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1.0 INTRODUCTION

1.1 QUALITY POLICY

SIG SAUER, Inc. (SIG) employees are fully committed to meeting or exceeding customer expectations by delivering defect-free products and services on time, every time. We will measure our performance and strive for continuous improvement.

1.2 PURPOSE

The purpose of this Supplier Quality Manual is to assist our supply base in understanding the quality expectations of SIG as well as providing a formal means of collaboration for our mutual benefit. This document is to be used to supplement the requirements of engineered drawings, process specifications, purchase orders, terms and conditions, and other similarly controlled documents which take precedence over this manual.

1.3 SCOPE

This document applies to all products or services to be bought for incorporation into the SIG saleable end product, and complies with Section 8.4, with a focus on section 8.4.3; “Information for External Providers” of ISO 9001:2015. This document establishes the minimum quality requirements for all Suppliers, whether the products being furnished are provided directly by the Supplier or are purchased from sub-tier Suppliers for use in SIG products.

1.4 ACRONYMS / DEFINITIONS

CTR: Certified Test Report
C of C: Certificate of Conformance
DPAS: Defense Priorities and Allocations System
FA: First Article
FAI: First Article Inspection
FAIR: First Article Inspection Report
LAT: Lot Acceptance Testing
NGSW: Next Generation Squad Weapon
NMR: Non-Conforming Material Report
NIST: National Institute of Standards and Technology
NDA: Non-Disclosure Agreement
NVAR: New Vendor Approval Request
OSP: Outside Service Provider
PLM: Product Lifecycle Management
PO: Purchase Order
PSO: Process Sign Off
QAP: Quality Assurance Provisions

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QMS: Quality Management System
RTV: Return to Vendor
SCAR: Supplier Corrective Action Report
SPR: Supplier Performance Rating
SQE: Supplier Quality Engineer
UAI: Use As Is
USG: United States Government

Ballooned (Engineering) Drawings: An engineering drawing annotated with uniquely numbered balloons that identify product characteristics (dimensions, notes, etc.) to link inspection documents.

Components: Parts that belong to an assembly.

Certified Stock: Material that is returned to SIG after being 100% reworked, sorted, and inspected at the Supplier or qualified source for nonconformance(s) listed on a NMR provided by the SQE.

First Article Inspection: SIG defines a first article inspection to be one where the Supplier and SIG pull samples from the first lot of material run that replicates the production process and inspects the samples for complete conformance to the print.

Important Characteristic (INSP) Designates NGSW Inspection Protocols Apply. Commonly used for the NGSW program prior to application of Quality Assurance Provisions per ARDEC drawing number 12993384, this symbol denotes that inspection is to be done using SIG4-1005 major characteristic sampling.

Source Control: Items that are purchased through a specific Supplier that may have a proprietary design. These items are not governed by a standard specification. The Supplier part number must be listed in the notes section of the print. “SOURCE CONTROL” will appear on the print.

Specification Control: Items that are purchased to a standard industry specification which governs the print dimensions. Examples include but are not limited to ASTM, ASM, DIN, ISO, etc. The specification must be listed in the notes section of the print. “SPECIFICATION CONTROL” will appear on the print.

1.5 RELATED DOCUMENTS & REFERENCES

ISO 9001:2015 Quality management systems — Requirements
ISO 17025 Requirements for the competence of testing and calibration laboratories
SIG3-782 Supplier Performance Rating

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SIG4-004 Supplier Corrective Action Report
SIG4-073 Request for Waiver/Deviation Form
SIG4-117 Supplier First Article Approval
SIG4-180 New Vendor Request Form
SIG4-1005 Sample Inspection Tables
SIG4-1093 Supplier Audit Checklist
SIG4-1033 OSP Supplier Scorecard
SIG4-1015 Certificate of Conformance Template
SIG4-1016 Certified Test Report Template
SIG4-1128 Process Sign Off Form
ARDEC Drawing Number 12993884 (Public document can be found via online search or by contacting Sig Sauer Supplier Quality Engineer or Sig Sauer Buyer).
USG Specification MIL-STD-1916

For more information, visit www.sigsauer.com/Suppliers.

2.0 SUPPLIER QUALITY – GENERAL

2.1 SUPPLIER QUALITY MANAGEMENT SYSTEM

The Supplier shall establish, document, and maintain a quality management system as a means of ensuring that product conforms to specified requirements. The QMS will be subject to periodic review by SIG in relation to products supplied. The Supplier quality system must ensure that products are traceable to all raw materials and/or components to be used in the manufacturing process, production operation, date(s) of manufacture, lot/heat/batch number traceability, revision level, and records of conformance.

2.2 SUPPLIER QUALIFICATION

Prior to receiving a purchase order from SIG for goods or services, the Supplier must be approved through the SIG new vendor approval process, by means of a NVAR form. This may include quality surveys, plant visits, production samples, and manufacturing process capability reviews. Prior to proceeding with any business discussions or transactions, Supplier and SIG must have a signed NDA on file.

