QUALITY CONTROL REQUIREMENTS
FOR PROCURED MATERIALS
(Taken from EB2678M)

OVERVIEW

It is the responsibility of the supplier to transmit those portions of the purchase order that are applicable, including the substance of this specification to any and all sub-tier suppliers via a purchase order or some other contractual means.

Establish and maintain a Quality System, which will assure the quality and adequacy of the item or service provided. A quality system refers to the activities carried out within an organization to satisfy the quality expectations of its customers to include an adequate calibration system. It is preferred that your Quality System meets one of the following:

- ISO 9000 Quality Models as modified by Supplemental Technical Requirements (STRs), (See Standard Clauses 60-5, 60-19 & 60-58)
- MIL-I-45208 Inspection system Requirements
- MIL-Q-9858 Quality Program Requirements

Appendix A (omitted)

Appendix B

To assure compliance with the laws governing fraud, falsification and the like (such as US Code Title 18, Part I, CH 47, Sec. 1001) it is recommended that all Suppliers, including their sub-tier Suppliers implement a fraud & falsification and malpractice prevention program.

Appendix C (omitted)

Appendix D

Provides an example of Malpractice Notice suitable for posting.

Appendix E

Provides supplemental requirements for Forging operations

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1.0 REQUIREMENTS

1.1 Order of Precedence

In the event of any inconsistency in the ordering data, the inconsistency shall be resolved by giving precedence in the following order:

1. The Purchase Order (PO)
2. PO supplement.
3. The Drawing
4. Component Specification (Customer Specification)
5. Primary Reference Specifications and Standards (e.g. Military and Federal Specifications)
6. Sub-tier Specifications (e.g. Commercial Specifications)

If any discrepancy, differences or conflict exist between the ordering data and the drawings and specifications or between the drawings and specifications; a written inquiry is to be submitted to resolve the conflict, and the seller shall not proceed except at its own risk.

1.2 Specification Effectivity

Requests to use earlier or later revisions of the sub-tier specifications must be submitted in writing.

1.3 Forms

a) **Vendor Information Requests (VIR)**

Requests for interpretation or clarification of any purchase order requirements, changes to drawings or specifications, and/ or requests for acceptance of a non-conforming conditions and repair welding authorizations (when required) shall be submitted in writing

b) **Vendor Procedure Approval Request (VPAR)**

All NDT (LP, MP, UT, VT, RT), Alloy Identity, Welding and Brazing production and repair and special processes (e.g. forging, 1st Article) must be performed in accordance with approved written procedures.

These procedures shall be submitted to Advex for approval. This shall be submitted and approved **prior to** performance of the applicable task. Failure to comply will be cause for rejection.

c) (omitted)

2.0 DOCUMENTATION/OFFICIAL RECORDS

2.1 Official Records

Official records are records that substantiate conformance to contractual requirements, including data entered into automated systems. All entries on official records shall be legible and documented with an instrument that provides a permanent record (e.g. ink pen). Authorized personnel signing official records shall be designated in writing by the Supplier. This authority may be granted by title or name. (e.g., QC Manager, Chief Metallurgist, Mr. John Doe, etc.)

2.2 Documentation

a) Signatures/Initials/Badge Numbers/Inspection Stamp on official records are verification that the action identified has been performed in accordance with requirements and the results are as recorded.

b) Certifications shall be based on personal observations, other certified records, or direct reports from assigned personnel. Original raw inspection data sheets shall be retained when data are transcribed or summed on other forms.

c) When a person, other than the one who performs the inspection or test activity, signs a quality document, they must indicate for whom they are signing (e.g. J. W. Brown (signature) for D.W. Smith (printed)).

d) Material certification data (chemical analysis, mechanical and physical testing) must be recorded on the testing company's letterhead and shall bear the name, title, and signature of the authorized company representative. Certification data supplied to the Purchaser shall be either the original mill certification, original certification from the testing facility or exact photocopies of the original certifications.

e) The Suppliers may provide a test report under their letterhead listing the results of all tests performed provided copies of the original testing results on testing activity letterhead are also included. In such cases, the Supplier's report shall clearly denote that the data is transcribed data.

f) Statements on certification documents must be positive and unqualified. Words such as "To the best of our knowledge" or "We believe the information contained herein is true" are not acceptable.

g) The supplier is required, unless permission is granted in writing or supplement to the purchase order, to use the same unit of measurement as specified in the technical data package when reporting inspection and acceptance data.

h) The use of ditto marks and continuation arrows are not acceptable for repeated data, initials or signatures.

