

Standard Operating Practice S.O.P. No. 52-10-005.2-00-004

SINGLE SUPPLIER PROCUREMENT

1.0 PURPOSE

To establish procedures for control of parts machined complete from castings herein referred to as raw material purchased by the supplier. This supplier can be an Eaton raw material or machining supplier.

2.0 SCOPE

Procurement procedure for parts where a single supplier provides castings, machining and other processing. Applicable to all parts purchased in this manner.

3.0 APPLICABLE DOCUMENTS

<p>QCP 5.5 SOP 52-10-005.3-00-004 ARG-994-123</p>	<p><u>Certified Supplier Program</u> <u>Material Testing and Acceptance Procedure</u> <u>Source Inspection (Card)</u></p>
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4.0 PROCUREMENT

- 4.1 ATC Purchasing or Planning may select a part to be procured per this method. This type of procurement shall only be considered for production released castings, where the tooling and process have been qualified and approved by Eaton.
- 4.2 When parts are selected to be purchased per this procedure, a purchase requisition (Form ARG 2654) shall be initiated reviewed by Supplier Quality and processed.
 - 4.2.1 Casting VQR part number, change letter and date shall be listed in the comment section of the requisition. The casting VQR shall be linked to the finished part number in WDS through the ENG 8 screen.
 - 4.2.2 Finished part VQR part number, change letter and date shall be listed in the "VQR" block of the requisition.
- 4.3 The purchase order line item(s) for casting test material shall list the delivery bay locations (field #315) as "AA-5"
 - 4.3.1 The descriptive text for the test material line items shall state the description of the material and the casting part number (e.g. "test material for P/N 216XXX")
- 4.4 The purchase order line item for finished parts shall list the delivery bay location (field #315) as RI for certified machining suppliers.

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8/20/08	- J Revised complete 09/11/12
Prepared by	Approved by
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5.0 PURCHASING

5.1 It shall be the Purchasing Agent's responsibility to direct the supplier regarding the requirements of this S.O.P. including the prime contracted suppliers responsibility for flowing down requirements to sub tier suppliers (e.g. blueprints, Vendor Quality Requirements (VQR), Part Revision Status Sheet(s) (if applicable), Approved Vendor List (AVL), Special Process List (SPL) and applicable specifications).

6.0 CASTING SUPPLIERS RESPONSIBILITY

6.1 **For Noncertified Casting Suppliers.** Eaton will source inspect each raw material lot at the casting supplier, unless otherwise specified. The source inspector shall verify acceptance of all certifications and audit radiographs as well as inspection of the parts in accordance with the receiving inspection S.O.P.

6.1.1 Eaton source inspectors will not evaluate parts unless the complete test material package is presented with the parts.

6.1.2 Sample sizes and characteristics in the S.O.P. are those that Eaton has determined require inspection based on historical data, process limitations, previous problems or customer requirements. This inspection does not guarantee that latent defects or discrepancies on parts that were not included in the sample inspected will not be uncovered during machining.

6.1.3 The integrity of the lot remains the prime suppliers' responsibility.

6.2 **For Certified Casting Suppliers.** the Designated Supplier Quality Representative (DSQR) shall perform the functions in accordance with QCP 5.5. The DSQR stamp on casting certifications shall be substituted for the source inspection card Form ARG-994-123.

6.3 The Source Inspection Card (form ARG-994-123) or the DSQR stamp on casting certifications shall be the evidence of Eaton, FSD, Euclid casting approval. These shall be included with the test material package and parts from supplying foundry.

6.4 When the casting supplier is the prime, test material, X-Ray film and one copy of certifications (test material package) shall be shipped to within 10 working days after casting source inspection. It will be the prime vendor's responsibility to assure that the test material package is complete.

6.4.1 When the machining supplier is the prime, the test material, x-ray film and one copy of certifications (test material package) package shall be shipped to Eaton within 15 working days of casting source inspection.

6.4.2 Packing slips for the test material package shall indicate the Eaton purchase order and test material line item(s).

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7.0 PRIME SUPPLIERS RESPONSIBILITY

- 7.1 All MRBA actions are processed through the prime supplier. The purchase order for the finished parts shall be on the MRBA.
- 7.2 Assure all serial numbers of the castings match the serial numbers listed on the raw material certifications.
- 7.3 Assure that the material was accepted by the source inspector (source card ARG-994-123, shall accompany test material package) or DSQR (designated supplier quality representative). A “DSQR” stamp on first page of the certification is evidence of acceptance.
- 7.4 Assure that Raw Material “test material package” (certifications, test material and x-rays) is sent to Casting/Forging Receiving Inspection for processing. The source card shall be included, if applicable.

Note: The packing slip for raw material test package shall include the finished part purchase order number and line item number for the casting test material. If the raw material test package is shipped directly from the foundry, the foundry must be instructed to include the above information.

- ∅ 7.5 Standard hardware (pins, inserts, etc.) when not provided by Eaton shall be purchased from a distributor listed on the Eaton, FSD Euclid Approved Vendor’s List (AVL).

8.0 MATERIALS ACCEPTANCE OF FINISHED MACHINED PARTS

- 8.1 Finished parts acceptance shall be in accordance with the Material Testing and Acceptance SOP 52-10-005.3-00-004.