2.3 SUPPLIER SITE AUDITS AND / OR EVALUATIONS

SIG reserves the right to perform periodic on-site assessments of the Supplier's facility, quality systems, equipment, records, and product. The Supplier's personnel, gauging,

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tooling, and testing facilities shall be made available as requested. This applies to both new and current Suppliers.

2.4 SUPPLIER PERFORMANCE RATING / OSP SCORECARD

Supplier Performance Ratings are designed to allow SIG to accurately assess and communicate Supplier performance while collaborating with Suppliers for improvement. SIG measures and reviews Supplier quality and delivery performance on a cyclical basis. Supplier performance rating values are tracked over time and evaluated for consistency and/or improvement. In accordance with the SIG Quality Policy, we expect our Suppliers to measure their own performance and strive for continuous improvement.

2.5 NONCONFORMITY AND CORRECTIVE ACTION

The Supplier shall maintain a non-conformity and corrective action system. SIG may issue, at the discretion of SQE management, a SCAR as a result of audit finding(s) or non-conforming material. Due dates for SCAR response shall be determined by the assigned SQE. Once the issue is deemed by SIG to be corrected (completion of SCAR form), at least three consecutive shipments of conforming parts or services must be received in order to close out the SCAR unless otherwise agreed by SIG SQE management.

2.6 ORDER OF PRECEDENCE

Unless otherwise instructed by SIG the order of precedence is: PO, SIG engineering drawing, SIG specification requirements, non-SIG specification requirements.

3.0 SUPPLIER QUALITY - SPECIFIC

3.1 CONTRACT REVIEW

The Supplier shall establish and maintain procedures for coordination of contract review. Before acceptance of a purchase order or contract, the Supplier shall review the order to ensure that:

- The requirements are clear and adequately defined.
  - Any differences between the PO, records kept on file, and contract have been resolved, including that pursuant to drawing revisions and verbal communications. If a conflict exists between items on SIG engineering drawing, PO, and/or the specification called out, notify the assigned SQE **and** Buyer immediately for proper procedure moving forward. Exceptions to the SIG engineering drawing, PO, or SIG specification must be submitted and accepted on a SIG waiver deviation form.

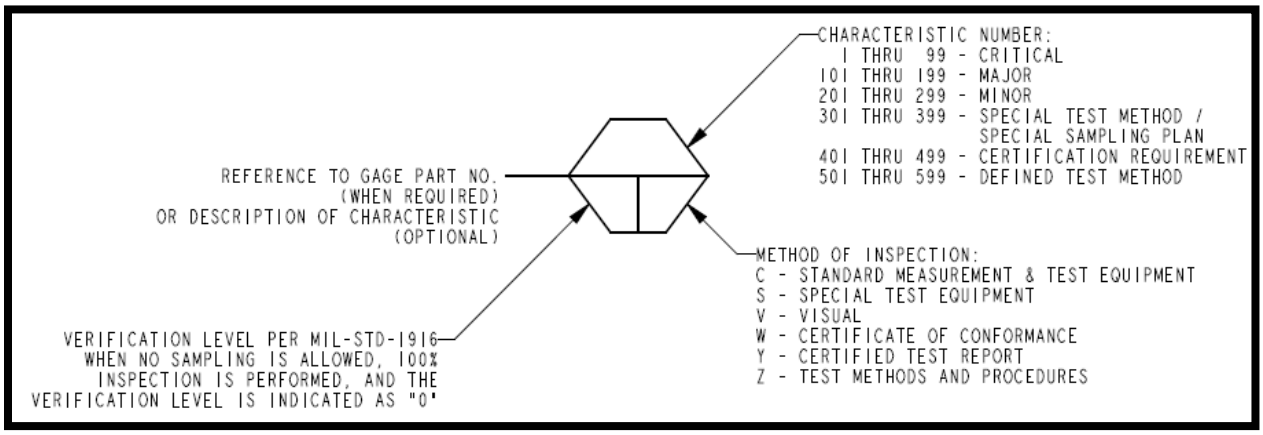
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- The Supplier has the capability, personnel, and equipment (including tooling and gauges) to meet the contract requirements.
- Non-Commercial products are characterized by the DPAS flow down listed on the SIG purchase order. If the PO does not contain the DPAS flow down, then the parts are to be considered for commercial use.

3.2 EXPLANATION OF REQUIREMENTS AND THE QAP DRAWING SYMBOL

Figure 1 represents the QAP reference on ARDEC drawing number 12993884. The QAP designations will be on the SIG ballooned drawing when applied. Unless otherwise specified, the Supplier is responsible for the performance of all inspection requirements specified herein and on the applicable drawing(s).

ARDEC drawing number 12993884 clarifies the requirements for FA, LAT, workmanship, CTR, and C of C. Special test methods, test equipment, and characteristics are explained further in the figure below and within this document.



#12992884 Excerpt – For Reference Only

Figure 1. QAP DWG

3.3 DESIGN AND DOCUMENT CONTROL

It is the responsibility of the Supplier to verify that all drawings and specifications are consistent with that delineated in the purchase order. The Supplier is required to adhere to any secondary specifications referenced in the primary specifications unless otherwise stated in the PO. Any exceptions to the print or specifications require a waiver or deviation prior to part delivery. It is also the responsibility of the Supplier to assure that those persons within its organization, who are directly responsible for assuring conformance of the product, fully understand all drawings and specifications.