2.3 Corrections to Documents

a) Corrections to official records shall be made by drawing a single line through the incorrect entry. Corrections to official records should be made by the person who made the original entry, a supervisor or a person assigned by the supervisor and must be initialed and dated in permanent ink. The original entry must remain legible. Erasure or other obliteration of information on official records is prohibited.

b) When additional information is added, it shall be initialed and dated.

c) When a document is retyped, in portion or completely, to correct or add information, it shall be identified as a **"CORRECTED COPY"** and all changes shall be identified (e.g. *). The document shall be resigned and dated.

2.4 Record Retention

a) All test and inspection records including radiographs, furnace charts of heat treatment (unless otherwise noted in the purchase order), radiographic records, and reports of non-conformances, applicable to material supplied to the purchaser shall be retained by the supplier. These records shall include verification that all required inspections and tests have been accomplished with satisfactory results by a qualified individual.

b) Test records shall be retained for a period of seven years after completion of the last item of the contract. (See paragraph 2.5)

c) Where work is performed under continuing contracts or on other than a contractual basis, these records shall be retained for seven years from the date the work was performed.

d) Records shall be made available to the purchaser within 36 hours upon request. When requested, the Supplier shall provide objective quality evidence that the item, material, or service used in the performance of this order is in full compliance with the appropriate specifications and indicated revisions.

2.5 Destruction of Records

At the end of the seven year retention period, as discussed in Paragraph 2.4 (b), the Supplier shall contact the Quality Department of the procuring activity for instructions. Destruction of test, inspection, Quality records and objective quality evidence must be approved by the procuring activity.

2.6 Electronic Data Retention

Record retention periods also apply to electronic records. Records generated and maintained in the Supplier's information systems or equipment (including mainframe, mini, and microcomputer/ storage systems) are to be periodically reviewed by appropriate information owners and/ or custodians to ensure that record management requirements (i.e. controlled access, password protection and backup protection) are being met.

2.7 Electronic Signatures

2.7.1 Definitions:

2.7.1.1 Electronic Signatures

The electronic signature is equivalent to a person's handwritten signature. It indicates approval of a certification of information or action(s) in the same manner as pen-and-ink signature.

2.7.1.2 Electronic Identification

The electronic identification is an electronic means of identifying a signer of an electronic record, document transaction, or instrument. It is unique and attributable to only one person. Examples of various electronic identifications include but are not limited to; an identifying keystroke, a password, a personal identification number (PIN), or a token or magnetic key.

2.7.2 Electronic Signature Process Controls

The controls for the electronic signature process should provide:

2.7.2.1 The signer must take a distinct action to "sign" electronically.

2.7.2.2 A means to delegate signature authority which allows the delegated individual to utilize their own electronic identification (i.e., integrity of each person's electronic signature must be preserved.)

2.7.2.3 A means to identify the electronic signer by name on the electronic paper version of the document and be maintained for the retention life of the electronic record.

2.7.2.4 Preservation of unauthorized access to electronic identifications.

2.7.2.5 An established password policy to change electronic identification and not share electronic identification.

2.7.2.6 Reviews to ensure proper use of electronic signatures.

2.7.2.7 A means to identify an electronic signature on a record as an electronic signature.

2.7.2.8 Electronic signature applications shall not allow unauthorized users to change electronically signed documents, or records. All changes to electronically signed documents, or records made by authorized users shall be revision controlled, identify the person making the change, and shall clearly reflect that the document, or record has been revised.

2.7.3 Electronic Signature Flow Data Down to Sub-Tier Suppliers and Sub-Contractors

2.7.3.1 It is the Supplier's responsibility for implementation of Electronic Signature at sub-tier suppliers and sub-contractors.

2.7.3.2 The Supplier shall flow down these Electronic Signature requirements to their sub-tier suppliers and sub-contractors.

2.7.3.3 It is the Supplier's responsible to ensure that their suppliers or sub-contractors have a policy for that addresses changes to electronically signed documents are ensures that changes are only performed by authorized personnel and all changes to electronically signed documents, or records are properly documented.

