ALLIANCE ELECTRONICS DISTRIBUTOR

Supplier
Quality Manual

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WHEN PRINTED

INTRODUCTION

Welcome to Alliance Electronics Distributor (AED)

Alliance Electronics Distributor is a distributor of electronic components and peripherals dedicated to serving their Domestic and International customers with reliable and competitive products and services.

Introduction to Manual

In today's manufacturing environment, product that is found to be non-conforming at receiving, or during production, causes serious disruptions of the production and shipping schedules, resulting in high production costs. Even the best Receiving Inspection program cannot detect all defective material. Alliance Electronics Distributor (AED) requires suppliers to control the quality of material shipped to AED, so that AED can be confident of the product when it is received.

In order to be a preferred/acceptable provider/supplier to our customers, we must continually improve our quality levels. As part of this improvement, we must have a process in place that encourages, supports and ensures our suppliers meet quality performance expectations.

Specific strategies include:

- Long-term partnerships with our suppliers
- Close interaction among our customers engineering, manufacturing, purchasing and quality personnel and our suppliers.
- Assure compliance with ISO 9001-2015, AS9100, AS9120 (latest versions) and other industry and regulatory standards.

These manual details our needs and expectations from you – our partners in order to ensure that purchased material meets AED's requirements.

Scope

This information applies to all provider/suppliers who have interest in doing business with Alliance Electronics Distributor. It also applies to AED's possible outsourced partners and their subsidiaries.

This manual supplement the requirements stated on AED's Purchase Orders (PO) and applicable commercial and military standards, i.e. FAA, ISO 9001:2015, and AS9100/AS9120 (latest versions). These requirements are necessary to ensure that material delivered to AED by its providers/suppliers will meet or exceed required quality levels. The requirements, as listed, are based on a defect prevention system, which will improve quality, lower costs and increase productivity.

Acceptance of Alliance Electronics Distributor's purchase order is considered acceptance AED's of ***terms and conditions***.

Drawings and engineering specifications set tolerances and performance requirements. The responsibility of each provider/supplier is to ensure that those requirements are met. Alliance Electronics Distributor encourages each supplier to work toward continuous improvement in all areas regarding quality, delivery, and performance.

Alliance Electronics Distributor reserves the right to audit its suppliers for compliance with the requirements stated in this document and applicable standards. Either AED or its authorized representative may accomplish this through scheduled audits.

Alliance Electronics Distributor's Quality Policy

"Alliance Electronics Distributor, Inc. (AED) will consistently provide products and services that meet or exceed the requirements and expectations of our customers. We will actively pursue continuous quality improvement through "Plan-Do-Check-Act" (PDCA) methodology and "Risk" mitigations programs that enable AED's staff members to do their job right the first time, every time.

Quality is an internal part of our commitment to provide world-class products and customer service. We will achieve this by:

Knowing who our Customers are and what they want, AED is committed to providing the highest quality products and services, while maintaining open communications and seeking continual feedback through phone conversations, email/correspondences, Corrective Actions.

Our Quality Management System is built on the concepts of customer satisfaction and continual improvement.

To ensure this commitment, all employees are trained on this policy, which provides the framework for all other policies and procedures.

Understanding the "Risks" that are inherent to our business and the overall supply chain, while ensuring we mitigate them from the time we accept a customer's requirements to the time we deliver our products.

President/Co-President: Digitally signed by Benjamin Arnold & Richard Orshansky Date: 3/1/2018

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1.0 Quality Management System Requirements

1.1 Quality Management System

Each Alliance Electronics Distributor supplier is required to maintain an effective quality management system (QMS), preferably one that conforms to ISO 9001:2015, AS9100/AS9120 (latest version) Quality Management System – Requirements. In addition, the supplier must meet all other requirements of this manual.

1.2 Quality Manual and Procedures

The supplier, as requested, will furnish Alliance Electronics Distributor with a copy of the supplier's Quality Manual and supporting procedures. This includes detailed documents and work instructions specific to products provided to AED.

