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The following clauses always apply unless stated otherwise on our purchase order.

QC1 - Inspection and Quality System Requirements

Supplier shall have an Inspection System conforming to the requirements of ISO 9001 and/or AS9100/9120 (latest revisions). Manufactures and suppliers shall develop inspection procedures and maintain records of inspection. Records shall include evidence of inspection for all attributes (i.e. first article inspection manufactures only) of products/processes supplied to Altemp Alloys. The inspection system shall evaluate products/processes to insure that only materials/services that conform to purchase order requirements are delivered to Altemp Alloys.

QC2 - Substitution

No substitution of material, specification, size or any other nature will be allowed except by amendment on Altemp Alloys, purchase order in writing.

QC3 - Counterfeit Material

Seller shall establish and maintain a counterfeit material prevention / avoidance and control plan and flow down any applicable Altemp Alloys and or customer requirements to any sub tier suppliers including counterfeit material reporting seller also agrees and shall ensure that counterfeit material is not delivered to Altemp Alloys. In the event that counterfeit material is delivered to Altemp Alloys seller shall, at its expense, promptly replace such counterfeit material with genuine material conforming to the requirements of this contract. Notwithstanding any other provision in this contract, seller shall be liable for all costs relating to the removal and replacement of counterfeit material, including without limitation Altemp Alloys costs of removing counterfeit material, of reinserting replacement work, and of any testing necessitated by the reinstallation of material after counterfeit material has been exchanged. This provision also applies to seller's sub-tiers.

QC4 - Record Retention

Suppliers shall retain verifiable objective evidence of build, inspection & test records, special process certifications, raw material certifications and certificates of conformance for a minimum of ten (10) years from date of shipment, unless a time period is otherwise specified on the purchase order as directed by our customer. The data shall be made available to Altemp Alloys upon request. The supplier will not destroy records associated with any purchase order issued by Altemp Alloys, without 30-day prior written notice to the Quality Manager of Altemp Alloys.

QC5 - Nonconforming Product


Suppliers shall assure that product that does not conform to specified requirements is not shipped to Altemp Alloys.

Dispositions of "Use as Is or Repair" for products under Altemp Alloys customer design control shall require written authorization prior to shipment from Altemp Alloys Sales Manager or General Manager.

QC6 - Approved Special Process Source

Altemp Alloys only customer approved special processors shall be used on this purchase order. When applicable the processor and/or customer information will be flowed down to the supplier.

The use of Altemp Alloys customer approved supplier does not relieve the supplier from responsibility to furnish acceptable product and when applicable will be flowed down on our purchase order.

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QC7 - Supplier Control

Suppliers, including distributors, are responsible for ensuring that the applicable requirements of Altemp Alloys purchase orders are imposed on sub-tier suppliers for raw material, components or processing services being used in the manufacture of products or services being provided. As well as ensuring that suppliers and their sub tier are aware of their contribution to product and service conformity, their contribution to product safety, and the importance of ethical behavior.

QC8 - Prohibited Sources

Altemp Alloys suppliers and/or sub-tier suppliers are prohibited from using any source listed on the U.S. government Excluded Parties List System (EPLS) by locating the company in search at www.sam.gov/portal in the production of products to be delivered to Altemp Alloys.

QC9 - Right of Entry

Altemp Alloys party auditors, our customers and relevant regulatory authorities will have access to supplier's, and all other facilities involved in the purchase order, where they will have access to all procedures, practices, processes, associated documents and records related to quality assurance, quality control and configuration control. Altemp Alloys reserves the right to determine and verify quality of work, records and material.

The supplier shall notify Altemp Alloys of any change in the location of supplier's facility.

QC10 - Responsibility for Conformance

Acceptance of product shall not be used as evidence of effective control of quality by the supplier, and shall not absolve the supplier of responsibility for acceptable products or preclude subsequent rejection by Altemp Alloys or its customers.

QC11 - Industry Specifications and Standards

For all Military, Federal, and Industry specifications and standards, the supplier shall comply with the revision in affect at the time Altemp Alloys purchase order is issued.