2.8 (omitted)

3.0 DRAWING AND DOCUMENT CONTROL

3.1 The Supplier is not to assume that a replacement specification identified in a specification "Cancellation Notice" is equivalent or better than the cancelled specification. Specification cancellation notices do not modify the PO. If the Supplier intends to deviate from the invoked revision, permission must be obtained from the Purchaser in writing.

3.2 Supplier drawings or sub-tier Supplier forging sketches may be required to be submitted to the purchaser for review and approval. When working to approved drawings, all proposed changes to these drawings must be submitted to the purchaser for approval in writing prior to use. The Supplier assumes all responsibility when work is performed to unapproved drawings.

4.0 DESIGN CHANGES

4.1 Any changes to the design of an item or to a service being procured by the purchase order must be submitted in writing for Purchaser review and approval. Design change is defined to mean changes to any of the following:

- Drawings approved by the Purchaser or Government
- Specifications listed on documents issued or approved by the Purchaser or Government
- Inspection systems
- Reliability
- Safety
- Weight
- Materials or special requirements
- Unusual inspection or test procedures or equipment
- Any special revision or model identification whether specified in the Purchase Order, or referenced document.
- Any change that could affect interchangeability (Fit, Form, Function)
- Change to approved manufacturing processes or procedures (1st Article tests, forging sketches, test specimen locations, etc.)
- Any change that affects provisioning parts procured as onboard repair parts, shore based spares, or any part procured as a construction spare part.

4.2 The purchaser shall be notified in writing any work on dies/ patterns/ process tooling which will affect the dimensions of the product.

4.3 Where commercial brand names or names of specific manufacturers are specified in the purchase order together with terms such as "similar to" and "or equal", such identification is intended to be descriptive, but not restrictive, and is to indicate the quality and characteristics of products that will be satisfactory. Supplier's requests when submitted with justification in writing offering equal products will be considered for approval.

4.4 If the product or procedures specified have been approved by the Purchaser or the Government to qualify the product and to permit the supplier to become a qualified source for the product, the supplier may not change the process, material, material sources or procedure without prior approval by the Purchaser in writing.

5.0 MATERIAL CONTROL

5.1 (omitted)

5.2 The Supplier shall perform or have performed all necessary inspections and tests to ensure that the material procured from lower-tier suppliers conform to all requirements. Inspections, tests, and/ or certifications from activities, other than the Suppliers, does not relieve Suppliers of their responsibility to furnish material/ services in full compliance with all purchase order requirements.

5.3 The degree of control of sub-tier suppliers shall be dependent on the complexity of the item being purchased and the subtiers quality performance record. Control shall be maintained by one or more of the following:

a) Conducting quality audits and source inspections at the subtier facility.

b) Performing chemical and mechanical testing, on a sample basis, to confirm reported results on test reports.

c) Performing generic alloy identity tests, on a sample basis, to assure the proper alloy is being supplied.

d) Utilizing supplier receipt inspection history.

e) The seller shall ensure that their sub-tier suppliers are capable of attaining and maintaining a quality system acceptable to the purchaser for supplies and services covered by the purchase order.

5.4 Items or material requiring traceability to Objective Quality Evidence (OQE) shall be stored and processed such that positive identity is maintained. Each piece of material shall be individually and permanently identified. During in process manufacturing when individual marking is not practical totes, bags, or boxes identified properly and accompanied by a properly identified process traveler, are a suitable alternative to permanent marking provided the identity is maintained at all times.

5.5 Unless the purchase order specifically identifies the area where permanent marking on an item should be applied, it shall be marked in an area that is readily accessible and unlikely to be obliterated during installation.

5.6 When material is worked or heat treated, resulting in changes to its mechanical properties, the mechanical properties shall be re-determined and the material shall be uniquely re-identified to provide traceability to the final heat treatment and mechanical properties certified for that material. Furnace charts shall be retained by the supplier, unless otherwise specified, as OQE for audit purposes

5.7 Unless specifically authorized in the purchase order, only seamless pipe and tubing shall be used in items/ components supplied. The Supplier's material control system must assure that seamed pipe and tubing is controlled such that it cannot be mixed with seamless pipe and tubing. This material control requirement must be passed on to the Supplier's mill or distribution sources and sub-tier Suppliers.