1.3 Flow-down to Sub-tier Suppliers

The supplier shall flow down to its sub-contractors all quality related requirements specified in the applicable purchase order(s) and this manual, including regulatory requirements.

1.4 Control of Sub-tier Suppliers

Suppliers are responsible for the quality of materials and components provided by their sub-tier suppliers and sub-contractors. AED suppliers must impose controls on their sub-tier suppliers that provide quality results and documentation comparable to the controls applied to suppliers by AED. The extent of the controls may vary, depending on the nature and complexity of the product and processes, but should normally include:

- Evaluation and qualification of sub-tier supplier facilities
- Control to ensure that raw materials used meet AED's requirements
- Controls to ensure that the sub-tier suppliers of components used are those approved by AED, where applicable
- Ensure that sub-tier suppliers have an ESD control program that meets or exceeds the needs of AED if the parts or materials are ESD sensitive
- Part qualification, including first article inspection and process capability studies of as applicable
- Control of drawings/revisions
- Control of nonconforming material
- Corrective action and preventive action programs
- A continuous quality improvement program
- A "Risk" management program

Where appropriate, AED may specify the sub-tier suppliers that may be used, evaluate and qualify the sub-tier supplier's facilities, and assist the supplier in controlling the sub-tier supplier. Typically, this occurs when the sub-tier supplier is an essential component of the supply-chain process. *Alliance Electronics Distributor reserves the prerogative to evaluate the quality system and records of such sub-tier suppliers as necessary. In the event of AED's involvement, it does not absolve suppliers of the ultimate responsibility for the quality performance of their sub-tier suppliers.*

2.0 Supplier Qualification Process

All suppliers of production materials to AED must be qualified suppliers. The extent of the qualification process is dependent upon the criticality of product purchased and other factors determined by AED. The qualification process in its most complete form consists of three parts:

- A questionnaire completed by the supplier.
- A quality management system self-assessment completed by the supplier, using the Alliance Electronics Distributor Supplier Assessment Survey form. This is returned, along with the supplier's quality manual and documentation for review by AED.
- An on-site assessment by AED personnel or their authorized agents.

Alliance Electronics Distributor periodically (minimum of annually) reevaluates suppliers through the use of quality performance data and/or on-site assessments.

2.1 New Supplier Questionnaire

In the early stages of the supplier selection process, potential suppliers are sent a questionnaire. This questionnaire solicits general information about the company such as location(s), size, capabilities, and financial stability as well as detailed questions regarding the Company's Quality Management System and quality history.

2.2 New Supplier Self-Assessment

When a new supplier is being considered, they are sent a Quality Management System Self-Assessment Survey form. The supplier completes the self-assessment and returns it along with a copy of their quality manual and supporting documents. Alliance Electronics Distributor will review the quality manual, procedures, and survey to determine if the documented quality system meets AED's requirements.

2.3 On-Site Assessment

For suppliers of critical components, an on-site assessment of the supplier's facility may be performed. The on-site assessment includes three components:

- A quality assessment to determine whether the supplier's quality management system is in place and functioning effectively.
- A business assessment to determine whether the supplier has financial resources, production capacity, and other business resources needed to fulfill Alliance Electronics Distributor's production needs.
- A technology assessment to determine whether the supplier has the needed technical resources, including production and inspection equipment, facilities, engineering resources, etc.

If the assessment team determines that the supplier meets AED's requirements, AED qualifies the supplier to bid on new business and supply products.

2.4 Periodic Reevaluation

Alliance Electronics Distributor periodically reevaluates current suppliers through the use of quality performance data and/or on-site assessments. If requested, the supplier shall make their facility available for on-site process verification by Alliance Electronics Distributor personnel, with reasonable notice.

3.0 Part Qualification

The supplier is responsible for submitting all First Article data if requested by AED on the first article requirements checklist. Alliance Electronics Distributor and the supplier will agree on the number of the samples to be checked and submitted with the first article data. Where possible, all First Article documents should be submitted to AED Quality Assurance Manager in electronic format (preferably Adobe Acrobat or Microsoft Office).

