



Setra Systems LLC Supplier Handbook

V8 – March 6, 2026



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1. ABOUT SETRA SYSTEMS, LLC

- 1.1. Setra Systems, LLC is comprised of Setra Systems and Gems Sensors & Controls. The companies were merged in 2023 and do business as Setra Systems (Setra) and Gems Sensors & Controls (Gems), referred to herein collectively as "Gems Setra". We design and manufacture reliable and innovative sensing and monitoring technologies to deliver solutions to customers' problems and challenges.
- 1.2. Our headquarters are in Boxborough Massachusetts. We are a global company with production facilities in the USA (Massachusetts and Connecticut), Great Britain and Asia.
- 1.3. Setra systems, LLC is part of the Ralliant group of companies, based in North Carolina with 7,000 team members worldwide. The Ralliant business system (RBS) is the cornerstone of our culture and our ultimate competitive advantage. We deliver precision instruments and solutions for mission-critical industries, giving engineers the confidence to push boundaries.

2. PURPOSE OF DOCUMENT

- 2.1. The purpose of this document is to elaborate on the expectations Gems Setra has of its suppliers. The intent is to improve the accuracy and efficiency of communications, in-bound shipments and products, and invoicing.

3. SUPPLIER CODE OF CONDUCT

- 3.1. Supplier will comply with all laws and regulations applicable to their business, and the standards of its industry, including those pertaining to the manufacture, pricing, sale, distribution, labeling, import, and export of merchandise. Without limiting this requirement, Supplier will not: (A) violate, misappropriate or infringe upon the intellectual property rights of Ralliant and its subsidiaries or any third party; or (B) engage in any activities which would violate any applicable laws and regulations relating to (1) bribery or illegal payments, (2) laws against unfair competition, (3) unfair and deceptive trade practices, (4) the environment, (5) health and safety, (6) international trade, including exports and imports, (7) data privacy, (8) money laundering, (9) employment, (10) contracting with governmental entities, or (11) medical devices, if applicable. **For more information, please visit: www.Ralliant.com/suppliers**

4. QUALITY

4.1. DPPM (PPM)

- 4.1.1. Gems Setra expects that all suppliers achieve a DPPM (defective parts per million) level of 1500 or better. A suppliers DPPM level will be monitored monthly using a rolling 3-month basis.

$$DPPM = \frac{\text{Quantity Rejected}}{\text{Quantity Received}} * 1,000,000$$

4.2. SUPPLIER CORRECTIVE ACTION REQUESTS (SCAR)

- 4.2.1. Gems Setra will generate a NCR (non-conformance report) for any material that doesn't meet Gems Setra drawings and /or specifications. Supplier will be notified of the discrepant material via a NCMR form or a SCAR (Supplier Corrective Action Request) form. A SCAR will require a supplier to submit formal written corrective action to address the non-conformance. The necessity for a SCAR will be evaluated by Gems Setra and will consider potential impact to production costs, quality costs, performance, reliability, safety, and customer satisfaction. The supplier is expected to complete all the sections of the SCAR form with correct information and provide additional supporting documents where applicable. The completed SCAR form must be returned via email within 20 (twenty) days from the issue date for timely closure.
- 4.2.2. Gems Setra will disposition the discrepant material as; use-as-is, return to vendor, sort, or rework based on severity and production requirements.
- 4.2.3. An example of a SCAR and a NCMR Form is included in the Appendix

4.3. QUALITY RETURNS (RMA)

4.3.1. RMA (Return Material Authorization) process:

4.3.1.1. Gems Setra will contact supplier to request a RMA # via a RMA request form. The Supplier is expected to have the RMA#, shipping account number and shipping address back within 48 hours after the initial request was issued.

4.3.1.2. Gems Setra will generate a DM (debit memo) using the information from the RMA form. 4.3.1.3. The supplier will receive a copy of the DM from Gems Setra ERP system for return of parts. NOTE: The DM does NOT authorize the supplier to send replacement material

4.3.1.4. The buyer will issue a separate PO to the supplier for the replacement material if required.

4.3.1.5. Gems Setra will take the debit against open invoices for the supplier.

4.4. SORTING/REWORK

4.4.1. Should Gems Setra need to sort or rework material; Gems Setra will bill the supplier at a rate of up to \$70 per hour for sorting and any other rework charges incurred based on required resources.

4.4.2. Alternatively, the supplier can send a representative within 24 hours to sort or rework the material at Gems Setra facility.

