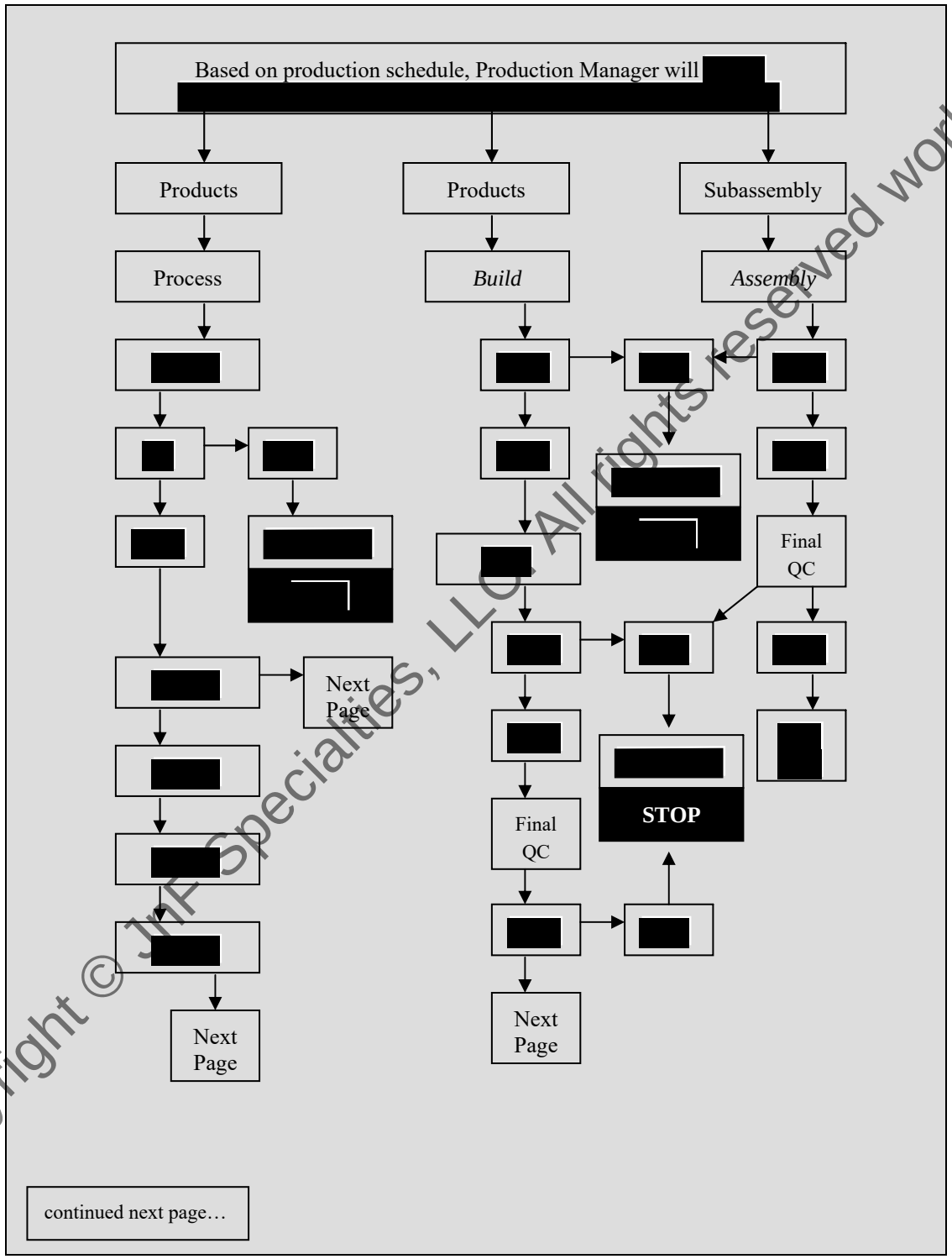

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