In some cases, AED personnel may wish to be present during the initial production run as applicable. This will allow AED to validate and verify the process before any product is shipped

3.1 First Article Requirements Checklist

For each new or changed part, AED sends the supplier a First Article Requirements Checklist, listing the steps and information that must be submitted for qualification of the component or assembly for production. The checklist items selected are based on the type of component or assembly to be supplied.

3.2 Material Certification/Test Report

When requested, the supplier must provide a material certification and/or test report. This report must include the specification number, specified material and/or physical requirements, and the inspection/test results. A simple statement that the material meets the requirements is not acceptable. Each report must be traceable to the supplier's material and must be signed by the organization that performed the testing.

3.3 Failure Modes and Effects Analysis (FMEA)

When requested, the supplier must perform a Process Failure Modes and Effects Analysis (PFMEA) and submit it for approval. For parts and assemblies that are designed by the supplier, the supplier should also perform a Design Failure Modes and Effects Analysis. The PFMEA considers all reasonably foreseeable potential failure modes of each process. Based on the potential seriousness and likelihood of a problem, the supplier develops manufacturing controls. The PFMEA should be a living document, and should be updated when process changes occur, or when defective material is produced. PFMEA methods and examples can be found in Potential Failure Mode and Effects Analysis published by AIAG.

3.4 Control Plan

When requested, the supplier must develop a control plan, and submit it for approval. The control plan is a detailed description of the supplier's proposed processing steps required to produce the part, and the controls that are put into place to control the quality at each step. The control plan must include all in-house processing, external processing, inspection, packaging, and shipping. Suppliers may use their own format. Measuring devices and fixtures designed and built to check AED's parts must be identified with a gage number and drawing and must be listed on the control plan.

The control plan must include all critical characteristics. Where detailed instructions are required, the supplier details those instructions in a work instruction, or equivalent, which must be listed in the control plan. Inspection methods, sample sizes, and sampling frequencies should be based on the process capabilities, seriousness and likelihood of potential non-conformances, and process stability. Critical characteristics that do not meet AED's process capability requirements must be inspected 100%, unless AED approves alternate control methods in writing.

3.5 Electrostatic Discharge (ESD) Susceptibility

When components or assemblies supplied to AED are susceptible to ESD, the supplier shall establish ESD susceptibility information for them. Procedures, methods, and equipment used for determining the ESD susceptibility shall be provided to Alliance Electronics Distributor. ESD failure modes shall be considered in PFMEAs, and ESD controls shall be included in control plans and packaging.

3.6 Material Safety Data Sheets (MSDS)

As applicable, Material Safety Data Sheets (MSDS) must be provided during First Article process.

3.7 Agency Approvals and Compatibility Reports

The supplier is responsible to provide the proper agency approval test reports per AED's requirement. Examples are UL, CE, FCC, TUV, etc. The supplier is also responsible for agency test reports from their sub-supplier or other outside test agencies.

The suppler is responsible to submit test results that verify compatibility as required. Testing may be done by the supplier or by a test facility certified by the supplier.

3.8 Packaging & Labeling

The supplier must adequately plan for packaging of material shipped to Alliance Electronics Distributor. The supplier will provide a documented packaging plan including container size, number of parts per container, packaging configuration, etc. Packaging will be designed to provide protection from any damage that may occur. For static sensitive components, ESD packaging shall be provided. Packaging, labeling, and shipping materials must comply with the requirements of common carriers to secure the least transportation costs.

3.9 Certificate of Conformance (C of C)

Unless otherwise specified by contract/PO, each shipment shall include certification of conformance (C of C) and/or other documentation. The supplier must provide C of C for all materials and processes specified on the purchase order or contract.

