



Workmanship:

- Plating and Anodizing shall meet the specification identified on the applicable Westinghouse drawing unless otherwise specified in the CMC purchase order or specification.
- E-Coat shall meet the color, process, and material identified on the applicable Westinghouse drawing unless otherwise specified in the CMC purchase order or specification.
- Subcontracted coating services shall be performed in accordance with CMC's purchase order requirements. Purchase orders and/or drawings shall include applicable technical requirements; a Certification of Compliance is required for all subcontracted (i.e. plating, anodizing, e-coat, etc.) services.
- The Subcontractor is permitted to deposit plating or anodizing material in tapped holes, provided that the tapped holes are dimensionally correct and the threads engage properly per specification after plating or anodizing.
- 100% coverage is required on coated areas unless paint or powder coat is to be applied over coated surface.
- The Subcontractor shall handle all plated items with clean gloves (e.g. cotton, nitrile, etc). Oils and acids from bare hands can potentially damage plating resulting in part rejection.

Calibration Requirements:

- The Subcontractor shall utilize calibrated equipment for fabrication and inspection in accordance with their Quality Program.
- The Subcontractor's calibration services provider shall be ANSI/ISO/IEC 17025 accredited.
- Accreditation of the calibration services provider is to be provided by a signatory of the International Laboratory Accreditation Cooperation (ILAC) Mutual Recognition Arrangement (MRA) (e.g. NVLAP, A2LA or ACLASS).
- The calibration services provider's published accreditation scope shall cover the contracted services including the needed measurement parameters, ranges, and uncertainties.
- The calibration services provider shall provide as-found calibration data when calibrated items are found out-of-tolerance.
- The calibration services provider shall identify laboratory equipment/standards used on instrument calibration records.



Plating Inspection (Applies When Referenced On CMC P.O.) FM-059 Rev. 3

- The Subcontractor may utilize an in-house calibration process provided calibration procedures are documented and the standard used for performing the calibration are in accordance with the requirements above.
- The Subcontractor shall report as-found calibration data to CMC when calibrated items are found to be out-of-tolerance.

Inspection Personnel Requirements:

- Personnel performing inspections shall have an annual vision examination for near vision acuity and color contrast differentiation satisfying the following criteria: Natural or corrected near vision acuity in at least one eye capable of reading a minimum of Jaeger Number 1 letters on a standard Jaeger test chart at a distance of not less than 12 inches or equivalent test pattern demonstrating near vision acuity of a Snellen fraction 20/25 or better AND Ishihara or equivalent color vision examination to show ability to distinguish and differentiate contrasts between colors.
- Inspection reports shall identify dimensional requirements as an acceptable range, rather than as a nominal +/- a tolerance. This is a best practice that prevents simple human error resulting from an inspector calculating the acceptable range in his/her head at the time of inspection.
- The following inspections shall be performed by designated inspectors who are not directly responsible for subcontracting the part being inspected, unless otherwise specified.
- The Subcontractor's personnel performing inspections shall handle all plated items with clean gloves (e.g. cotton, nitrile, etc). Oils and acids from bare hands can potentially damage plating resulting in part rejection.

Inspection:

- Plating Inspection – Subcontractor shall inspect 100% of all items to the requirements of the applicable revision of WNA-IG-00373-GEN.
- Subcontractor shall measure the plating thickness on a sample of parts according to Table 1 (one measurement per part minimum) to confirm they meet the minimum plating thickness acceptance criteria defined on the applicable drawing. This data shall be (1) recorded by the Subcontractor in an inspection report, (2) included in hardcopy with the shipment back to CMC and (3) E-mailed to quality@cmc-usa.com.
- Paint (including powder), anodizing, and E-Coat Inspection – Subcontractor shall verify 100% of all items meet the applicable requirements of the CMC purchase order, including the applicable revision of WNA-IG-00373-GEN.



**Plating Inspection (Applies When Referenced On CMC P.O.)
FM-059 Rev. 3**

Production Lot Size	Sample Size
1	1
2 – 4	2
5 – 6	3
7 – 11	4
12 – 20	5
21 – 24	6
25 – 28	7
29 – 32	8
33 – 41	9
42 – 50	10
51 – 56	11
57 – 62	12
63 – 69	13
70 – 76	14
77 – 83	15
84 – 90	16
91 – 96	17
97 – 102	18
103 – 108	19
109 – 114	20
115 – 120	21
121 – 126	22
127 – 132	23
133 – 138	24
139 – 144	25
145 – 150	26
151 – 162	27
163 – 174	28
175 – 186	29
187 – 198	30
199 – 210	31
211 – 225	32
> 225	32

Packaging Requirements:

- Completed items are to be packaged and shipped in accordance with standard industry practice and in addition shall meet the following minimum criteria:
 - Items shall be inspected by Subcontractor prior to packaging and, if necessary, cleaned.
 - Items not immediately packaged shall be protected from contamination.
 - Items shall be packaged to preclude damage during shipment, prevent moisture exposure, and facilitate ease of unpacking of the product.
 - To preclude damage to coatings, items shall be isolated from each other with packing material prior to packaging in final container.
 - Items shall also be isolated from interior walls of final container to preclude damage from exterior impact.



Plating Inspection (Applies When Referenced On CMC P.O.) FM-059 Rev. 3

Subcontractor shall measure the plating thickness on a sample of parts according to Table 1 (one measurement per part minimum) to confirm they meet the minimum plating thickness acceptance criteria defined on the applicable drawing. This data shall be (1) recorded by the Subcontractor in an inspection report, (2) included in hardcopy with the shipment back to CMC and (3) E-mailed to quality@cmc-usa.com.

Attach inspection results and at a minimum shall include:

- CMC Purchase Order
- Part Number
- Lot quantity
- Sample quantity
- Measurement results
- Inspection gage used, including calibration date and next due date
- Inspection personnel name