5.8 Permanent marking methods shall be in accordance with MIL-STD-792.

5.9 Refer to the applicable DFAR clauses in the terms and conditions of the Purchase Order for restrictions on the use of foreign material.

6.0 (omitted)

7.0 MANUFACTURING AND SPECIAL PROCESSES

7.1 No welding without prior approval from Advex shall be allowed. After approval, Repair Welding of Base Materials shall be accomplished in accordance with EB Specification 4186.

7.2 Repair welding, bonding, or impregnation in excess of that permitted by the basic material specification will not be allowed without prior approval by the Purchaser in writing.

7.3 When a procedure is required by the purchase order for special processes (e.g. NDT, forging sketches, 1st Article tests, etc.) or for welding (production or repair) for procedure shall be submitted to the Purchaser.

7.4 When radiography is required, the Supplier shall review (or have reviewed by a qualified individual) and approve all RT films whether RT was performed by Supplier or a sub-tier Supplier. The Purchaser's approval of the film must be obtained prior to shipment of the item unless authorization to the contrary has been previously granted in writing. Film submitted for approval, including film for all weld repair cycles shall be forwarded to the Purchaser, unless reviewed by the Purchaser's Representative on site. When noted in the purchase order, the film will become the property of the Purchaser.

7.5 Forging Suppliers may qualify to be listed on the Approved Forging Supplier List to manufacture products for ultimate delivery to the Purchaser, after demonstrating compliance with supplemental requirements as verified by desktop and on-site evaluations of procedures and operations for the manufacture of forged products. See Appendix E for supplemental requirements for approved forging suppliers.

8.0 INSPECTION

8.1 Inspection at Supplier's Plant

a) The Purchaser, Government, or Government Representative reserves the right to audit processes and systems and to verify the conformance of the item(s) and services to the purchase order at any location including sub-tier suppliers at any stage of development or manufacture.

b) The Supplier shall provide assistance to the Purchaser's or Government's representative during source inspection, audits, or other activities as may be specified by contract. This will include, but not be limited, to the following:

(1) Cooperation in establishing dates and times of visits to the plant facilities.

(2) Providing requested information, documents, and escorts during audits, surveys, and shop inspections or tours

(3) Providing calibrated M&TE to the Purchaser and/or Government representatives to check product compliance.

8.2 System 21 Inspection Requirements for Threaded Holes

Tapped holes and fabricated internal threads shall be inspected IAW System 21 criteria per FED-STD-H28/20B. Inspection shall include use of appropriate size threaded internal functional, fixed limit Go/Not Go gages to verify the final tapped hole thread form. In addition, Go/Not Go cylindrical plug gages shall be used to ensure the threaded hole meets the minor diameter requirements of the threaded hole. Use of an inside micrometer or Intrimik to measure the thread minor diameter in lieu of a cylindrical plug gage is acceptable, but not required.

NOTE:

Insert threaded Go gage to full thread depth. Insert plain cylindrical plug Go gage to full depth. Not Go thread plug gage shall not enter more than 3 turns. Verify that the number of complete threads meet drawing requirements.

100% inspection of each threaded (tapped) hole shall be performed on items that are specifically identified as requiring System 21 thread inspection on the Electric Boat or Huntington Ingalls Industries - Newport News Shipbuilding drawings or via purchase orders on items that are identified as "SMC CAT: 1". All other applications may be sample inspected, unless otherwise specified by the applicable drawing.

The inspection records shall document accomplishment of the inspection of the threaded (tapped) holes and retained on file. No special OQE is required to be supplied. The Suppliers Certification of Conformance that the material complies with the Purchase Order, Specification and Drawing Requirements is considered to adequately document accomplishment of this inspection.

9.0 CORRECTIVE ACTION SYSTEM

9.1 The Supplier must establish and maintain a Corrective Action Reporting System in accordance with the invoked quality requirements. In addition to non-conformances that have an assignable cause, a Corrective Action Report must be issued to internal activities or external Suppliers when the following non-conformances are found:

- Loss of material traceability or incorrect material.
- Loss of test records or failure to perform tests.
- Any nonconformance that becomes repetitive and demonstrates a trend.

9.2 The Corrective Action Reporting System must describe the nonconformance, establish the root cause, describe the immediate corrective action and the permanent preventive actions taken to preclude recurrence in the future, and assign individual responsibility to correct the root cause. Pertinent documentation shall be maintained by the Supplier and made available for review by the Purchaser upon request.

