



REVISION HISTORY			
REV	DATE	ORIGIN	REASON FOR CHANGE(S)
A	12Feb18	Paul Gettins	New
B	5/04/18	Daniel Crouse	Added PCN language

Q-CODE Q44E QUALITY REQUIREMENTS
MATERIAL/WELD/COATING/TEST/DIMENSIONAL

With acceptance of/or receipt of product against this order the supplier agrees to allow Plexus, their customer and regulatory authorities the right of access to their facility and all applicable records. The following are the quality requirements for product purchased under Q-code Q44D. Unless a written waiver is received from Plexus, the supplier agrees to abide by the quality requirements listed below. Plexus will only give a written waiver after notifying and obtaining approval from the customer authorized person and Certified Body.

Pre-1st Shipment (Part Number or Revision change) - Before a product will be released for production the supplier will be required to meet the documentation and quality requirements as follows:

- A. First Article Inspection Report - All dimensions must be within print tolerance. Any dimension which is not within print specification must be approved by Plexus in writing before product can be shipped.
- B. Supplier Master Document List (SMDL)
- C. Manufacturing Record/Data Book
- D. EN10204 Type 3.1 Material Inspection Certification must detail the following:
 - Name of Material Supplier
 - Material Suppliers part number
 - Details of the Test/Inspection Results
 - The Lot # and Date Code or Serial numbers for each shipment
 - A statement of Compliance to specification
 - Signed and dated by an authorised inspection representative independent of the manufacturing department.
- E. Welding Documentation
 - Welder Approval/Qualification Record (WAR/WQR)
 - Welding Consumable/Filler Metal Test Certificate
 - Welding Procedure Approval/Qualification Record (WPAR/WPQR)
 - Welding Procedure Specification (WPS)
- F. Non-Destructive Testing/Examination
 - Penetrant Test (PT) Report – Weld
 - Ultrasonic Test (UT) Report – Weld
 - Non-Destructive Testing or Examination (NDT/NDE) Operator Qualification
- G. Painting/Coating Documentation
 - Paint/Coating/Lining Certificate/Report
- H. Pressure Testing

*Notice: This document is considered "UNCONTROLLED" when it exists in any printed form. See the Partner Portals - Supplier section of the Plexus Web page for the current master of this Q-code.

- Leak Test Certificate/Report
- I. Certificate of Conformance (COC) must also include the following:
- Name of Manufacturer/OEM/OCM
 - Manufacturer's/OEM's/OCM's part number when required
 - Plexus part number
 - Revision or EC level if applicable
 - Quantity
 - Purchase order number
 - Lot # and Date Code ₁ or Serial numbers for each shipment
 - A statement of Compliance specifying compliance to the following:
 - The drawings and specifications provided by Plexus
 - The requirements of the specific PO
 - Signed and dated by an authorised representative

¹ The minimum-required date code format shall identify the 2-digit workweek, 2-digit year (WWYY). If the component marking contains a lot and date code, then those markings must be traceable to the COC.

All cartons, required documentation, labels, packaging and packing slips must have part number, EC level or revision, quantity and P.O. number listed on them.

Subsequent Shipments-The documentation and quality requirements for all subsequent shipments will be as follows:

- A. Critical Dimensional Report – For all subsequent Shipments, a full dimensional report with all critical dimensions documented and within print tolerance. Any dimension which is not within print specification must be approved by Plexus in writing before product can be shipped.
- B. Manufacturing Record/Data Book
- C. EN10204 Type 3.1 Material Inspection Certification must detail the following:
 - Name of Material Supplier
 - Material Suppliers part number
 - Details of the Test/Inspection Results
 - The Lot # and Date Code or Serial numbers for each shipment
 - A statement of Compliance to specification
 - Signed and dated by an authorised inspection representative independent of the manufacturing department.
- D. Welding Documentation
 - Welder Approval/Qualification Record (WAR/WQR)
 - Welding Consumable/Filler Metal Test Certificate
- E. Non-Destructive Testing/Examination

- Penetrant Test (PT) Report – Weld
 - Ultrasonic Test (UT) Report – Weld
 - Non-Destructive Testing or Examination (NDT/NDE) Operator Qualification
- F. Painting/Coating Documentation
- Paint/Coating/Lining Certificate/Report
- G. Pressure Testing
- Leak Test Certificate/Report
- H. Certificate of Conformance must also include the following:
- Name of Manufacturer/OEM/OCM
 - Manufacturer's/OEM's/OCM's part number when required
 - Plexus part number
 - Revision or EC level if applicable
 - Quantity
 - Purchase order number
 - Lot # and Date Code ₁ or Serial numbers for each shipment
 - A statement of Compliance specifying compliance to the following:
 - The drawings and specifications provided by Plexus
 - The requirements of the specific PO
 - Signed and dated by an authorised representative

₁ The minimum-required date code format shall identify the 2-digit workweek, 2-digit year (WWYY). If the component marking contains a lot and date code, then those markings must be traceable to the COC.

All cartons, required documentation, labels, packaging and packing slips must have part number, EC level or revision, quantity and P.O. number listed on them.

Shipments of multiple lot and/or date codes must be identified separately on the DOC with the actual quantity shipped for each. Each lot and/or date code shall be independently packaged (i.e., no mixed lot/date codes within a package: reels, trays, tubes, bags, etc.).

Material received without the completion and proper execution of the Quality Requirement allows Plexus the right to return the material as defective. For material that has been previously provided to Plexus, the requirements under subsequent shipments will be followed.

Product change notification

Upon acceptance of conforming product, documentation, and the requirements of this Q-code, the supplier's manufacturing process shall be considered "qualified". All changes require written approval from Plexus prior to implementation. Product or Process change notification requests (PCNs) shall be submitted to pcns@plexus.com.