

# Pacific Metallurgical Customer Purchase Order Requirements

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As an aerospace special processor maintaining NADCAP and AS9100 approval, Pacific Metallurgical is required to conduct a detailed contract review on each order we receive. In order to conduct this contract review, specific information needs to be present on every purchase order we receive. The following is a list of the minimum information needed on a purchase order per the requirements of NADCAP, the relevant Primes, and individual processing specifications. **Failure to provide this information will result in the order being placed on hold until the issue can be resolved.** We appreciate your help and understanding when providing this information.

## **For all orders, the following information is required:**

- Customer name
- Contact information (Name, Phone number and/or email address)
- Quantity of the parts (and test pieces, if any)
- Part numbers, if applicable
- Description or dimensions of the parts
- Material alloy and current condition
- Processes to be performed
- Specification, revision, and applicable PSD's or amendments
- Minimum amount of material to be removed from all surfaces after heat treatment (alloy steel and titanium only)
- Temperatures, times, and other parameters if these processing variables are not defined by the specification
- Straightening and stress relieving requirements (if required)
- Inspection and sampling requirements (as applicable)
- Corrosion protection requirements (if required)
- Packaging and shipping requirements (if required)

## **For orders requiring processing per aerospace specifications, the following general information is also required:**

- Note: Orders subject to Boeing's D1-4426 Document must follow the purchase order requirements listed in D1-4426 Appendix D. <http://active.boeing.com/doingbiz/d14426/Appendix-D.pdf>
- Identification of the prime aerospace customer that has design authority
- Identification of the aircraft model or hardware that the part numbers represent where applicable. (e.g. Boeing 777, Airbus A320, etc.) (For Boeing parts, identification of the Division that has design authority such as Commercial, Defense, or Helicopter is acceptable. This information tells PMI which PSDs apply.)
- Cleaning requirements - the following must be cleaned per applicable specifications prior to sending to Pacific Metallurgical:
  - Aluminum
  - Titanium; please provide a copy of the cleaning cert.

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-Inconel that will be heat treated to the RPS 12.01 specification; please provide a copy of the cleaning certification.

-PH steels that are contaminated with low melting point metals (e.g. lead, tin, bismuth, zinc, wood's metal), or that require passivation.

-400 Series stainless steels that will be heat treated to the DPS 5.00 series specifications; please provide a copy of the cleaning certification.

## **For AMS-2759 specifications the following information is required per the corresponding sub-spec:**

All AMS2759 specifications:

**-Purchase orders must state the specific specification revision being requested.** This is a requirement of the ORDERING INFORMATION section of every AMS2759 document.

AMS2759/1F

- Purchase orders must state the specific specification revision being requested.
- Purchase order must state if parts are designated as Damage Tolerant, Maintenance Critical, or Fracture Critical.
- Tensile strength or hardness if other than that stated in Table 3.
- The part Type designation (removing more than 0.020" from all surfaces after heat treatment is Type 1, removing less than 0.020" from any surface after heat treatment is Type 2).

AMS2759/2G

- Purchase orders must state the specific specification revision being requested.
- Purchase order must state if parts are designated as Damage Tolerant, Maintenance Critical, or Fracture Critical.
- Tensile strength or hardness if other than that stated in Table 3.
- The part Type designation (removing more than 0.020" from all surfaces after heat treatment is Type 1, removing less than 0.020" from any surface after heat treatment is Type 2).

AMS2759/3G

- Purchase orders must state the specific specification revision being requested.

AMS2759/4D

- Purchase orders must state the specific specification revision being requested.

AMS2759/5E

- Purchase orders must state the specific specification revision being requested.

AMS2759/6B

- Purchase orders must state the specific specification revision being requested.
- Must state that parts are free from surface contamination prior to being sent out for nitriding.

AMS2759/7B

- Purchase orders must state the specific specification revision being requested.
- Must state that parts are free from surface contamination prior to being sent out for Carburizing.

AMS2759/11A

- Purchase orders must state the specific specification revision being requested.
- Cycle 1 or Cycle 2 when stress relieving austenitic corrosion resistant steels (300ss)
- Current condition of the parts, and if parts are made from strain hardened material or parts that have been intentionally cold worked, strain hardened, or peened.
- Tempering or aging temperature as applicable that was last performed.
- Minimum hardness or strength that parts have been heat treated to.
- Whether the stress relieve process to be performed is pre-plate, pre-chemical processing, or before other processing