Regardless of whether or not an OEM C of C is provided with the shipment, distributors must maintain and have available C of C and/or acceptable traceability documentation to the original equipment manufacturer. Certificate of Conformance shall include as a minimum:

- Supplier name, address, and telephone number
- Part number
- Lot number, quantity and serial number (if applicable) Date code (if applicable)
- Certification references, i.e. Mil, FAA, DoD (if applicable) Statement that all parts comply with drawing, specification, Technical Order (T.O.), and purchase order requirements
- Statement of traceability for raw materials and processes to the products delivered to AED
- Legible approval signature(s), including titles, by an authorized supplier representative
- Alliance Electronics Distributor's Purchase Order number

Where required by contract or purchase order, DFAR 252.225-7014 shall apply for specialty metals.

3.10 Traceability

The supplier must plan for traceability of components. The supplier will provide a written plan specifying how components will be marked with serial or lot numbers and date codes if required, or how containers will be identified with lot numbers or date codes if component marking is not required. The plan will also include sizes of lots or batches. Where possible, batch sizes should be minimized to aid in containment should quality problems be found.

4.0 Manufacturing Control and Quality Requirements

4.1 Process Control

In order to ensure manufacturing control, the supplier shall establish and document process standards and criteria for all aspects of the manufacturing operation. These standards shall include documented route sheets and processing specifications that identify specific requirements.

The supplier shall assure that all incoming materials and components used in the manufacture of products to be delivered to AED shall be inspected, tested or otherwise verified to be conforming prior to use or processing. Non-conforming material shall be conspicuously identified and segregated to prevent commingling with acceptable material until properly dispositioned. Material that is found non-conforming can only be reworked back to drawing or specification requirements. Material that cannot be reworked will not be dispositioned as use-as-is by the supplier without written approval from AED's Quality Assurance department. Contact the AED buyer immediately should either of these dispositions be required.

Alliance Electronics Distributor encourages the use of statistical methods to control quality. Such methods include Statistical Process Control (SPC) techniques. In some cases, AED may require the supplier to submit quality control plans and process flow charts in advance of the start of manufacturing.

Alliance Electronics Distributor may require the supplier to participate in pre-production review and readiness meetings. Items covered in these meetings could include the following

- Quality Planning
- Specifications & drawing requirements
- Process flowcharts and control
- FMEA (Failure Modes and Effects Analysis)
- Risk Management
- Critical characteristic selection
- Process capabilities
- Test and Qualification
- First Article Inspection
- Metrology, gaging, and measurement methods
- Statistical Process Control
- Packaging, labeling, and delivery
- Documentation and records retention
- FAA requirements – Form 8130-3 / JAA Form 1

4.2 Statistical Process Control

Where specified in the control plan, the supplier is required to apply effective statistical process controls. Effective controls must include:

- The control chart displays control limits that are correctly calculated (specification limits may not be used as control limits).
- The control chart is at the process area, visible to the operator, or persons who are responsible for controlling the process.
- For each out-of-control condition, actions are taken to bring the process back into control. Actions taken to bring the process back into control are recorded.
- Product produced during any out-of-control condition is sorted, scrapped, reworked or dispositioned through the supplier's material review process.

4.5 Lot Control

A lot consists of product of one part number and revision that are made at the same time, under the same processing conditions, from the same lot of raw materials. The primary purpose for identifying lots is to determine the scope of actions that must be taken when problems arise during further manufacturing or with customers. Each container of material shipped to Alliance Electronics Distributor must be identified with the Supplier's lot number. Inspection records must be traceable to lot numbers.

The following are typical conditions that result in a change of lot numbers:

Change of part number or revision
Change of part number or revision of components
Interruption of continuous production (typically for more than a few hours)
Repairs or modification to the tooling or equipment
Tooling changes (other than minor adjustment or replacement of consumable tooling)
Change to a different lot of raw materials
Process changes

4.6 Traceability

Traceability ties finished product back to the components used in the product. When traceability is specified, the traceability marking should be effective down to the individual component, i.e., lot code; batch or serial should be identifiable throughout AED's processes.

