HISTORIQUE / *HISTORY*

Date	Rev	Changements	*Change*
2007-October 17	Rel	Première version	*First Release*
2008-Noveber -27	1	Allocation pour rejet maintenant sur bon d'achat. Couvre tout type d'impression. Plus autres précisions.	*Scrap allowance will be referenced on the Purchase Order.* Scope not limited to pad printing anymore. Plus other precisions added.
2009-February -25	2	Nouvelles exigences pour les fournisseurs. Sections 12.0 et 13.0 ajoutées.	*New requirements for suppliers. Sections 12.0 and 13.0 added.*
2011-February 18	3	Nouvelle exigence pour la rétention des documents par les fournisseurs	*New requirement for suppliers regarding documents' retention time*
2012-February -20	4	Nouvelles exigences pour les fournisseurs : Demandes Spéciales, Droit d'accès spécial, Changement des matériaux, processus de fabrication ou de site de fabrication	*New requirements for suppliers regarding Special Requirements , Special Rights of Access , Change to materials, manufacturing process or manufacturing facility location*
2013-February 04	5	Combiné dans la Clause 13 le droit d'accès spécial	*Combined special right of access into Clause 13 right of access*
2017- February 09	6	Maintenant applicable aussi aux pièces peintes et plaqué. Réécriture pour ajouter clarté différentes sections. Ajout de Section 18 évaluation de la performace.. Ajout de nouvelles photos	*Applicable now also to Painted and Plated parts. Rewriting to add clarity various sections, Added section 18 Performance Evaluation. Added new Pictures*
2020-Feb-26	7	Changement de logo et nom de compagnie. Changement de titres de postes	*Changed company's name and logo. Changed titles.*

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APPROBATION / *APPROVAL*

Director of Quality	Date 2020 Feb 26
Production Manager	Date 2020 Feb. 26

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Purpose

The purpose of this document is to ensure that painted, plated, and printed parts meet both Precikam and end-customer requirements, and, when applicable, regulatory authorities' requirements.

1.0 Scope

Covers the requirements associated to sub-contracting operations of plastic parts between Precikam and the Suppliers: Painter (subcontractor of painted parts), Plater (sub-contractor of the plated parts) or Printer (sub-contractor of printed parts). The term Customer refers to Precikam's end customer.

2.0 Acceptance Criteria for Painted and Plated Parts (Appendix 1)

- The paint or the metallic plating must be as per the approved Master Sample (paint grade, shade, thickness, texture);
- No surface marks such as bubbles, scratches, fingerprints, dust, embedded fibers, missing finish, are accepted;
- Paint or Plating resistance tests must be done by the Painter or the Plater at every production as per instructions supplied and approved at the beginning of the project;
- The quality of the Paint or Plating must be consistent throughout the lot and from lot to lot;
- The Supplier is responsible to perform 100 % inspection of the parts before shipping them to Precikam.
- A Certificate of Conformity or Compliance must be provided with each shipment.

3.0 Acceptance Criteria for Printed Parts (Appendix 1)

- The ink must be as per the approved Master Sample (ink grade, color, shade, thickness, texture);
- The printed parts must be free of defects such as incomplete letters, smudges, misalignment, double printing, porous printing - printing too thin, that allows plastic to be seen under the letter;
- Ink resistance tests must be done by the Printer at every production as per instructions supplied and approved at the beginning of the project;
- The quality of the ink must be consistent throughout the lot; and from lot to lot
- The Supplier is responsible to perform 100 % inspection of the parts before shipping them to Precikam;
- A Certificate of Conformity or Compliance must be provided with each shipment.

4.0 Processing Conditions

Plastic parts must not be submitted to temperatures exceeding 175°F for more than 45 minutes, to chemicals or to other treatments that can influence negatively the properties of the part.
Once a Master Sample is approved, no change to processing parameters can be done without Precikam' s written approval.