4.5. SUPPLIER DEVIATION REQUESTS

4.5.1. In certain instances, it may be permissible for the supplier to temporarily deviate from drawing requirements and specifications. Supplier may request a SRW (Supplier Request for Waiver) form from Gems or a TDN (Temporary Deviation Notification) from Setra. The forms must provide all required and pertinent information concerning the requested deviation. If non-conforming material is associated with the deviation, the supplier is responsible for the segregation of the non-conforming material until approval is granted. Any discrepant material received at Gems Setra without an approved SRW or TDN may be rejected and returned to the supplier at the supplier's expense with all additional handling and shipping costs incurred by the supplier. Once a deviation is approved, all material shipped with the allowed deviation must be accompanied by a copy of the signed and approved SRW or TDN.

4.5.2. An example of a SRW and TDN Form is included in the Appendix.

5. ENVIRONMENTAL HEALTH & SAFETY

5.1. Gems Setra is committed to conducting its business in an environmentally responsible manner, in compliance with all applicable environmental, health and safety laws and regulations, and in a manner that promotes pollution prevention and protects the health and safety of our associates, customers, and members of our local communities worldwide. Gems Setra expects Suppliers to demonstrate a commitment to responsible environmental stewardship, and workplace health & safety.

6. ON-TIME DELIVERY (OTD)

6.1. Gems Setra expects that our suppliers will maintain **95% on-time delivery or better**. We work with our suppliers to achieve this goal through such programs as Kanban and VMI. Gems Setra encourages suppliers to provide suggestions that will allow them to attain this goal.

6.2. PO Due date

6.2.1. Purchase order (PO) requested dates are the date that product is expected at Gems Setra dock, it is not the ship date. Suppliers are measured against the shipment requested date, not shipment promise date.

6.3. PO Quantity

6.3.1. Gems Setra reserves the right to return any product shipped more than the quantity ordered. If the quantity shipped is less than the quantity ordered, supplier should obtain buyer approval in writing to close the order. Supplier adherence to this process will be tracked in a quality database as product is received. Suppliers will be notified of violations.

7. MATERIAL REPLENISHMENT PROGRAMS

7.1. Gems Setra uses multiple material replenishment systems to ensure the optimal flow of material. These include: Kanban, VMI (vendor managed inventory), off-site consignment. We determine the best program based on the suppliers/part usage, cost, and manufacturing location. Our primary replenishment system is the Kanban system. When appropriate, Gems Setra may also place discrete POs/spot buys.

7.2. Kanban Basic Program expectations:

- 7.2.1. Suppliers are expected to carry the negotiated minimum inventory levels to meet fluctuating demands.
- 7.2.2. Gems Setra will issue a master blanket purchase order (PO) for each item on the program and will issue a release (Kanban PO) as necessary. The Kanban PO will have its own identifying PO number and will deduct off the master blanket PO.
- 7.2.3. PO quantity determines liability unless otherwise defined in any signed Agreement.
- 7.2.4. The due date for all Kanban PO's will be based on a set lead time agreed to by the Supplier and Buyer. This is the JIT (just-in time) lead time. The due date (or request date) is the date the product is due at Gems Setra's dock.

7.3. VMI basic program expectations:

- 7.3.1. Suppliers are expected to manage the inventory levels at the VMI stocking location and at their facilities for each item on the program.
- 7.3.2. Gems Setra will issue a weekly consolidated PO for each item on the program based on weekly supplier VMI scan report. Product is expected to arrive at Gems Setra within five (5) business days; this is the JIT (just-in-time) lead time.
- 7.3.3. Estimated annual usage (EAU) for each item on the program may be provided upon request. Supplier is expected to use this information to establish recommended ROP/ROQ quantities subject to approval.

7.4. Off-site Consignment basic program expectations:

- 7.4.1. Gems Setra uses a 3PL (3rd party logistics provider) warehouse for inventory management services.
 - 7.4.2. Product stored at the 3PL are considered in consignment and are owned by Supplier until released to Gems Setra.
 - 7.4.3. Gems Setra will issue a master blanket PO for each item on the consignment program and will issue a release (kanban release PO) to ship product from the 3PL to Gems Setra.
 - 7.4.4. Supplier will have access to the 3PL's web portal to view inventory levels and will receive email notices to assist in management of the items on the consignment program.
 - 7.4.5. Gems Setra and Supplier will agree to set inventory aging guidelines.
- 7.5. Suppliers will be expected to consider participation in these programs as requested by Gems Setra. Detailed program requirements may be further defined in a Long-Term or Program Agreement.