9.3 In the event non-conformities or latent defects are discovered after delivery and acceptance by the purchaser, the supplier shall provide to the Purchaser, notice and subsequent written documentation (i.e. Letter of Advisement) of the deficient condition in sufficient detail to enable timely action to preclude adverse impact on ship or personnel safety or equipment performance.

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41 Research Drive
Hampton, VA 23666

QUALITY DEPARTMENT:
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41 Research Drive
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10.0 AUDITS

10.1 The Supplier shall establish and maintain an internal quality audit program. It is recommended that the Supplier also establish and maintain an external (sub-tier) review and quality audit program. These programs shall be designed and implemented to determine compliance to purchase order requirements.

10.2 Both internal and external audits will be preplanned using a checklist of audit elements that are capable of determining if contract requirements can or are being satisfied. An audit report will document the level of compliance found during the audit. Non-conformances will be clearly documented on a Corrective Action Report with required follow-up actions sufficient to determine satisfactory resolution. Records of audits and corrective and preventive actions shall be maintained by the Supplier and made available for review by the Purchaser upon request.

10.3 The supplier shall audit their internal quality assurance program and the internal manufacture and/ or process system on a frequency set by procedure to determine compliance to their quality program and the requirements established by this specification.

Appendix A (omitted)

Appendix B Contract Compliance and Awareness of Malpractice Prevention

1.0 Scope

1.1 The purpose of this specification is to clarify business ethics and standards of conduct. These guidelines apply to all aspects of work performed by direct Suppliers and their "sub-tier" Suppliers, including manufacturing, inspection, and services.

1.2 All Suppliers providing product or services to Electric Boat Corporation (EBC) are provided the General Dynamics "Blue Book", titled Standards of Business Ethics and Conduct at time of initial purchase order placement. Within this booklet are various topics pertinent to ethics and standards of conduct while doing business with Electric Boat Corporation. Acceptance of purchase orders and, by extension, acceptance of the business ethics and conduct contained within the Blue Book, signifies Supplier's commitment to comply with purchase order (contractual) requirements.

2.0 General

2.1 Suppliers (management and employees) are contractually obligated and expected to meet all purchase order requirements. Suppliers are required to inform sub-tier Supplier's hired by the Supplier that they are likewise contractually obligated and expected to meet all purchase order requirements.

2.2 Suppliers and sub-tier Suppliers shall be aware and vigilant for Malpractice and Fraud and Falsification (F&F), as it affects contract compliance. All parties associated with product and services destined for ultimate delivery to the Purchaser must be aware that Malpractice and F&F are grave and serious matters. The act of Malpractice or F&F has the potential for severe and costly damages.

2.3 It is the responsibility of all parties to avoid the slightest possibility or appearance of impropriety or malpractice and to report known or suspected occurrences to the proper authorities (See 2.6). All personnel working within the program must be aware of malpractice and fraud & falsification, pitfalls that could lead to malpractice and fraud & falsification, methods to eliminate potential situations, and Purchaser expectations of supplier's, their employees, and subcontractors.

2.4 Consequences of malpractice and fraud & falsification could involve functional failure of product in operation on land or at sea, causing loss of equipment and life. Consequences also include severe dollar loss to the Purchaser, the Government, and the Supplier due to lengthy investigations, possible disqualification from future contracts, production shutdown, and loss of employment. Acts of malpractice or fraud & falsification will result in purchase order contractual action and will also be subject to federal criminal prosecution for violations of law under Title 18 of the U.S. Code, Chapter 47, Section 1001.

2.5 Suppliers must ensure that employees and sub-tier suppliers are provided documentation and information necessary to perform assigned and contracted work correctly. Employees and sub-tier suppliers must follow established work procedures and contract documents to perform best possible effort within the program.

2.6 Any party aware of, or having reason to suspect, malpractice or fraud & falsification is obligated to report this violation anonymously or in person to:

a) Local Supervision or Management,

b) Purchaser Supervision or Management,

c) Purchaser Quality Representative,

d) Purchaser Buyer, or

e) Department of Defense Hotline:

- telephone (800) 424-9098 or
- website http:/ /www.dodig.osd.mil/hotline/hotline7.htm
- email hotline@,dodig.osd.mil or
- mail to
  Department of Defense Hotline
  The Pentagon
  Washington, DC 20301-1900

Should such a notification be necessary, information including location, date(s), time, names of people involved, and violation suspected would be most helpful to promote an investigation.