5.0 Special Requirements for Quality of Printed and Painted Parts (additional)

If special requirements, such as qualification of personnel, identification and revision status of specifications, process requirements, inspection and verification status, relevant technical data, test, inspection, verification methods (including production process verification), use of statistical techniques for product acceptance and related instructions for acceptance, critical items (critical, special and key characteristics as defined by Precikam or its Customer), requirements for test specimens (e.g. production method, number, storage conditions), requirements for inspection, verification, investigation or auditing, are required from the Supplier, as well as its supply chain, these requirements will be mentioned on the Purchase Order and reference will be made to this clause.

6.0 Scrap Allowance

The Scrap Allowance is the percentage of the plastic parts provided by Precikam to the Supplier that can be used for set-up and internal rejects without the Supplier being charged.
Precicam's Purchase Order or Supplier Agreement specifies the Scrap Allowance percentage for each part or project, to which the Supplier agrees at the beginning of the project.
The Precikam Purchase Order specifies the number of parts sent to the Supplier. If the number of parts returned to Precikam is lower than the agreed Scrap Allowance, the cost of the missing parts in excess of the Scrap Allowance can be charged to the Supplier.

7.0 Defective parts found by Precikam or by the Customer

Any defective part found by Precikam will be put aside and charged back to the Supplier, regardless of the Scrap Allowance. The cost of any operation done on the part up to the moment the defect is found will be charged to the Supplier. The cost of the plastic part could be charged to the Supplier, if the number of rejected parts is more than the Scrap Allowance for the specific Purchase Order.
If a defective part is found by the Customer, the cost of the defective part or the assembly in which the part was used will be charged to the Supplier.

8.0 Return of defective parts to the Supplier

Any rejected parts will be separated and clearly identified. Precikam will contact the Supplier; ask for a Return Authorization Number (RMA) that will be used as reference number for credit request. The parts will be returned to Supplier, unless otherwise instructed in writing.

9.0 Rework on the parts

Any defective parts can be re-worked by the Suppliers, if the quality of the part is not affected and no visible residue remains on the part. For specific applications, the re-work of the parts must be done only with Precikam's approval, and this will be mentioned Precikam's Purchase Order.

10.0 Traceability

Traceability of Parts: Precikam assigns a Purchase Order number (KPxxxxx) to each lot of parts sent to Supplier; all communications and all reject identification must refer to this number. The Supplier must keep traceability information as when the parts were processed, on what machine, by whom, etc. and must be able to provide this information upon request.

Traceability of Boxes containing Accepted parts: the Supplier will identify the boxes with the PO number (KPxxxx), the date of processing and the initials of the person who approved the work

Traceability of Boxes containing Scrap parts: if the Supplier decides to return any rejected parts to Precikam, the Supplier will identify these boxes with the PO number (KPxxxx), the type of reject (plastic, print, paint, plating, etc.) and the quantity. The type and quantities must match the information on the Packing Slip.

Traceability of Records: the Supplier must keep all relevant records regarding the manufacturing of each production lot for a period of minimum 5 years. If the Supplier is requested to keep records for more than 5 years, this request will be mentioned on the Precikam Purchase Order.

11.0 Packaging

Unless otherwise specified on the Precikam Purchase Order, the parts are to be returned in the same boxes that they came in, that have the original Precikam manufacturing information. Extra boxes at the end of a run must be discarded and must not be kept for future shipments. Parts must be packaged in a way that will prevent any scratch or other damage done to the parts during transportation.

The Purchase Order will specify if a special protective tape must be applied or if other special methods of packaging must be used.

12.0 RoHS Compliance

The inks, metallic finishes, or paints (including any additive, solvent, colorant, etc.) used must meet the Restriction of Hazardous Substances in Electrical and Electronic Equipment (RoHS3) Directive (2015/863).