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When clarifications and/or interpretations are needed, the Supplier is to contact the SIG Buyer and SQE.

Supplier shall maintain all design records for the product or service, including all components. Documents provided by SIG are considered proprietary and Supplier shall maintain control of these drawings at all times. Drawings kept on file by the Supplier must be the current revision documented on the PO.

When the Supplier is the design authority for the item being purchased ("Source Control" items), records and design documents shall be made available to SIG upon request. If Supplier design changes, it is the responsibility of the Supplier to immediately notify the assigned Buyer and SQE.

3.4 PRODUCT ENGINEERING SAMPLES

When required by SIG, Supplier shall provide engineering samples in advance of qualification for evaluation. Engineering sample parts will only be used for engineering evaluation by SIG. Engineering sample parts **cannot** be used to qualify the Supplier to run production. FA parts must be used for FA submission and approval. Parts are to be sent to SIG address with Attention to the requestor of the samples listed clearly. Parts are to be non-destructively labelled or marked and identified on packaging as well as packing slip as "Engineering Test Samples- PN XXXX, Rev X" or similar.

4.0 PRODUCTION QUALIFICATION

When deemed necessary by SIG a PSO, SIG4-1128, will be initiated in conjunction with a first article PO. A PSO is used to ensure that a Supplier can meet the manufacturing capability and quality requirements of an engineering design. The PSO incorporates print review, FA requirements, certification requirements, gage design and capability studies. A PSO may also be requested on non-FA parts at SIG's discretion.

The FA Submission must represent the manufacturing process used for production parts. Manufacturing process is considered frozen upon FA Approval. No changes may be made to the manufacturing process without notification to SIG in writing and may require a new FA.

4.1 PRINT REVIEW

Upon either quote, PO receipt, or submission, please request a print review or feasibility discussion as required, of your assigned SQE via the Buyer. Key discussion points for successful FA submissions include, but are not limited to:

- SIG Ballooned drawings included with SIG FA PO
- SIG FA inspection sheets included with SIG FA PO

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- Methods of inspection, including use of fixtures and gages if different than SIG FA inspection sheet(s). At least one set of Supplier designed dedicated gages should be retained, and one set provided to SIG to be used during inspection for correlation.
- Please be sure to note most efficient manufacturing lot sizes quoted or proposed to satisfy outside process lot/batch fees and optimal run lengths.

4.2 FIRST ARTICLE REQUIREMENTS – COMMERCIAL PRODUCT

Product/service qualification for commercial items shall be by means of a FA approval and an optional on-site audit / PSO. The purpose of this approval is to verify that the product being produced complies with all requirements identified in the referenced ballooned engineering drawings, specifications, SIG inspection sheets, and other requirements as applicable so that it can be continuously and sustainably manufactured.

- The sample size to be supplied for Commercial FA approval shall be a production run of 25 pieces, unless otherwise specified on the PO, with all samples produced using the same parameters to be submitted for inspection. If multiple cavities are to be used in production, then the 25-piece sample must be evenly distributed throughout the cavities.

FA submittals are required in the following instances:

- New production part/assembly or engineering design
- Change in production process or method
    - Mold change, mold parameters, DMLS parameters, etc.
- Drawing revision
- Change to outside supplier
- Parts not received within the previous **24** months.

In the event of a production facility or equipment move or extensive modification, SIG assigned SQE and Buyer must be notified in writing prior to the change with the details of the change. This change may require re-qualification through FA, optional On-Site Audit/PSO, and separate written authorization from SIG prior to continuing production.

A Delta FA submittal may be completed in the place of a full FA submission when deemed appropriate by the SQE. For example, resubmission of a failed FA, a significant process change, print/spec change, etc. A Delta FA requires all critical features (features listed on SR inspection sheet) to be inspected, as well as any dimensions, OSP, or features affected by the change. If not specified as such, always provide a full FA submission, or ask the assigned SQE for clarification. In instances where received parts fail FA, and it is deemed by engineering to revise prints to accept

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the parts, FA approval will be granted as documentation only on existing parts without the need for FA re-submittal.

- Inspection shall be performed using the same identification numbers as listed on the ballooned drawing and the FA inspection template received from SIG. Suppliers are not to use any alternate ballooned drawing or inspection template without prior written authorization from SIG.
- If a drawing specifies that dimensions apply pre-plating, a minimum of 20% of the FA lot shall be inspected in the pre-plate condition (i.e., 1 out of 5), and 20% of the FA lot shall be nondestructively marked and provided in the pre-plate condition for correlation of measurements.
- For assemblies, submit five (5) of each component unassembled; the remaining PO quantity must be fully assembled. The Supplier must also include a 5-piece FAIR for all sub-components.

For parts that include a “MAKE FROM” SIG part number with SIG drawing, first article inspection must also be completed on the “MAKE FROM” part unless otherwise specified in writing by SIG SQE. Two pieces minimum must be inspected. In the case of SIG supplied “MAKE FROM” material the first article inspection is not required.