4.7 Workmanship

Workmanship standards shall be in compliance with those called out on the drawing or specification, or when not stated, best available industry standard. If internal standards are developed, or industry standards are used such as ANSI or SAE, they must be compliant with invoked standards. They must also be acceptable to AED Quality Assurance Department.

4.8 Safety

At no time should any customer, or person at AED's facility, be exposed to hazardous material or situations that are not inherent in a component's structure. Residues, films, out-gassing products and packaging materials should comply with OSHA (Occupational Safety & Health Association) standards. For items with inherent hazards, safety notices must be clearly observable. As applicable, MSDS sheets must be provided during the First Article process.

4.9 Maintenance

The supplier must maintain all facilities, manufacturing machines, tools, measuring devices, and other equipment in such a manner that the supplier can support AED's product requirements, and the quality of parts manufactured for AED is not degraded in any way.

4.10 Electrostatic Discharge (ESD) Controls

If the supplier furnishes ESD-sensitive materials, the supplier must maintain an effective ESD program that meets all requirements for the material produced.

5.0 Drawings/Changes

5.1 Drawing and Change Control

The supplier must have a documented system for assuring that the latest AED drawings are in effect at their facility. The supplier's quality management system must contain a documented procedure that describes the method used for the receipt, review, distribution, and implementation of all changes to drawings and specifications. In addition, the procedure must address control of obsolete drawings and specifications. A documented procedure should also detail the method used to contain new or modified parts until approved by the customer.

5.2 Process Changes, Engineering Changes

Suppliers must have systems in place to control changes to drawings, specifications, processes, or produced parts. Systems should be capable of handling changes being requested by AED or its customer.

NOTE: The First Article approval process is directed at a given part number for a specified revision level produced in a specific area of the manufacturer's facility. **Suppliers may not make any changes in their process, location, material, or to the part without written approval from Alliance Electronics Distributor.** The supplier must formally request a process change on all AED components.

5.3 Supplier Process Change Request (SPCR)

A Supplier Process Change Request (SPCR) is used to request a change to a released part, process, drawing, or specification. Alliance Electronics Distributor encourages SPCRs for process improvement with the stipulation that before an SPCR is submitted, the supplier thoroughly reviews their FMEA and control plan to assure that all process-related issues have been addressed and resolved.

The originator of an SPCR includes the following information:

- Drawing or part number
- Drawing or part title
- Description of problem or recommended change
- Reason for change or "rationale"
- Proposed effective date

The supplier submits the SPCR with the revised FMEA and control plan (if applicable) to AED for evaluation of the following:

- Supplier-demonstrated process capability and stability
- Comparison to First Article data
- Industry standards

- Supplier process engineering capabilities
- Supplier's adherence to control plan

After AED has completed the review, and concurs with the supplier, AED will notify the supplier as to the final disposition of the SPCR and part submittal requirements and dates.

When monitoring is required, the appropriate markings must be identified on the lots etc. for a specified time frame as decided jointly with AED and the supplier.

5.4 Supplier Deviation Request

A supplier is never permitted to knowingly ship product that deviates from the print, specification limits, or design intent without written authorization from AED. If such a condition exists, the supplier may request Alliance Electronics Distributor to allow shipment of the product. This is accomplished by initiating a Deviation Request.

If directed by AED, the supplier must send samples of non-conforming items to AED or its customer for evaluation. The cost of any testing required to determine the acceptability of the product will be charged to the supplier. Alliance Electronics Distributor will determine the item's acceptability and what corrective actions (if any) are required beyond the deviation. If approved, AED will send a written deviation approval to the supplier.

The deviation is only intended to be an interim action and **is not** to be construed as an engineering change. The supplier must begin work immediately to correct the condition in question. This must be accomplished within the time frame stated on the deviation. Failure to comply with the mutually agreed upon closure date for the deviation may result in the supplier's rating being affected.

In all cases, the supplier must fully contain all product suspected of being non-conforming at their facility.