8. COST / PURCHASE PRICE VARIANCE (PPV) / VALUE ADD/VALUE ENGINEERING (VA/VE)

- 8.1. Gems Setra expects suppliers to support Gems Setra ability to sell product at a competitive rate. Gems Setra actively encourages and desires suppliers to participate in cost reduction efforts and for these efficiencies to be shared between Gems Setra and the Supplier. Examples of these activities include kaizen events, material evaluation, enhanced manufacturing processes and tooling, etc.

9. SUPPLIER PERFORMANCE

- 9.1. Gems Setra evaluates suppliers primarily based on quality, delivery, cost, and customer service.
- 9.2. Gems Setra Score card - Suppliers performance regarding quality and delivery may be communicated to suppliers via a Gems Setra Score Card transmitted on a periodic basis.
- 9.3. Gems Setra SCIP (supplier continuous improvement plan)– Gems Setra may engage key suppliers in a detailed review of their overall performance metrics.

10. PURCHASE ORDER CONFIRMATION

- 10.1. Suppliers are expected to confirm receipt of each PO with the buyer within 24 (twenty-four) hours. Supplier's failure to acknowledge purchase order quantity, delivery and cost will be assumed to imply acceptance.
- 10.2. Gems Setra Standard Terms and Conditions of Purchase ("Terms") apply. The Terms are located at: <http://www.gemssensors.com/terms-and-conditions> and at <https://www.setra.com/terms-and-conditions>

11. NATIONAL DEFENSE RATING

- 11.1. Gems Setra may issue a PO with US Defense Priority requirement. In the event of a PO being rated as a Defense Priority, Supplier will be advised of the DPAS rating and is required by U.S. law to follow the provisions of the DPAS regulation (15 CFR 700). Detailed requirements for a DPAS rated order can be found at: <http://www.gemssensors.com/terms-and-conditions/> >

12. INVOICING AND PAYMENT

- 12.1. Payment of invoices, less any amounts in dispute, will be made at **net 90 days check/wire transfer** or **net 60 days credit card** from the date of acceptable invoice(s), unless otherwise negotiated in writing. International wires are also an option. For payment to be made promptly, the supplier must send the commercial invoice directly to Gems Setra in one of the following means:

Invoices to Gems Setra:

Primary: Email (preferred): AP@setra.com

Alternate: Mail

Setra Systems, LLC, Attn: Accounts Payable, 159 Swanson Rd., Boxborough, MA 01719 USA
or

Gems Sensors & Controls, Attn: Accounts Payable, 1 Cowles Rd, Plainville, CT 06062 USA

- 12.2. Invoices included with the physical goods will not be processed.
- 12.3. Invoices must include the following:
- 12.3.1. Invoice date
 - 12.3.2. Supplier name and remit to address
 - 12.3.3. Gems Setra PO number(s)
 - 12.3.4. if the shipment is a kanban release, this is the specific release number, NOT the blanket order number
 - 12.3.5. Gems Setra part number(s)
 - 12.3.6. Quantity shipped (in the same unit of measure as on the PO)
 - 12.3.7. Price (in same currency as on PO, usually US dollars)
 - 12.3.8. Packing slip number / reference number that ties each invoice to a specific shipment.

13. PACKAGING AND LABELING

- 13.1. Each package/carton in the shipment should contain a label that specifies the following:
- 13.1.1. Supplier name
 - 13.1.2. Country of Origin
 - 13.1.3. Gems Setra PO number(s)
 - 13.1.4. if the shipment is a kanban release, this is the specific release number, NOT the master blanket PO number
 - 13.1.5. Gems Setra part number(s) and revision
 - 13.1.6. Date of manufacture
 - 13.1.7. Quantity in box
- 13.2. In addition, the shipment should contain, at a minimum, the following paperwork:
- 13.2.1. Commercial invoice (international shipments only)
 - 13.2.2. Packing list
 - 13.2.3. CoC (Certificate of Conformance),
 - 13.2.4. CoO (Country of Origin certification)
 - 13.2.5. Material certifications and secondary operations certifications
 - 13.2.6. Mill certification (as applicable)
 - 13.2.7. Other paperwork as required by Gems Setra
- 13.3. Note: documentation can be sent electronically to: suppliercoc@Gemssensors.com or incomingfreight@setra.com.

