

# Quality Work Instruction

## Title: Sublet Print Revision Control

### 1.0 PURPOSE:

1.1 To ensure sublet vendors manufacture to the current revision level.

### 2.0 SCOPE:

2.1 Applies to the Quality Work Instructions Manual for Herker Industries and Engineered Assemblies.

### 3.0 DEFINITIONS:

3.1 **Herker's Customer Revision Level:** This is the revision level specified by Herker's customer.

3.2 **Drawn Date:** The 'Drawn Date' is Herker's process print revision level. This allows Herker to change their manufacturing process to obtain the customer's requirements per the customer's revision level.

### 4.0 PROCEDURE:

4.1 **Vendor** Verifies the PO# specified on Herker's print matches with the actual Purchase Order to ensure that the Vendor is manufacturing to the correct print. The PO# will be specified on the print header or with a "Controlled Red" stamp.

4.2 **Vendor** Compares their records to Herker's customer revision level and Herker's "Drawn Date" to determine if the requirements have changed from previous orders.

### 5.0 REFERENCES:

### 6.0 ATTACHMENTS:

- 6.1 Process Print
- 6.2 Title Block
- 6.3 Old Process Print
- 6.4 Old Title Block
- 6.5 Print with Alternate "Controlled Red" Stamp
- 6.6 Alternate "Controlled Red" Stamp

POSITION	SIGNATURE	DATE
Sr. Director of Operations		
Director of Engineering		
Purchasing / Materials Manager		

# Quality Work Instruction



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### ATTACHMENT 6.1



#### Process Print

JOB # 012345 -- PO # (IF SUBLET) \_\_\_\_\_ 01 24,2007

*Print is valid only for specified PO #.*

NEW PART		DRAWN REV. DATE		1/18/07			
DESCRIPTION		NAME	DATE	PART #: 12345		OP. #	
<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF HERKER INDUSTRIES. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF HERKER INDUSTRIES IS PROHIBITED.		DRAWN	KFA	1/18/07	DESCRIPTION: PART		10
DIMENSIONS ARE IN INCHES ALL CORNERS .015 MAX BRK NO BURRS ALLOWED TOLERANCES: FRACTIONAL: ±.015 ANGULAR: ±1° .XX ±.010 .XXX ±.005 Ø'S TO BE  WITHIN .010 T.I.R. 150 MAX SURFACE FINISH		CHECKED	RJW	1/19/07	SCALE: A		A
		APPROVED	DC	1/20/07	MATERIAL: STEEL		1:1
						<CK>= CUSTOMER KEY CHARACTERISTIC <HK>= HERKER KEY CHARACTERISTIC SHEET 1 OF 1	

### ATTACHMENT 6.2 Title Block

NEW PART		DRAWN REV. DATE		1/18/07			
DESCRIPTION		NAME	DATE	PART #: 12345		OP. #	
<b>PROPRIETARY AND CONFIDENTIAL</b> THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF HERKER INDUSTRIES. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF HERKER INDUSTRIES IS PROHIBITED.		DRAWN	KFA	1/18/07	DESCRIPTION: PART		10
DIMENSIONS ARE IN INCHES ALL CORNERS .015 MAX BRK NO BURRS ALLOWED TOLERANCES: FRACTIONAL: ±.015 ANGULAR: ±1° .XX ±.010 .XXX ±.005 Ø'S TO BE  WITHIN .010 T.I.R. 150 MAX SURFACE FINISH		CHECKED	RJW	1/19/07	SCALE: A		A
		APPROVED	DC	1/20/07	MATERIAL: STEEL		1:1
						<CK>= CUSTOMER KEY CHARACTERISTIC <HK>= HERKER KEY CHARACTERISTIC SHEET 1 OF 1	

*The 'Drawn Date' is Herker's process print revision level. To be written as Day/Month/Year from 06FEB07 forward. Previous versions to be written as shown here.*

*The 'Rev.' is Herker's customer revision level.*

# Quality Work Instruction

## Title: Sublet Print Revision Control

### ATTACHMENT 6.3 Old Process Print

JOB # 012345 -- PO # (IF SUBLET) \_\_\_\_\_ 01 24,2007

*Print is valid only for specified PO #.*

NEW PART	1/18/07	<b>Herker</b> Industries, Inc.
DESCRIPTION	DRAWN REV. DATE	<HK> = HERKER KEY CHARACTERISTIC <CK> = CUSTOMER KEY CHARACTERISTIC
CUSTOMER --	PROC. STD	TOLERANCES UNLESS OTHERWISE SPECIFIED
PART NO. 12345	REV. A	FRACTIONAL ±.015 DECIMAL .XX ±.010 .XXX ±.005
OPERATION HEAT TREAT	NO. 10	ANGLES ±1° ALL CORNERS .015 MAX BRK
MATERIAL STEEL	SCALE STD	SURFACE FINISH 150 DIAMETERS TO BE CONCENTRIC TO EACH OTHER WITHIN .010 T.I.R. NO BURRS ALLOWED
DRAWN BY R.J.W.	CHK BY DC 1/19/07	APVD BY KEA 1/19/07
	DATE 1/18/07	

### ATTACHMENT 6.4 Old Title Block

NEW PART	1/18/07	<b>Herker</b> Industries, Inc.
DESCRIPTION	DRAWN REV. DATE	<HK> = HERKER KEY CHARACTERISTIC <CK> = CUSTOMER KEY CHARACTERISTIC
CUSTOMER --	PROC. STD	TOLERANCES UNLESS OTHERWISE SPECIFIED
PART NO. 12345	REV. A	FRACTIONAL ±.015 DECIMAL .XX ±.010 .XXX ±.005
OPERATION HEAT TREAT	NO. 10	ANGLES ±1° ALL CORNERS .015 MAX BRK
MATERIAL STEEL	SCALE STD	SURFACE FINISH 150 DIAMETERS TO BE CONCENTRIC TO EACH OTHER WITHIN .010 T.I.R. NO BURRS ALLOWED
DRAWN BY R.J.W.	CHK BY DC 1/19/07	APVD BY KEA 1/19/07
	DATE 1/18/07	

*The 'Drawn Date' is Herker's process print revision level.*

*The 'Rev.' is Herker's customer revision level.*