Any parts sent to Alliance Electronics Distributor that have been approved on a Deviation must be clearly identified on the box, container, or other packaging method with the appropriate markings decided jointly by AED and the supplier.

6.0 Packaging & Labeling

6.1 Packaging

Each supplier must adequately plan for packaging. Alliance Electronics Distributor encourages supplier-initiated packaging improvements. Suppliers will provide packaging that provides protection from any damage that may occur. Packaging, labeling, and shipping materials must comply with the requirements of common carriers, in a manner to secure the lowest transportation costs.

Packaging for ESD sensitive items must meet appropriate ESD packaging requirements. Contamination is a serious concern to AED. Packaging must protect the components from contamination, including fibers and Foreign Object Debris (FOD) from the packaging materials.

Expendable materials and packaging must be legal and safe for standard "light industry" disposal. The preferred maximum weight of manually handled packs is 40 lbs. The maximum acceptable weight is 45 pounds, unless approved by Alliance Electronics Distributor in writing.

Whenever possible, only one part number and one supplier lot is to be packaged in a shipping container. When more than one part number or lot number is packaged in a shipping container, each part number and/or lot number must be separately packaged (i.e. bags or boxes) inside the container, with each labeled as to the contents.

6.2 Labeling

Each shipping container or inside package must contain the following information:

- Manufacturer part number (if no manufacturer part number exists, supplier part number is used)
- Quantity
- Supplier's Name
- Purchase Order Number
- Lot identification (if required)
- Required ESD Susceptibility Label on packaging for ESD sensitive items, using the Electronic Industries Association Standard EIA-471 symbol or equivalent.

7.0 Corrective Action System

Alliance Electronics Distributor requires suppliers to utilize a closed-loop corrective action system when problems are encountered in their manufacturing/distribution facility, or after nonconforming product has been shipped to AED. Alliance Electronics Distributor may request that a supplier take corrective action via a written Provider Corrective Action Request (PCAR). A PCAR may be initiated by the rejection of material at AED or may be based on a trend or repeated rejections or failures

7.1 Corrective Action Process Approach

The corrective action system utilized should be similar to the process outlined below. The focus should be on identifying the root cause(s) of the problem and taking action to prevent its recurrence.

- Use a team approach
- Identify the risks and opportunities identified during the planning process
- Describe the problem
- Contain the problem
- Identify and verify root causes(s)
- Determines if flow down corrective action is required from an external provider – if one is responsible for the nonconformity
- Implement permanent corrective actions
- Verify corrective action effectiveness
- Close the corrective action

7.2 Provider/Supplier Corrective Action

Alliance Electronics Distributor issues a Provider Corrective Action Request (PCAR) to a supplier when non-conforming parts are found at incoming inspection, in test, or by an AED's customer. They can also be issued as a result of a supplier audit. The supplier is required to respond by returning the PCAR back to AED within fourteen (14) business days or sooner. The following provides a brief outline of the PCAR procedure that suppliers to AED should comply with:

- Alliance Electronics Distributor requires that the supplier take immediate containment action upon notification of the nonconformance. The supplier must submit a written response to AED, reporting the Supplier's initial observation and defining the interim containment plan within three (3) business days of notification. The Supplier's Initial Observation is an acknowledgement that the Supplier has been informed of the problem and has begun to gather information about the problem.

- The containment plan must clearly define the containment actions at the supplier's facility to assure that no nonconforming product is shipped to AED. If suspect (SUP) product has already been shipped, the supplier must address all SUP stock in transit and any stock at AED. The supplier will assist AED in identifying customer "Risk" by identifying all SUP lot numbers and associated quantities involved.

- Within one (1) weeks after the original notification, the supplier must report the results of the Supplier's investigation into the cause of the problem.

- Within two (2) weeks from the initial notification date, the supplier must submit the corrective action to be taken to prevent recurrence of the problem, and the effectivity date (the date the corrective action will be implemented.). Actions such as "train the operator," "discipline the operator," or "increase inspection," are typically not acceptable corrective actions.