- 13.4. Documents should be attached to outside of box, with one set of duplicate documents inside the carton. If shipment contains multiple cartons, the paperwork should be included in one carton clearly marked "paperwork enclosed". An example of each of these documents is included in the Appendix.
- 13.5. Maximum allowable weight for each package is **25 (twenty-five) pounds**. All goods shall be packaged and packed by Supplier adequately to ensure arrival at destination in an undamaged condition. All international shipments must be boxed and contents rust-proofed and otherwise protected to prevent damage in transit and meet all export shipping requirements.
- 13.6. Notice to all Non-Domestic Suppliers: Per U.S. import regulations, all parts must be marked with Country of Origin; all stainless-steel and aluminum parts must include a material certification, traceable to the manufacturing mill, with each shipment
- 13.7. An example of an acceptable Packing List, COC, and Material Certification is included in the Appendix.

14. FREIGHT TERMS

- 14.1. Gems Setra standard freight terms for domestic shipments will be by Gems Setra assigned carrier as FCA Origin, Freight Collect, unless specifically stated otherwise in any Long-Term Agreement between Supplier and Buyer. Shipping terms for international shipments are FCA, Port of Origin, Freight Collect, per INCOTERMS 2010, unless specifically stated otherwise in any such Long-Term Agreement.
- 14.2. In addition, Supplier is expected to follow shipping instructions as listed in Gems Setra freight routing guide, unless otherwise instructed in writing. The routing guide is located on the Gems Setra web site at: <https://www.gemssensors.com/terms-and-conditions>

15. DRAWINGS AND QUOTING

- 15.1. Gems Setra provides 2D drawings to control fit and form of parts. It is Gems Setra expectation that all parts provided will meet ALL of the drawings requirements (including material requirements and notes). Changes that will improve availability or cost of the product may be submitted by Suppliers for review by Gems Setra. If requested change is accepted the drawing will be revised to include the change. Parts supplied must meet the drawing revision level as noted on any PO. In case of any discrepancy, Supplier should notify Buyer.
- 15.2. Any quote submitted without exceptions noted will be assumed to meet ALL drawing requirements.

16. PART QUALIFICATION PROCESS (PQP)

- 16.1. Gems Setra uses PQP (Part Qualification Process) for approval of any new parts. The first time Gems Setra is receiving a part or revision level from that supplier, part is considered under qualification. A part is considered under qualification until the part has received Final Approval by Gems Setra. This requires the supplier to submit FAI (first article inspection) sample parts along with the package of documentation called PQP workbook.
 - 16.1.1 PQP level would be requested at the time FAI PO is placed and PQP level will be indicated on the FAI PO. Submission requirements for different PQP levels are defined in the PQP workbook. There are 3 (three) levels of PQP (namely High, Medium, Low) that Gems Setra could request. PQP level is determined based on the complexity and criticality of the part to Gems Setra application.
 - 16.1.2 Upon submission of PQP package and samples, Gems Setra will make the determination on the approval or rejection of the part and will notify the supplier. This process will typically require 3 (three) or more sample units to be submitted.
- 16.2. Any production quantities of parts produced prior to final acceptance of a part are the responsibility of the supplier unless alternate arrangements have been made in writing by Gems Setra and the supplier.
- 16.3. Part approval does not guarantee PO award.
- 16.4. The transition period to ramp up to full production volumes of a new part may often take as long as 6 months, or longer, while Gems Setra uses up any pre-existing commitments.
- 16.5. PQP documents should be sent electronically to the Requester, for Quality approval, prior to shipping any samples