2.7 False allegations of malpractice and fraud & falsification are likewise serious matters and subject to federal investigation and prosecution. It is imperative that persons making allegations be knowledgeable and truthful with the facts and not be with vindictive or spiteful intent.

3.0 Contract Compliance

3.1 To demonstrate contract compliance with this specification, the Supplier is required to perform, and maintain records for, the following:

a) Alert all employees to this (Contract Compliance and Awareness of Malpractice Prevention) Appendix during new hire indoctrination.

b) Annually provide refresher training to this (Contract Compliance and Awareness of Malpractice Prevention) Appendix for all employees.

c) Appendix D is provided as a visible reminder notice, and provides contact information should malpractice or fraud & falsification be observed or suspected. Suppliers are to post this reminder notice in conspicuous and prominent locations throughout the facility, especially work areas, at a minimum rate of one (1) copy for every fifty (50) employees

d) Include verification during internal quality audits that malpractice and F&F training is performed and reminder notices are posted.

e) Include an awareness in audit requirements that auditors be alert for malpractice and F&F during internal and external quality audits.

f) Perform periodic and independent overchecks of final inspections and testing.

g) Alert all sub-tier Supplier's of malpractice and F&F by pass down of this specification in supplier purchase orders.

h) While performing on-site quality audits at sub-tier Supplier's facilities, confirm and verify sub-tier awareness of malpractice prevention.

4.0 Examples of Malpractice and Fraud & Falsification (F&F)

- Issuing a procedure or instructions known to contain unauthorized deviation(s) to contractual requirements.
- Knowingly waiving or eliminating a contractual requirement without authority to do so.
- Deliberately accepting unsatisfactory work.
- Intentionally performing unacceptable work.
- Failing to report problems or unsatisfactory conditions in one's own workmanship.
- Verifying by signature that an action was taken, knowing in fact the action was not taken, or not performing the required checks or verifications to assure the action was taken.
- Verifying performance of action based on hearsay, not personal observation.
- Tampering with calibrated instruments to avoid rejection of work.
- Falsifying dates on records to comply with frequency or deadline requirements.
- Falsifying data to cover-up a procedure or drawing deviation.
- Falsifying data to have work accepted, thereby avoiding further work or rework.
- Concealing or not reporting information on malpractice, fraud, or falsification known to have been committed by others.

Appendix C (omitted)

Appendix D

NOTICE

Any party aware of, or having reason to suspect, MALPRACTICE OR FRAUD & FALSIFICATION is obligated to report this violation anonymously or in person to:

a) Company Supervision or Management,

b) Purchaser Supervision or Management,

c) Purchaser Quality Representative,

d) Purchaser Buyer, or

e) Department of Defense Hotline

- telephone (800) 424-9098 or
- website http: //www.dodig.osd.mil/hotline /hotline7.htm
- email hotline@dodig.osd.mil or
- mail to:
  Department of Defense Hotline
  The Pentagon
  Washington, DC 20301-1900

Should such a notification be necessary, information including location, date(s), time, names of people involved, and violation suspected would be most helpful to promote an investigation.

NOTICE

Appendix E Supplemental Requirements for Forging Operations

1.0 (omitted)

2.0 In addition to, or in conjunction with, testing required elsewhere in the purchase order, Suppliers shall invoke the following requirements on orders for forgings from an approved forging supplier:

a) Subsequent to forging (and heat treat if performed), material must be physically re-identified with a unique traceability identification to distinguish the revised properties from the original heat number traceability.

b) Obtain and test mechanical test samples as required in the purchase order, applicable material specification, modification for the material specification, and/ or approved forging drawing. Test samples to be physically identified with the forging traceability number.

c) The forging supplier shall maintain the mechanical test specimens, and their respective test results, as objective quality evidence, subject to audit and further analysis by the Purchaser.

d) Retention of records and specimens shall be in accordance with paragraph 2.4

e) The material test report for the original heat number must be annotated to reflect the assigned heat/ lot number or unique traceability identity number (IAW paragraph 2.2).

f) Chemical and mechanical test report submittal to the Purchaser shall be in accordance with the requirements contained elsewhere in the Purchase Order.