4.3 FIRST ARTICLE REQUIREMENTS – NON-COMMERCIAL PRODUCT

Product qualification requirements for non-commercial items in support of a DPAS order shall be defined by the drawing, the PO, and any supplemental documents provided by the Buyer at time of order placement. The Supplier should review all documents prior to the start of work to ensure that they fully understand and are able to satisfy requirements listed. Questions regarding these requirements shall be directed to the SQE and Buyer.

- Inspection shall be performed using the same identification numbers as listed on the ballooned drawing and the FA inspection template received from SIG. Suppliers are not to use any alternate ballooned drawing or inspection template without prior written authorization from SIG.
- If a drawing specifies that dimensions apply pre-plating, a minimum of 20% of the subgroup shall be inspected in the pre-plate condition (i.e., 1 out of 5), and 20% of the sample lot shall be nondestructively marked and provided in the pre-plate condition for correlation of measurements.

A 25-piece FA quantity is acceptable for DPAS rated orders if parts were produced using the same parameters as relates to the spindle, fixture, tool, machine, or program. Note: If product is produced from a molding tool/cavity

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with greater than 1 mold/cavity a 100-piece sample is always required, and the parts must be evenly distributed for each cavity.

Additional quantities for validation may be requested, as recorded on the Purchase Order.

FA submittals are required in the following instances:

- New production part/assembly or engineering design
- Change in production process or method
    - Mold change, Mold parameters, DMLS parameters, etc.
- Drawing revision
- Change to Outside Supplier
- Non-commercial parts not received within the previous **12** months.

In the event of production facility or equipment move or extensive modification, SIG assigned SQE and Buyer must be notified in writing prior to the change with the details of the change. This change requires re-qualification through FA, optional On-Site Audit/PSO, and a separate written authorization from SIG prior to continuing production.

A Delta FA submittal may be completed in the place of a full FA submission when deemed appropriate by the SQE. For example, resubmission of a failed FA, a significant process change, print/spec change, etc. A Delta FA requires all critical features (features listed on SR inspection sheet) to be inspected, as well as any dimensions, OSP, or features affected in the change. If not specified as such, always provide a full FA submission, or ask the assigned SQE for clarification. In instances where received parts fail FA, and it is deemed by engineering to revise prints to accept the parts, FA approval will be granted as documentation only on existing parts without the need for FA re-submittal.

4.4 NON-CONFORMING FIRST ARTICLE INSPECTION

If the Supplier discovers that one or more characteristics of the FA lot do not meet print and the Supplier would still like to submit the sample for FA approval, a waiver or deviation request must be submitted and approved by SIG before shipment of product, and the approved waiver or deviation must also accompany the certification package sent in electronically.

- Note full FA approval cannot be granted with any waivers against the FA submission. Product can be conditionally approved for production by SIG, via issuance and conditions outlined via use of the Request for Waiver/Deviation Form and the FA Approval Form. Conditional approvals will default to the period of time

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referenced on the waiver/deviation form. A PO Line requiring another FA submission will be created for Delta FA submission.

- An existing SIG signed and approved waiver or deviation on file will allow for proper receipt and production use during the Waiver/Deviation approval period. If required beyond this period, an extension via the same form must be requested with explanation of why an extension is required.
- If an FA fails incoming inspection, the SQE will notify the Supplier if parts will be returned, scrap via credit request, conditionally accepted (waiver and delta FA inspected on next shipment) or fully accepted (deviation to print/spec).

4.5 DELTA FA REQUIREMENTS

Delta FAs are subject to the same SIG ballooned drawings, SIG FA inspection forms, and all requirements listed above, except:

- Report shall be clearly labeled as a "Delta FA."
- Report shall contain required characteristics determined by the SQE and critical features as deemed appropriate by SIG. 100% of dimensions are not required to be inspected, only those detailed on the SIG supplied Delta FA Inspection Sheet.
- Any additional requirements will be listed on the PO.
- If prior revision has full FA approval with deviation(s) and the new revision print has no additional changes beyond the deviation(s), an Administrative FA (documentation only) can be applied. Any additional changes beyond the deviation(s) require a delta FA.

5.0 CERTIFICATION REQUIREMENTS

All delivered goods and/or services require a (C of C), which must include SIG part number and item revision, Supplier name (company letterhead acceptable), PO number, shipment quantity, and creation date. Any certifications not adhering to this will be considered non-conforming and rejectable at the Supplier's expense. This applies to both FA and production certifications. Certification documents for non-commercial items in support of a DPAS order require a signature, date of signature, and type/printed name and title of certifying official.

- Certification packages must be emailed to certs@sigsauer.com, with the Buyer on copy, prior to product shipment. One email per part number; paperwork other than pack slip in box not accepted.
- Part Number, PO Number, and Quantity must be in subject line.
- File types accepted are PDF, however an Excel file may be submitted for the FAIR only. Zip files are not accepted.
- Signed and approved waiver or deviation form shall be included in the cert package for all applicable shipments.