17. CHANGE MANAGEMENT/COPY EXACT! (CE!)

- 17.1. CHANGES BY GEMS SETRA – Drawings may be revised by Gems Setra. Such changes may require additional qualifications. Gems Setra shall notify the supplier of all relevant revisions by sending the updated print with the first PO or PO revision for the updated part.
- 17.2. CHANGES BY SUPPLIERS – Any changes to form, fit, or function of the part including component, process, and/or design changes must be submitted in writing to Gems Setra prior to making any changes. Verbal notification of changes will not be accepted by Gems Setra. When the supplier submits changes for Gems Setra approval, the information submitted must include a complete description of the change. The Supplier must have a documented process whereby changes that impact Gems Setra are triggered for notification and written approval.
- 17.3. SUB-CONTRACT SUPPLIERS – Gems Setra must be notified at time of quotation of any primary process or procedure not performed directly by the Supplier and outsourced to a subcontract supplier. Additionally, Supplier must notify Gems Setra of any changes to fabrication processes and sub-contract sources. New FAI units may be required. Supplier is responsible to manage the quality and liability of their subcontracted suppliers.
- 17.4. LAST TIME BUY – For any changes under this section, Gems Setra shall have the option to make a last time buy for the product before the change is implemented.
- 17.5. OEM (original equipment manufacturer) COMPONENTS –
- 17.5.1. Suppliers that provide OEM parts either individually or in an assembly are expected to implement, maintain, and enforce a Counterfeit Material Prevention and Detection Process to assure the authenticity and conformance of purchased parts and may be required to sign a Counterfeit Materials Prevention and Detection Process agreement.
- 17.5.2. Electronic components are primarily controlled through an AVL (approved vendor list)

18. SUPPLIER CERTIFICATIONS

- 18.1. Gems Setra prefers, and in some instances may require, Suppliers be at a minimum of ISO or AS certified or in the process of obtaining such certification.

19. COMPLIANCE WITH LAWS AND REGULATIONS

- 19.1. It is Gems Setra expectation that suppliers comply with all applicable laws and regulations.
- 19.2. Gems Setra has strict policies regarding Equal Opportunity Employment, Conflict Minerals, ROHS compliance, counterfeit parts, anti-dumping, mercury, and export and import regulations.
- 19.3. Learn about Ralliant's Integrity and Compliance Policies here: <https://www.Ralliant.com/culture#integrity-compliance>

20. SUPPLIER VISITS

- 20.1. Gems Setra expects suppliers to allow Gems Setra personnel to visit Supplier's site(s) as required. Gems Setra also expects that Suppliers will visit Gems Setra on a periodic basis to support business needs.

21. GEMS SETRA OWNED TOOLING

- 21.1. Please see Setra T&Cs section #12. BUYER'S PROPERTY: Unless otherwise provided in writing, property of every description, including all tools, equipment and materials furnished or made available to Supplier, title to which is in Buyer's name, and any replacement thereof, shall be and remain the property of Buyer. Property other than materials shall not be modified without the written consent of the Buyer. Such property shall be plainly marked or otherwise adequately identified by Supplier as property of Buyer (by name) and shall be safely stored separately and apart from Supplier's property. Supplier shall not use such property except for performance of work hereunder or as authorized in writing by Buyer. Such property while in Supplier's possession or control shall be kept in good condition, shall be held at Supplier's risk, and shall be kept insured by Supplier, at its expense, in an amount equal to the replacement cost with loss payable to Buyer. To the extent such property is not materially consumed in the performance of this Order, it shall be subject to inspection and removal by Buyer and Buyer shall have the right of entry for such purposes without



any additional liability whatsoever to Supplier. As and when directed by Buyer, Supplier shall disclose the location of such property and/or prepare it for shipment and ship F.O.B. its plant to Buyer in as good condition as originally received by Supplier, reasonable wear and tear accepted.

22. APPENDIX A - GLOSSARY OF TERMS

- **Cold Start Lead Time** – Length of time for Gems Setra to receive the first Kanban release quantity when issuing a new blanket purchase order.
- **Discrete Purchase Order**- A Discrete Purchase Order is for a specific quantity of parts to be delivered on a specified date. Also referred to as a Standard PO.
- **PQP** – Process used by Gems Setra for qualification of parts (Part Qualification Process).
- **JIT Lead Time** – Length of time for Gems Setra to receive a kanban quantity from a supplier when releasing it from an existing master blanket purchase order. This time-period includes supplier order processing time as well as shipment time (days in transit).
- **Kanban** – A material pull system in which a customer (Gems Setra) signals suppliers that material is required.
- **Kanban Agreement** – Document which outlines the responsibilities of the supplier and Gems Setra.
- **Kanban Bin Quantity** (release quantity) – Predetermined release quantity based on usage, JIT lead time and safety stock.
- **Kanban Card** – Internal document which contains part information, used as an internal signal.
- **Kanban Release Order** – A Kanban Release Purchase Order will decrement the quantity on the master blanket purchase order. An example of a Kanban release order is included in the Appendix.
- **Master Blanket Purchase Order** – An estimated quantity of product required over an extended period of time. Due date on this type of order is the intended date for the order to have shipped complete.
- **Processing Lead Time** – Length of time for supplier to internally restock a new manufacturing lot.
- **Supplier Continuous Improvement Plan (SCIP)** – Process used by Gems Setra to identify opportunities for supplier improvement.
- **Supplier Quality Engineer (SQE)** - Primary point of contact for all quality-related issues and correspondence. Supplier Corrective Action Requests, Supplier Deviation Requests, and any quality related requirements must be managed in coordination with the Supplier Quality Engineer and the Buyer.
- **Supplier Scorecard** – A tool to measure a supplier’s quality and delivery performance.