QC12 - Calibration System


Calibration of measuring and test equipment used for product acceptance shall be traceable to established international or national measurement standards. Procedures for periodic calibration, certification and maintenance of tools and equipment shall be established and followed.

Measuring and test equipment supplied or serviced under this purchase order shall be calibrated in accordance with Military Specification MIL-STD-45662 'Calibration System Requirements', or in accordance with ANSI/NCSL Z540-1.

QC13 - Key Characteristic

When applicable the seller shall maintain applicable statistical control charts for key characteristics identified by the customer drawings.

A copy of the key characteristics statistical control charts must accompany all items in the shipment to Altemp Alloys.

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The seller shall flow down to sub-tier suppliers the applicable requirements in the purchasing documents, including key characteristics where required.

QC14 - Statistical Techniques

Suppliers are responsible for understanding and reducing variation within processes and are encouraged to use control-charting techniques.

When control charting is not performed, sample inspection of all attributes shall be performed to ANSI/ASQ Z1.4, (MIL-STD-105).

QC15 - Report of Discrepancy

Any departure from drawing specifications or other purchase order requirements must be documented by the seller and submitted to Altemp Alloys for review and disposition. A copy of this disposition document, stating rejection or approval, must accompany each affected shipment.

QC16 - Report of Escape

The seller upon discovery of a shipment/delivery of nonconforming product must provide a notice of disclosure to the Altemp Alloys within 24 hours of discovery.

QC17 - Certificate of Compliance/Conformance


Seller shall provide with each shipment one copy of a certified statement that the goods furnished on the purchase order meet Altemp Alloys specification requirements as stated on the purchase order and/or drawing(s) provided. At a minimum, the Certificate of Conformance must contain the following information as it applies to the product(s) being certified:

- Alloy name
- Heat Number and/or serial/lot number
- Drawing number and revision date if applicable
- Producing mill source and melt source, if different
- Country of origin for melt and producer
- Quantity of items (pieces, footage, pounds, etc.)
- Altemp Alloys purchase order number
- Specifications and grade to which the product was purchased
- Conflict Free Minerals Statement
- Seller's name and address
- Signature and title of recognized quality assurance representative

Acceptance of product at Altemp Alloys is contingent upon receipt of a Certificate of Conformance, which contains the above referenced requirements. Certificate of Conformance under this requirement shall not be used in lieu of other requirements for test reports specified by this purchase order. Failure to supply certifications which comply with the above requirements may result in a delay of payment and/or rejection of material.

QC18 - Mill Test Reports

Supplier shall furnish two clear and legible sets of a certified copy of the original mill test report showing specific results of chemical and mechanical analysis on each heat of material supplied on

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Altemp Alloys, purchase order. Test reports that are “chemistry only” require approval in writing from Altemp Alloys buyer. A mailed copy is only required when asked on our purchase order.

QC19 - Aluminum Chemistry

Aluminum raw material test reports must reflect actual chemistry not minimum/maximum.

QC20 - Processing Test Report

Processor must include our customer’s purchase order number, part number, and test piece size used in testing. These are to be identified on all processing test reports and flowed down if an outside source is used.

QC21 - Furnace Charts

For each heat number processed, the processor shall furnish time and temperature charts representing the heat treating or brazing operations performed.

QC22 - Heat Lot

Only one heat number/lot per line item unless otherwise specified. If multiple heat lots are approved on one-line item they must be marked and clearly segregated.

QC23 - Material Safety Data Sheet

Supplier shall provide a current material safety data sheet specific to the product purchased.

QC24 - Delivery

The “due” date shown on Altemp Alloys purchase orders are the on dock dates. We measure suppliers for on-time delivery and quality. For your convenience we accept shipments up to 3 days prior to the on-dock due date.

Receiving Hours: M-F 7:00 a.m. to 3:00 p.m.

Maximum weight on skids 4500 pounds, loading dock access


Shipments under 150Lbs and 109” in length are to ship via ground. FedEx Ground Acct# 699355216, UPS Acct# 867722, any other shipments contact Logistics@altempalloys.com for routing instructions.

QC25 - DFARS - Metal/Raw Material Requirements

All raw material shall be provided from a domestic or qualified country melt source (DFARS 252.225-7012).