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- If a purchased part is an assembly, the assembly, and all component part numbers along with revisions must be listed on the cert, except for “Source Control” or “Specification Control” Commercial Assembly parts.
- For ammunition components, certificates must include date of manufacture.
- Dimensional inspection, test reports, certifications, and all other records for Production lot conformance as well as from initial FA submission shall be retained and be provided if requested by Supplier Quality.
- Inspection reports shall be performed and recorded using the same identification numbers listed on the ballooned drawing received directly from SIG.
- Other testing/paperwork may be required as communicated by the SIG SQE, Buyer, or PO.
- If a C of C or certification needs to be corrected, please use one of the following methods for the correction:
  - A handwritten correction must be a single line strikethrough with the edit legibly written above or below along with the editor’s initials and date.
  - The C of C or certification can be reprinted with the typed correction along with a new signature.
- Certificate of Conformance to meet the requirements of ARDEC Drawing Number 12993884 section 2.6 and shall include traceability to lot/batch & PO# of sub-tier goods/services. All sub-tier goods/services must be easily traceable in the provided documentation, heat # is the preferable way to link raw material to other steps. Sig supplied C of C form SIG4-1015 meets all above requirements.
- When required, a Certified Test Report (CTR) shall contain data from 5 test specimens. Note: 400 series “Y” QAP denotes a CTR, SIG4-1016 is the recommended format for CTR submissions.

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5.1 CERTIFICATION PACKAGE – COMMERCIAL PRODUCT - MATRIX

Submission Requirement	Commercial							
	Source Control		Spec Control		Standard		OSP	
	FA	Production	FA	Production	FA	Production	FA	Production
FAIR (SIG Supplied Template)	--	---	X	---	X	---	X	---
C of C (SIG4-1015 or equivalent)	X	---	X	---	X	X	X	X
CTR (SIG4-1016 or equivalent)	--	---	---	---	X**	X**	X	X
Sub Tier Certs*	--	---	---	---	X	---	---	---

* Subtier certs consist of material, coatings, heat treat, etc.
** Test report required for spring force or torque. Must be on SIG4-1016 (or equivalent).

Figure 2. Commercial Product Matrix

5.2 CERTIFICATION PACKAGE – NON-COMMERCIAL PRODUCT - MATRIX

Submission Requirement	Non-Commercial							
	Source Control		Spec Control		Standard		OSP	
	FA	Production	FA	Production	FA	Production	FA	Production
FAIR (SIG Supplied)	--	---	X	---	X	---	X	---
C of C (SIG4-1015 or equivalent ‡)	X	X	X	X	X	X	X	X
CTR (SIG4-1016 or equivalent)	--	---	---	---	X**†	X**†	X**†	X**†
Sub Tier Certs*	X	---	X	---	X	X	---	---

* Sub tier certs consist of material, coatings, heat treat, etc.
** Test report required for spring force or torque. Must be on SIG4-1016 (or equivalent) for USG.
† SIG4-1016 (or equivalent) is required if the print has a Y QAP from C of C requirements document 12993884 section 2.6 or may be required within specifications.
‡ Signature, date of signature, and type/printed name and title of certifying official should be present on Supplier documents when not utilizing Sig Sauer C of C or CTR formats. Supplier C of C must include links to sub-tier purchase orders/certifications for traceability when applicable.

Figure 3. Non-Commercial Product Matrix

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5.3 EXCEPTIONS AND ADDITIONAL INFORMATION ON FA SUBMISSIONS.

- For Raw Material (including Castings and 3D Printed DMLS Cores) and OSP processes, FA and CTR data will consist of a 2-piece sample minimum unless otherwise specified within ruling SIG specification or PO instruction. Sample to be inspected, non-destructively labeled, and kept segregated.
- For Thread Lock Compound (Nylok™) Patched Threaded Fasteners for FA, 5 non-patched parts shall be supplied for thread verification.
- For commercial parts and assemblies only, if an identical part or assembly with a different part number has been previously FA approved (e.g., commercial version of a non-commercial part), the subject part may receive FA approval by extension denoted on the Supplier First Article Form Sig4-117. Conditions must be identical, including mold/cavity, tool/fixtures, and manufacturing process.

6.0 PART MARKINGS AND PACKAGING FOR SHIPMENT

All parts must be clearly labeled and packaged in such a way that normal handling and movement during shipment will not cause parts to be lost or damaged. Additional requirements can be found below.

6.1 PACKAGING AND PRESERVATION

This section applies to all incoming receipts for FA parts, production runs, and government contracts. Please reference and ensure compliance with Code of Federal Regulations Title 49, Section 173.

Parts and raw materials with surface areas susceptible to scratches, dings, and/or other harm must be packaged with sufficient protective materials layered in between and around the edges of each individual part to ensure parts remain blemish free. If parts are not shipped/contained in a box to protect the outer edges of the part from damage, a suitable substitution must be implemented. Corners, tops, and bottoms of parts stacked on pallets are the most susceptible to damage and must be protected by heavy cardboard, wood, or similar dunnage type material.