23. APPENDIX B – EXAMPLE DOCUMENT

23.1. Important Note: These are EXAMPLES only, not required formats. The required content for these documents is listed in the main section of this document.

1) EXAMPLE OF CERTIFICATE OF COMPLIANCE (C OF C)

**** This document must be signed by an officer of the supplier ****

To: Gems Sensors & Controls

We hereby certify that the parts supplied on your purchase order # conform to the material specifications and/or drawings furnished with the order. Test reports, or certification of test reports covering material use on file at our plant subject to examination.

Part Number:

Rev Level:

Part Name:



2) Example of Material Certification

CERTIFICATE OF TEST

Page 01 of 01

Certification Date
22-FEB-2009

CUSTOMER ORDER NUMBER
25162
CUSTOMER PART NUMBER

Invoice Number
5180269

SOLD TO:

SHIP TO:

Description: 6061-T6511 EXTRUDED BAR AMS QQA 200/8, QQA 20
1-1/4 X 2 RECT X 12' R/L Line Total: 779 LB
HEAT: 686303 ITEM: 513741

Specifications:
QQ A'200/8 ASTM B221 06 ASME SB 221. 98
AMS QQ A 200/8 UNS 96061

ALUMINIUM CHEMICAL ANALYSIS

DESCRIPTION:	SI	FE	CU	MN	MG	CR	ZN	TI
MIN	0,4		0.15		0.8	0.04		
MAX	0.8	0.07	0,4	0,15	1.2	0.35	0.25	0.15
OTHERS :	EACH	TOTAL						
	0.05	0.15						AL REMAINDER

RCPT: R392893
MILL :

COUNTRY OF ORIGIN :

MECHANICAL PROPERTIES

DESCRIPTION	YLD STR KSI	ULT TEN KSI	%ELONG IN 02 IN	%RED HARDNESS IN AREA	BHN
	54.8	58.3	115		
DESCRIPTION	YLD STR KSI	ULT TEN KSI	%ELONG IN 02 IN	%RED HARDNESS IN AREA	
	53.9	57.4	12,5		

Material did not come in contact with mercury while in our possession

The above data were transcribed from the manufacturer's Certificate of test after verification for completeness and specification requirements of the information on the certificate. All test results remain on file subject to examination.

We hereby certify that the material covered by this report will meet the applicable requirements described herein including any specification forming a part of the description.

The willful falsification of false, fictitious, or fraudulent statements in connection with test results may be punishable as a felony under federal statutes.

MANAGER, QUALITY ASSURANCE



3) Example of Packing List

		Pack List Number: 73852 Date: 14-Jul-16	
To	Ship To		
GEMS SENSORS, LLC DANAHER CORPORATION DIV. 1 COWLES ROAD PLAINVILLE, CT 06062 USA			
Ph:	Fax	Ph:	Fax:
Terms		Ship Via	
Net			
Quantity	Description		
130 ea	Part: CV 143-281S Rev: A 0281" Short Expander Plug Sleeve: Anodized 2024 T-4 Aluminum, Ball: 302/304 Stainless Steel (**440 ball not offered in Aluminum) SO: 35510 P0: 817355 Line: 001 GEMS SENSORS P/N: 232002 LOT# 41287		
THANK YOU FOR YOUR ORDER! THIS IS TO CERTIFY THAT ALL PARTS DETAILED ABOVE AND SUPPLIED TO YOU, CONFORM TO ALL OF AND REQUIREMENTS			