13.0 Right of Access

Precikam, our Customers, or regulatory authorities can request right of access to applicable areas of facilities at any level of the supply chain applicable to the order, and to applicable records for the products manufactured for Precikam, with the purpose of performing quality system audits of the departments, processes, and relevant records applicable to the supply chain manufacturing process. The visit will be used to assure that the Supplier's facility has the capability of producing consistent quality products to the levels required by Precikam.

The information gathered from the visit can become part of the product or process feasibility, as required by Precikam Advanced Quality Planning process at the onset of each potential Customer contract.

14.0 Changes to Materials, Manufacturing Process or Manufacturing Facility Locations

Any changes to Supplier's raw materials, suppliers, manufacturing process, or manufacturing facility location must be communicated in writing to Precikam for approval, prior to proceeding. Precikam will reserve the right to require sample submission based on the nature of the change and Customer's approval might be required.

15.0 Shipment of non-conforming or suspect product

If the Supplier finds that non-conforming or suspect product has been shipped to Precikam, the Supplier must inform Precikam's Director of Quality immediately with details about the nature and extent of the non-conformance.

16.0 Deviation

Any deviation to this Procurement Specification must be communicated in writing to Precikam for approval, prior to proceed with the deviation.

17.0 Supplier Performance Evaluation

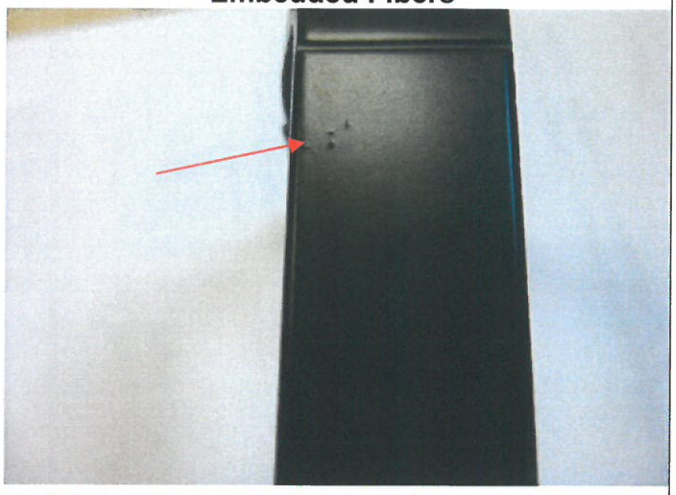
Precikam monitors and evaluates the Suppliers on a regular basis. Criteria for evaluation are: On time delivery, Scrap allowance, Customer Service. Precikam will ask the Supplier to take action and correct any failure to achieve the evaluation criteria.

Appendix 1

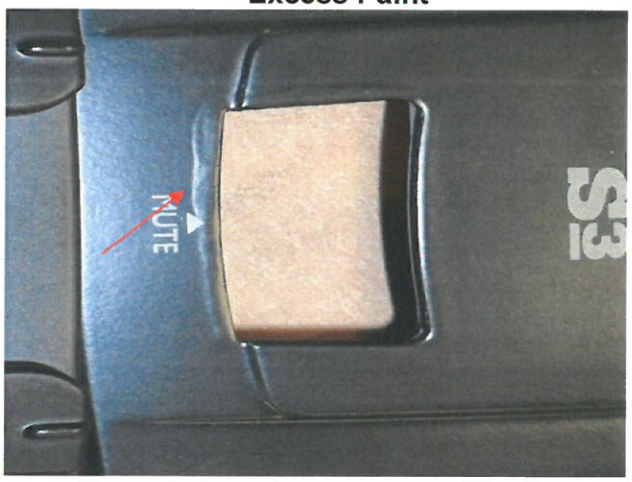
Reject Criteria for Visual Inspection Painted Parts