All ferrous parts must be coated with adequate rust inhibitor to protect the surface finish of the product or contained within VCI packaging unless specified by the print. Parts with this rust inhibitor must be adequately packaged and sealed so that there is no risk of leakage and/or damage of shipping container during transit or storage. Failure to adequately preserve and package parts may result in cosmetically and/or functionally unacceptable parts and is the Supplier's responsibility.

Raw Material from different heat lots may be provided in the same shipment, however, the different heat lots cannot be mixed in the same package (i.e., pallet or crate). Each

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heat lot must be packaged separately and clearly labeled with their respective heat lot numbers.

6.2 EXTERIOR MARKING REQUIREMENTS

A self-adhesive label of appropriate, legible size shall be affixed to one side of carton and be placed in the upper left-hand corner. The label should include the following information:

- Total number of cartons within the shipment
- Carton number of individual package
- Quantity of units contained within the carton
- Lot number of product within the shipment
- SIG Item number within the carton
- Item Revision within the carton
- Purchase Order Number
- Weight of the package
- Shipping Address of Supplier
- Recipient Address
- Waiver or Deviation number if applicable
- “Engineering Samples” (if parts are being shipped in under an engineering samples PO).
- Heat lot when applicable

See blank example below; in order to be acceptable all sections must be filled in.

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Ship To:	CARTON #: ____ of ____
SIG SAUER, INC. BAY DOOR "S" 72 PEASE BLVD. NEWINGTON, NH 03801	
PO No: _____	Production Lot #: _____
SIG P/N: _____	Rev. No: _____
Enclosed Qty: _____	Net Weight:_____
Total Shipment Qty: _____	Gross Weight:_____
Shipped From:	

Example

6.3 PACKAGE IDENTIFICATION LABEL(S)

Supplier must maintain sufficient records with proof of delivery for every shipment, to be provided to SIG upon request. Sufficient records include tracking number, email confirming receipt of parts, or signed delivery slip.

6.4 PACKING SLIP(S)

Packing slip identifying contents of the shipment must be included with every shipment. Packing list shall be enclosed in box #1 of the shipment. The exterior of box #1 carton within the shipment must be marked with "**PACKING LIST ENCLOSED**" on a minimum of two sides, not the top or bottom.

6.5 SPECIFIC TO SERIALIZED ITEM(S)

Those parts requiring individualized serialization as denoted on part drawings and/or specifications must be identified, marked, and shipped into SIG such that each shipment complies with these additional and unique requirements:

- Serial number must be placed in a manner not susceptible of being easily obliterated, altered, or removed. Supplier must not duplicate any serial number(s)

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used by any other similar or alternate product. Refer to actual print for detailed specifications.

- Serial number is to be engraved to a minimum of .003'' depth and in a font size of 1/16'' minimum. Refer to actual engineering drawing for detailed specifications.
- All serialized parts within a given shipment must be sequentially packaged and identified on an order level master list which includes parts by box number. Any breaks in the sequence must be noted (e.g., skip a space, part scrap in house, or line). The master list shall be included with the pack slip.
- The serial numbers for each part contained within the individual boxes must be stamped/marked in barcode readable form (font 36-48) on the outside of each box. Any breaks in sequence must be noted (e.g., skip a space, part scrap in house, or line).
- A complete sequential listing of every serial number must also be placed within each box, identifying contents within the box in barcode readable form (font 36-48). Any breaks in the sequence must be noted (e.g., skip a space, part scrap in house, or line).

7.0 ADDITIONAL INFORMATION

7.1 TOOLING

Mold design, parting lines, injection point(s), and ejector pin locations, fixture/racking marks, shall be approved in writing by SIG prior to tooling manufacture and production. At SIG's discretion, machine tooling and fixturing design may be subject to review.

7.2 MEASURING, TESTING, AND CALIBRATION

The Supplier shall have a written procedure with description for selecting, calibrating, and controlling any and all measuring equipment.

The Supplier shall establish and maintain a system assuring that all gauges, measuring devices and test equipment used for product acceptance are calibrated at specific intervals against certified standards that are traceable to NIST.

The calibration system should include the process for handling and storing test equipment which prevents abuse, misuse, damage and assuring that any defective measuring and test equipment is promptly identified and removed from service. Records of this procedure and evidence of compliance must be kept on file and available to SIG upon request.

At SIG's discretion, hard gaging designs may be subject to review and approval. Duplicates may be requested for SIG's use.

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7.3 IDENTIFICATION AND TRACEABILITY

Supplier shall maintain lot control through all internal and external manufacturing steps. Traceability shall be made available to SIG upon request.

The Supplier shall establish and implement a process for the avoidance, detection, mitigation, and disposition of counterfeit material. Material whose origin, age, composition, configuration, certification status or other characteristic (including whether or not the material has been used previously) has been falsely represented by:

- Misleading marking of the material, labelling or packaging.
- Misleading documentation; or
- Any other means, including failing to disclose information.
  - Except where it has been demonstrated that the misrepresentation was not the result of dishonesty by a supplier or external provider within the supply chain.