4) Example of Kanban Release Order

****Note: Contract Number refers to the parent Blanket order number that release is pulling from****

		KanBan Release 2089095			Page 1 of 1		
CoC and Packing Slip required with every shipment, ROHS and Reach may also be required.		<u>Contract Blanket</u> 1005614 <u>P.O. Date</u> 07/15/25 <u>Terms</u> Net Days <u>Incoterms</u> <u>Shipping Method</u>		<u>Buyer</u> <u>Buyer Email</u> @setra.com <u>Vendor #</u>			
VENDOR		SHIP TO	Setra Systems 159 Swanson Road Boxborough MA 01719 United States				
Line	Product/Description	Dock Date	U/M	Original Qty.	Open Qty.	Unit Price	Amount
1	031225000266 FTIRF26928 .250 DIA 66NA	07/22/25	IN	3600	3600		
							Rev Level:A
Kanban ID:279828Suppl.Loc.:DJ FIBER							

Buyer is not responsible for any charges not listed on this PO. Currency in: USD Order Total:

This PO Number [2089095](#) must be referenced on packing slip and invoice to ensure proper payment

Shipping Method: unless otherwise noted on the face of this PO, follow shipping instructions per Setra Shipping Guide located at: [terms and conditions](#)

Setra Systems will monitor all incoming shipments and invoices and will cover supplier shipping charges only when shipper follows the Setra Routing Guide. Failure to follow these instructions may result in charge backs of freight cost or additional penalties at the discretion of Setra Systems.

Buyer and Seller agree that the terms and conditions referenced here: [terms and conditions](#). Terms & Conditions are the sole Terms and Conditions governing this purchase. Seller is advised that these terms and conditions may change from time to time and accordingly Seller should periodically review these

Reference Setra Supplier Handbook -

Non-Domestic Parts: Per U.S. import regulations, all parts must be marked with Country of Origin, stainless steel and aluminum parts must include a mill cert. National Defense Rating: if this order is being rated as Defense Priority you will be advised the DPAS rating and are required by U.S. law to follow the provisions of DPAS regulation 16 CFG 700

Please send invoices to : ap_finance@setra.com for prompt payments.
[Reference Supplier Code of Conduct link](#)

5) NCMR form

Gems Sensors has created a Notification Only - **SCAR** (Supplier Corrective Action Request) through the Fortive Procurement portal for part number 32891.

[CLICK HERE TO PROVIDE RMA for SCAR # 23363](#)
(raltam@procurement.com)

****Do not reply to this email****

SCAR Type: Product Quality		Resolution Type: Notification Only	
SCAR #:	25363	Stage:	Notify Supplier
Created By:	K T	Date Added:	01/14/26
OpCo:	Gems Sensors	Factory:	Gems Plainville
Supplier Name:		Supplier Number:	12223
Supplier CSR Name:		Supplier CSR Email:	
Supplier Quality Name:		Supplier Quality Email:	
Buyer Notification Date:	01/14/26	Supplier Notification Date:	
Part Number:	32091	Part Description:	CBL 2 COND 18GA 390D PLYGHPRH
Drawing Revision:	A	Manufacturing Part Number:	
Buyer Name:	L M	Buyer Email:	
SQR Name:	Z T	SQR Email:	
Buyer Phone:	860 356-1331	SQR Phone:	860 793-7695
Discrepancy:			
The conduit and the earthing broke/split inside the cable jacket, I marked the bad spot with the red sharpie, and I included a photo for more details!			
Lot Quantity:	98	Part Lot Date:	
Sample Quantity:	98	Part SN:	
Sample Quantity Defective:	98	PO Information:	
Lot Quantity Defective:	98.00	Cost of Poor Supplier Quality:	
Disposition:			
Quantity Reworked:			
Quantity Scrapped:			
Quantity Returned:	98		
Quantity Used As Is:			
RMA Number:		RMA Request Date:	01/15/26
SCAR Closure Due Date:			

6) SCAR form

[CLICK HERE TO VIEW SCAR # 23320](#)

