

CIRCOR					Rev
Coating Quality Plan Requirements					1
TIER #	TIER	Program	Policy	Program Code	Page
4	MSF	Q	0.1-2	1.8-3	1 of 3

Quality Plan No. / Revision	Coating QP-03/Rev0
Purchase Order No.	Standard Plan – See Purchase Order
Material Specification No. / Revision	N/A

The following Quality Plans are mandatory and are required to be followed with this Quality Plan:

- ✓ MSF 1.8-5, Heat Treatment (if applicable to the coating process)
- ✓ MSF 1.8-1, Calibration Service Quality Plan Requirements

Identify Applicability
(place an X in the appropriate box)

<input type="checkbox"/>	Required procedures are submitted for review by the applicable CIRCOR API Manufacturing Location Engineering and/or Quality Departments or by a Subject Matter Expert (SME)
<input type="checkbox"/>	Required procedures are reviewed Onsite by competent CIRCOR Supply Chain location personnel
<input type="checkbox"/>	Technical audit
<input type="checkbox"/>	API Specification 6A is applicable
<input type="checkbox"/>	API Specification 6D is applicable

Purchasing agreements shall include the following provisions identified by this Quality Plan.

Only vendors that are in good standing in the Approved Vendors List shall be used. Refer to **MSPM 1.8, Purchasing Control** for other purchasing order requirements that may be required.

1. The vendor is required to submit to **CIRCOR** for review:
 - a. A copy of the coating procedure including:
 - i. The vendor's criteria for the qualification and approval of process(es). This also includes provisions for process re-validation.
 - ii. Blast cleanliness requirements
 - iii. Visual inspection requirements and acceptance criteria
 - b. Copies of the coating applicator qualification records
 - c. Copies of calibration records for inspection, testing, monitoring and measurement equipment used in the performance of coating activities

CIRCOR					Rev
Coating Quality Plan Requirements					1
TIER #	TIER	Program	Policy	Program Code	Page
4	MSF	Q	0.1-2	1.8-3	2 of 3

2. The vendor shall submit any proposed changes coating procedure to for **CIRCOR** review prior to using it on **CIRCOR** orders when changes are proposed.
3. The vendor is required to provide evidence of inspection results for:
 - a. Blast cleanliness
 - b. Anchor profile
 - c. Primer coat thickness
 - d. Final coat thickness
 - e. Visual inspection against specified acceptance criteria
4. The vendor is required to submit calibration records for the following coating equipment:
 - a. Anchor Profile Gages
 - b. Sling Psychrometer (or other humidity indicator)
 - c. Thermometer (or temperature indicator)
 - d. Dry Film Thickness Gages
5. The vendor shall provide a Certificate of Conformance(s) to document:
 - a. The vendor's coating procedure number and revision level
 - b. Applicator training and evidence of meeting experience requirements
 - c. Inspection equipment current calibration (traceable to NIST or equivalent national or international standard).
6. Conformance to the requirements stated herein provides sufficient evidence of equipment approval.
7. The vendor shall not subcontract the performance of any coating activities to a sub-vendor without **CIRCOR** approval.
8. The vendor shall notify **CIRCOR** if any portions of the activities covered by this PO are going to be subcontracted.

CIRCOR					Rev
Coating Quality Plan Requirements					1
TIER #	TIER	Program	Policy	Program Code	Page
4	MSF	Q	0.1-2	1.8-3	3 of 3

Quality Plan Required Documentation - COATING			
Quality Plan Reference Requirement	What is required?	Circor Review Required	
		Yes	No
1a	Coating Procedure	X	
1b	Personnel Qualification Records	X	
3	Inspection Results for: a. Blast Cleanliness b. Anchor Profile c. Primer Coat Thickness d. Final Coat Thickness Visual Inspection Against Specified Acceptance Criteria	X	
4	Calibration Records for: a. Anchor Profile Gages b. Sling Psychrometer (or other humidity indicator) c. Thermometer (or temperature indicator) d. Dry Film Thickness Gages	X	
6	Certificate of Conformance	X	
Attachment I	Including records specified by MSF 2.3.1-1, Supplier Documentation Requirements for this Quality Plan	X	

CIRCOR Supply Chain Location Approval Mike Evans 3/1/18
Signature Date

CIRCOR API Manufacturing Site Approval Carlos Castillo 3/1/2018
Signature Date

CIRCOR API Manufacturing Site Approval Tim M. [Signature] 3/1/2018
Signature Date