Paint Bubbles

Embedded Fibers



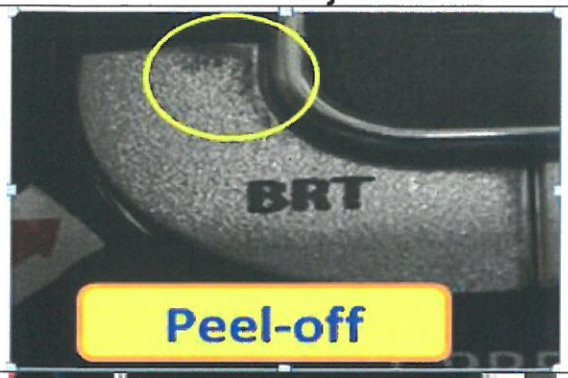
Excess Paint

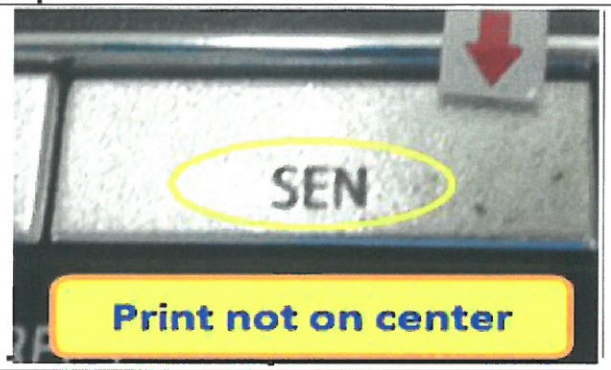


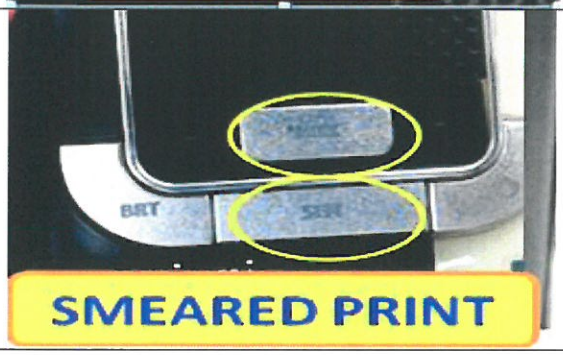
Uneven Paint

Excess Paint

Reject criteria for Visual Inspection - Plated Parts

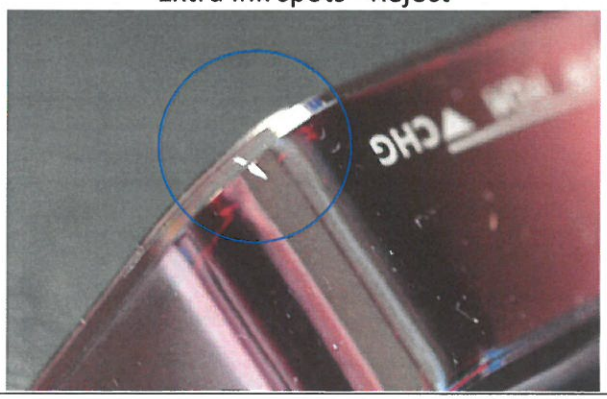




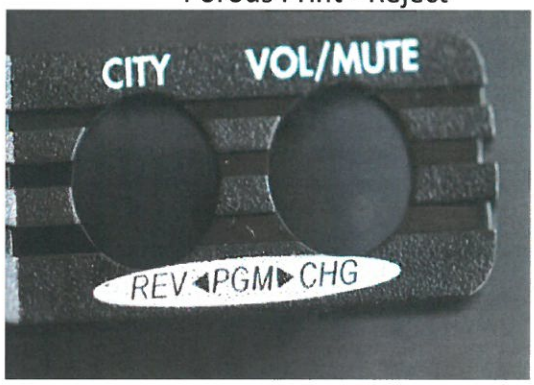


Reject criteria for Visual Inspection - Pad Printed Parts

Extra ink spots– Reject



Porous Print - Reject



Ink too Thin - Reject

Smudging of the print - Reject

END OF THE DOCUMENT