****Do not reply to this email****

SCAR Type: Product Quality		Resolution Type: Corrective Action	
SCAR #:	23320	Stage:	Approved & Closed
Created By:	Z T	Date Added:	03/10/25
OpCo:	Gems Sensors	Factory:	Gems Plainville
Supplier Name:		Supplier Number:	11785
Supplier CSR Name:		Supplier CSR Email:	
Supplier Quality Name:		Supplier Quality Email:	
Buyer Notification Date:		Supplier Notification Date:	05/14/25
Part Number:	253105	Part Description:	PISTON P581 RANGE 7080
Drawing Revision:	B	Manufacturing Part Number:	
Buyer Name:	L M	Buyer Email:	
SQR Name:	Z T	SQR Email:	
Buyer Phone:	800 356-1331	SQR Phone:	800 793-7695
Discrepancy:			
This part has a specification of 4-8 uin Ra finish, non-conformance to the drawing specification. Parts do not work.			
Lot Quantity:	343	Part Lot Date:	
Sample Quantity:	30	Part SN:	
Sample Quantity Defective:	30	PO Information:	2074326,2074327
Lot Quantity Defective:	343.00	Cost of Poor Supplier Quality:	
Disposition:			
Quantity Reworked:			
Quantity Scrapped:			
Quantity Returned:	343		
Quantity Used As Is:			
RMA Number:	13575	RMA Request Date:	03/10/25
Containment Action Plan:			
		Containment Plan Due Date:	
Parts are to be remade and in process steps to prevent bad finish at final inspection			
Root Cause:		Root Cause Due Date:	
We have determined that the cause of the pitting/poor surface finish on part# 253105 is likely due to moisture contamination during processes done at a third-party vendor. We will be promptly re-producing your order and intend to monitor much more closely between each third-party process to ensure the parts are satisfactory to your standards. As soon as I have more information on when we will be shipping parts I will let you know. We again apologize for all of this, and we are doing our best to correct the situation. Thank you for your patience. If possible, we would like to obtain the mating part/object that these parts are intended to interface with to ensure that the future parts we supply will be compatible.			
Corrective Action Plan:		Corrective Action Estimated Completion Date:	
		05/13/25	
* We have added an in-process inspection step immediately after grinding. * A profilometer has been installed in our QC department to measure surface finish more accurately, replacing the previous finish graph method. * We will also measure the surface finish after the black oxide process and share the results with you. We have already started manufacturing new parts, which will follow this updated process. Please allow 3-5 weeks for completion.			
Corrective Action Actual Completion Date:		05/15/25	
Supplier Response Date:		SCAR Closure Due Date:	07/13/25

[CLICK HERE TO VIEW SCAR # 23320](#)

7) SRW form

		Supplier Request for Waiver		Waiver No. <input type="text"/>	
		Gems Sensors 1 Cowles Road Plainville CT 06062			
Part Number	<input type="text"/>	Revision	<input type="text"/>		
Part Description	<input type="text"/>				
Supplier	<input type="text"/>				
Requirement	<input type="text"/>				
Deviation	<input type="text"/>				
Reason for waiver	<input type="text"/>				
Qty of Deviant Parts	<input type="text"/>				
Corrective Action	<input type="text"/>				
Comments	<input type="text"/>				
Requested by	_____	Date	_____	Company	_____
Approved by	_____	Date	_____	Company	_____



8)TDN Form

Setra sheet] of		TEMPORARY DEVIATION NOTICE		TDN /X	
REASON FOR DEVIATION			Orig/Date:	Date	
EI Vendor Request <input type="radio"/> Purchasing Request EI Engineering Request <input type="radio"/> Manufacturing Request <input type="radio"/> Other:			Only, time Faded, of order covered by this nudge:		
Explain Reason			Amendment Info		
PIN		REV	TITLE		
DESCRIPTION OF CHANGE					
TON SCOPE			YVIERE USED end PFDUCT IMPACTED DETAILS:		
PROCESS STAGE		APPLY AT STAGE? (Y or N)			
TIERS on order					
rEr 3 1 stock					
Inierredisie level ASSY on order					
Inierredine level ASSY in suck					
F1'..../_ A2SY on order					
Ff'..../_ A3S. in suck					
In = E_ = .E=AIRS			Copy Exact Applies: O YES Sales SignOff Date		
AREAS A FF ECTEEVOISTRIR mop/					
Cri 1 7: 5F: _es: VE Fozus =s ..: .:; s.: 'lts EFF2-Tkr =1 ND EFF3-DH.=+vAD"=edllf .06kflEfediY)		DINCOHING I NSP OSHIPPING [MACHINE SHOP <input type="radio"/> FUNGI-LASING	Include Starling Effvonvity Info-? <input type="radio"/> YES <input type="radio"/> ND	Mark-Ups Being Used: CI YES <input type="radio"/> ND	
AdditionalV, a copy of all TDNe mud go roc		DATE MDR	TON SIGN-OFF		DATE
SALES and QUALITY			klandadurkg:		
			Dually.		
			Eng.Tech. Autlxvily.		
TOYFORMDOC Rev. 2022-06-01					