7.4 REQUESTS FOR WAIVER OR DEVIATION

Any departure from drawing, specification, or contractual requirements shall be approved by SIG prior to shipment from Supplier's control. This shall be accomplished by Supplier submittal of a Request for Waiver/Deviation Form (SIG4-073) to the SQE and Buyer. Copies of approved waivers and deviations shall be included with electronic submittal of certifications prior to each shipment. Products or services which arrive at SIG with unapproved deviations or waivers will be considered as non-conforming product subject to return.

7.5 SUPPLIER NON-CONFORMING PRODUCT

It is expected that product supplied to SIG will conform to all requirements. If items supplied are determined to be non-conforming to requirements, a non-conforming material report (NMR) will be issued and subject to the following dispositions:

- RETURN TO VENDOR (RTV) –Return of items for replacement, rework, sorting, etc. in cases where items are production critical, but the Supplier can provide replacements without disruption to SIG production or returned for credit at Buyer discretion.

  RTV Process is as follows:
  - The NMR will be sent to Supplier, with pictures and/or lab report (if applicable), identifying the issue and requesting an RMA number.
  - An RMA number will be issued to SIG by Supplier within 2-3 business days.
  - If credit and replacement, Buyer will reopen the PO line item for the amount returned.

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- If credit only, Supplier is not to ship reworked product back to SIG. If Supplier would like the product to be scrapped at SIG, it is to be clearly noted when RMA is provided. It is the Supplier's responsibility to issue a credit memo with that request.

- SCRAP ON-SITE FOR CREDIT –Cases where return is not feasible (licensing, trade compliance, value, etc.) SIG will issue a request for credit of the parts or services provided and scrap from inventory.

- REWORK –Cases where return is not feasible due to production needs or other circumstances, items may be reworked and/or sorted at SIG to meet requirements at Supplier expense. If Supplier cannot rework/sort at SIG site, Supplier will be issued a credit request for SIG's cost of sort/rework and Supplier will issue a credit memo for those costs. DPAS rated orders may require Government approval for non-conforming product disposition.

- USE AS IS (UAI) –SIG reserves the right to consider items to be used "as is" but does not absolve Supplier from correction for future shipments. These will still be documented on an NMR, may require a SCAR and impact quality rating. DPAS rated orders will require USG approval for vendor non-conforming product disposition.

Provision of non-conforming product will have an impact on Supplier Performance Rating and be subject to formal corrective action. If non-conforming material is found at SIG or at Supplier, Supplier shall immediately notify the SQE and Buyer if it is discovered that non-conforming material may have been shipped to SIG. SIG will notify Supplier if non-conforming material is found on site via NMR, SCAR, or otherwise.

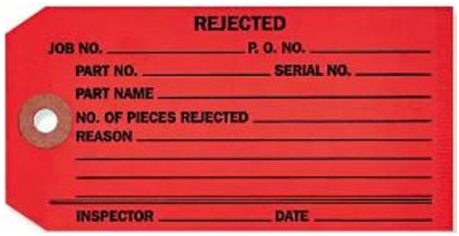
7.6 OUTSIDE SERVICE PROVIDERS (SPECIAL PROCESSES)

Outside Service Providers must adhere to the Supplier quality manual. Coating, heat treat, and other services for SIG product(s) is of special importance due to the impact on subsequent performance characteristics, appearance, and/or customer requirements. Supplier shall obtain prior approval of sub-tier Suppliers prior to use and shall be subject to Product Qualification. All services require a C of C certifying conformance to purchase order, specification, and drawing requirements (see sections 5.1 and 5.2). Additional requirements such as CTR may be required as stated on PO or within specifications. In cases where coatings or other processed parts are determined to be non-conforming, remediation options will be considered.

If the OSP Supplier produces or finds nonconforming components against a Sig PO and/or work order, the following process must be followed:

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- The nonconforming/rejected components must be segregated to a single box and identified within the box (red tape, stickers, reject tags, etc.)
- Nonconforming/rejected parts must be annotated on the packing slip
- A red tag (example below) must be adhered to the outside of the box with the following information:
  - Purchase order number
  - Work order number if available
  - Part number
  - Brief description of the issue



7.7 REWORKED OR SORTED MATERIAL

For parts rejected per NMR and following rework/sort at Supplier, a C of C must accompany shipment when returned to SIG. The document should reference rejection NMR # and clearly identify which feature(s) were reworked/sorted. Receiving Inspection will be performed on reworked features to determine if parts are acceptable. These containers must be clearly identified per section 6.2 with “Rework- Certified Stock to NMR #.”

7.8 SIG SAUER SUPPLIED GAGES

If it is agreed that SIG will provide gages for specified features or parts, it is the responsibility of the Supplier to calibrate them yearly at a minimum, maintain, and replace gaging as required, unless otherwise specified in writing. In these cases, SIG will verify initial calibration prior to shipment and will provide gage design drawings to Supplier for use in annual calibration. SIG will not be responsible for non-conforming material resulting from use of these gages. After revision change, Supplier to review if gage(s) need modification and review with SIG prior to use.

7.9 SIG SAUER OWNED PRODUCT

The Supplier shall exercise care with SIG property while it is under Supplier’s control. The Supplier shall identify, verify, protect, and safeguard SIG property as provided for use, verification, or incorporation into the product.