QC26 - Test Coupon

Supplier provided test coupons are to be a representation of the material, and condition as per Altemp’s purchase order requirements.

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QC27 - Identification for Product

Where impractical to stencil material due to size or shape of the alloy, a tag may be attached to the product listing all pertinent information such as; alloy type, specifications, conditions/temper, nominal thickness, heat/batch numbers and ingot number where applicable to ensure traceability. Do not place any markings on material with the vendor name unless the vendor is a mill.

QC28 - Mill Stencil

Raw material shall be stenciled with alloy, specifications, conditions/temper, nominal thickness, heat/batch numbers and ingot number where applicable to ensure traceability. Do not stencil our purchase order number on material.

QC29 - Preservation of Product

The mill/supplier/processor shall package, protect and preserve the product against the hazards of corrosion, contamination, damage, and deterioration during the production and at the Seller’s facility and during processing, while in transit, and prior to delivery to Altemp Alloys in order to maintain conformity to requirements.

Preservation of product shall include, where applicable in accordance with product specifications and applicable statutory and regulatory requirements.

Preservation of product will also include but is not limited too clean free of oil, dirt, rust, etc., prevention, detection and removal of foreign objects; chips, corrosion, labels, etc. Evidence of flaws, mishandling (scratches and/or dings) or abuse shall be cause for rejection.

All material delivered on the purchase order shall be packed with suitable protection to prevent damage and deterioration while stored at Altemp Alloys. Sheet product must be paper interleaved to protect from scratches.

Side board edges are to be used, and skids or pallets will be 1” wider than the product to avoid edge damage.

QC30 - Coils


Coiled material shall be identified by a method integral to the core and which is visible until the material has been completely removed from the core. The identification shall include alloy type, specifications, conditions/temper, nominal thickness, heat/batch numbers and ingot number where applicable to ensure traceability. Altemp Alloys does not pay for cores. Each core will be wrapped individually with at least 3 straps to hold while transporting to avoid unraveling.

QC31- Aerospace Quality

Material provided under this purchase order shall be produced as aerospace quality. When commercial quality applies the purchase order will state “Commercial Grade is acceptable.”

QC32 - Purchase Order Acknowledgement

Seller is required to promptly acknowledge Altemp Alloys purchase order in writing to ensure all parties involved are in agreement to eliminate waste and ensure customer satisfaction and email to the buyer of Altemp Alloys. Email is the first name of the person @altempalloys.com

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QC33 - Thickness

Product thickness quoted and purchased shall be on the test report. Product thickness that does not match thickness ordered will be rejected at seller’s expense.

QC34 - Conflict Minerals

Altemp Alloys will not accept material procured from conflict areas. Ensure your product is conflict free prior to shipping.

QC35 - Changes to supplier

A change in supplier name, ownership, facility relocation, or loss of 3rd party certification or adverse actions taken by the government will subject the supplier's Quality System to reevaluation by Altemp Alloys.

The supplier shall notify the Quality Manager of Altemp Alloys of any of these aforementioned changes in writing. Altemp Alloys will instruct the supplier on formal actions necessary for review.

QC36 - Corrective Action


The supplier shall respond to all requests for corrective action on or before the requested response due date noted on the NCR. Suppliers that do not respond to NCRs may be removed from the Approved Supplier List.

QC37 - Source Inspection

Source inspection is to be performed on this purchase order prior to shipment to Altemp Alloys. Inform the Buyer at Altemp Alloys when the product is ready for source inspection. The Buyer will arrange the dates and times for inspections.

QC38 - Wire & Cable

All wire and cable product purchased must be spooled on a reel.

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Type of Document		Work Instruction
Rev Date	Rev Letter	Revision History
7/6/2010	NC	Initial Release
4/10/2013	A	Revised adding when it applies
6/5/2015	B	Added additional clauses; "removed when it applies" because it all applies unless stated on PO; added fax number and freight account numbers
8/10/2017	C	Updated to meet AS9100 Rev D requirements
6/4/2020	D	Flow Down Requirement for Counterfeit Materials
6/01/2021	E	Revised for name change
6/17/2024	F	Full revision