- The supplier is required to keep AED informed of progress towards implementing the corrective action. When corrective action implementation is complete, the supplier and AED verify that the corrective action is effective in preventing the problem's recurrence.

8.0 Supplier Monitoring

Alliance Electronics Distributor continually monitors its suppliers to ensure they continue to meet AED's requirements, and to ensure that the supplier continues to ship acceptable parts. This may consist of:

- A quality management system surveillance audit at the supplier's facility
- An on-site audit of the supplier's control plan
- A random incoming inspection audit of a batch of product
- Source inspection of product at the supplier's facility
- Nth Article Inspection
- Review of supplier-furnished data packages
- A supplier progress review meeting conducted periodically at the supplier's site or AED to review supplier performance and progress

8.1 Supplier Audits

Periodically, Alliance Electronics Distributor may audit the supplier's QMS. The supplier must make their facility available for on-site process verification by AED personnel at any time, with reasonable notice. This may be a full or abbreviated documentation and on-site audit. The purpose is to evaluate any changes that may have occurred in the supplier's quality management system, and to assess the supplier's continuing commitment to quality improvement.

Periodically, AED may also audit the supplier's continuing conformance to the control plan approved in the First Article process when applicable.

8.2 Supplier-Furnished Lot Documentation

Alliance Electronics Distributor may require the supplier to furnish inspection, test, process performance, or other quality data with each shipment to ensure that the product meets AED's requirements. When data submission is required, the data must accompany each shipment, or be e-mailed or faxed to AED at the same time the lot is shipped. All documentation must be clearly identified with AED's or its customer's part number, and the supplier's lot number.

9.0 References

- AED QM-9120-B Quality Manual
- ISO 31000 Risk Management-Principles and Guidelines
- ISO 9001-2015 Quality Management System
- SAE AS9120B Quality Management Systems - Requirements for Aviation, Space and Defense Distributors.

10.0 Revisions

Revision	Date	Section	Paragraph	Summary of change	Authorized by
A	**07/07/18**			**Initial issue; Replacement of ISO9001:2008 Quality Management System with initial release of AS9120:2016 Rev B 07/07/2018**	**JT**

Appendix 1

C = 0 SAMPLING PLAN

	.010	.015	.025	.040	.065	.10	.15	.25	.40	.65	1.0	1.5	2.5	4.0	6.5	10.0
LOT SIZE	**SAMPLE SIZE**															
2 to 8	*	*	*	*	*	*	*	*	*	*	*	*	5	3	2	2
9 to 15	*	*	*	*	*	*	*	*	*	*	13	8	5	3	2	2
16 to 25	*	*	*	*	*	*	*	*	*	20	13	8	5	3	3	2
26 to 50	*	*	*	*	*	*	*	*	32	20	13	8	5	5	5	3
51 to 90	*	*	*	*	*	*	80	50	32	20	13	8	7	6	5	4
91 to 150	*	*	*	*	*	125	80	50	32	20	13	12	11	7	6	5
151 to 280	*	*	*	*	200	125	80	50	32	20	20	19	13	10	7	6
281 to 500	*	*	*	315	200	125	80	50	48	47	29	21	16	11	9	7
501 to 1200	*	800	500	315	200	125	80	75	73	47	34	27	19	15	11	8
1201 to 3200	1250	800	500	315	200	125	120	116	73	53	42	35	23	18	13	9
3201 to 10,000	1250	800	500	315	200	192	189	116	86	68	50	38	29	22	15	9
10,001 to 35,000	1250	800	500	315	300	294	189	135	108	77	60	46	35	29	15	9
35,001 to 150,000	1250	800	500	490	476	294	218	170	123	96	74	56	40	29	15	9
150,001 to 500,000	1250	800	750	715	476	345	270	200	156	119	90	64	40	29	15	9
500,001 and over	1250	1200	1112	715	556	435	303	244	189	143	102	64	40	29	15	9

***Indicates entire lot must be inspected**
NOTE: The Acceptance Number in all cases is ZERO.