SIG owned product is defined as: items sent by SIG to Supplier or items SIG purchased but sourced through the Supplier to aid in manufacturing and/or inspection.

7.10 RECORDS RETENTION

The Supplier shall maintain records for a minimum of 7 years (unless otherwise specified, such as contracts) in a readily retrievable form for review upon request within 48 hours of request. Records shall include material certifications, special processing

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certifications and other documents, work order/traveler/router or similar, test and inspection reports, calibration records, and FA submissions.

For non-commercial product Supplier Final Inspection sampling for production quantities is based on the verification level specified in the QAP and MIL-STD-1916. When no sampling is allowed, a 100% inspection shall be performed as indicated by a "0" verification level. These results shall be recorded, and all documents are to be kept on file.

7.11 GOVERNMENT AUDIT – BASIC GUIDELINES

When a part is purchased by SIG for a DPAS rated item, the USG can audit any and all Suppliers and sub tier Suppliers. An audit by the USG or SIG may be performed if there is a nonconformance. The following questions may arise during an audit:

- What contract requirements has SIG flowed down to you? Where can this information, a copy of the contract, and other SIG quality documents be found?
- Have all individuals performing any task on a part been properly trained? Are there records of this training on file?
- Is all documentation retained and on file? How long are records for this contract kept? What documentation needs to be kept on file?
- Are non-conformances and failures identified, recorded, and tracked? Explain the in-house process.
- Does an inspection of the product at select steps in the process indicate adequate controls to assure a conforming product?
- Is all relevant equipment calibrated to ensure continued accuracy? Where are these records kept?
- Are all manufacturing and quality control policies/procedures documented? Are they being followed? How is this verified?

7.12 DISCLOSURE OF SIG SAUER DOCUMENTS TO COMPETITORS

Under no circumstance shall a Supplier disclose SIG Sauer documents, specifications, gauges, fixtures or practices to any direct firearms manufacturer or competitor to SIG Sauer. This includes, but is not limited to, third parties performing heat treatment, coating, machining or any other manufacturing step. Contact the SQE if there is any question concerning a third-party vendor.

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8.0 AMENDMENT RECORD:

The management representative will process all authorized changes and keep the server document current. Please note the type of update on the left side, this will determine if associates must be re-trained on the updated revision for work instructions, visual aids, or any other trainable document. If the content within this document is not intended to be used as training material, N/A may also be used as the form of communication will be in SIG's PLM system.

TYPES OF UPDATES:

T = Associates must be re-trained; this indicates the physical or visual change to one or more steps of the process.

E = Editorial, for document control purposes, no changes to the process.

N/A = For non-trainable documents.

Type	Date	Rev	Details	Name
-	12/05/18	00	Initial Release, update to ISO 2015 (Obsolete SIG2-7-4-2 Rev 10)	H. Baril
-	8/22/19	01	Updated sec. 2.5 Corrective Action, 3.1 Contract Review, and 3.4 Product Qualification.	J. Sanborn
-	09/14/2020	02	Revised definition for "Source Control;" changed exceptions in Sections 3.4 & 3.13 to include "Source Control" and "Specification Control" drawings. Removed definition for "COTS." Removed dollar value for fee in Section 3.11.3. Revised some formatting.	J. Flynn
-	8/22/2023	03	Added 3.15 for NMR Fees. Updated section 3.13 to include certs for NGSW source control and spec control parts. Updated rules for commercial assembly FAs in section 3.4. Added rules for non-commercial assembly FAs in section 3.4. Added PSO form # to section 1.5. Added FA sample size for non-commercial parts to section 3.4. Added box/crate identification criteria to 3.11. Changed label with barcode in 3.11.3. Added shock, vibration to 3.11.5.	E. Kordas/ H. ONeil/ E. Murphy
E	12/5/2023	04	Updated Related Documents and References; corrected Table of Contents	T. Brand
E	5/6/2024	05	Updated to incorporate into new template SIG4-1098. Updated overall formatting. Allow FA approval by extension for identical parts (Section 3.4)	B. Hodges
E	7/11/2024	06	Replaced 2.4 Supplier Performance Rating (Scorecard) Title with Supplier Performance Rating / OSP Scorecard. Added C of C bullet point notes below the "source control" bullet notes, Pg 17.	B. Hodges
E	9/04/2024	07	Added a process for nonconforming components returning from OSP Suppliers, Pg 13.	B. Hodges E. Kordas
E	10/21/2024	08	Fixed formatting issues throughout document.	B. Hodges
T	11/05/2024	09	Expanded the FA sample parameters. Pg 7-8. Added ammunition date of manufacture. Pg. 17. Traceability Requirements for Supplier certs/sub tiers.	K. Cress C. Mack J. Cooper E. Kordas

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T	02/14/2025	10	Section 3.4 – changed FA needed after 12 months to 24 months for commercial only. Added note regarding non-commercial FAs remaining at 12 months.	E. Kordas M. Turgeon K. Cress
T	12/23/2025	11	Significant changes to section layout as well as the addition of sections specifically for commercial/non-commercial certification requirements.	C. Treadwell M. Shilladay J. Cooper E. Kordas B. Dunnigan

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