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Montana Metal Products L.L.C.

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AS9100 Quality Manual

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QM001		

Quality Manual Revisions

Revision Level	Section / Changes	Changed by / Date	Approved by / Date
Initial Release			Charles Kelley/04-07-03
A	Exclusions		
	Management Representative		
	Company's Introduction		
	References added	Lorena Gallegos/05-20-03	Edward Ubelhor/07-30-2007
B	Exclusions(Design)	Lorena Gallegos/06-27-03	Charles Kelley/06-27-03
C	Incorporated Process Interaction Matrix	Ed Ubelhor/07-22-05	Charles Kelley/07-22-05
D	Complete rewrite	Ed Ubelhor/07-30-07	Charles Kelley/08-01-07
E	Added standard element references to process descriptions	Ed Ubelhor/08-24-07	Charles Kelley/08-24-07

Welcome to Montana Metal Products LLC


Montana Metal Products is a precision sheet metal fabricator and machine shop located in Des Plaines, Illinois (about 10 minutes from O'Hare Airport).

Though founded in 1957, on "Montana" Street in Chicago, the company was acquired by its current owners in January, 1996, and has since expanded into a 97,500 square foot facility.

MMP currently runs two shifts, employing over 150 people. MMP has a 37,500 square facility in Monterrey, Mexico and a division in Wartburg, Tennessee operating in 10,800 square feet.

MMP's customer concentration has been within, but not limited to, medical systems, telecommunications, and aerospace, diagnostic type industries. Our strength is the manufacture of custom close tolerance, light gauge sheet metal fabrication in all alloys.

We offer assistance with processing from inception to prototype and into full production. In machining, we specialize in extremely complex close tolerance parts in many different alloys. Over the years, MMP has prided itself on superb quality manufacturing.

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COMPANY VISION

Become the premier North American precision metal fabricator with \$160 million in sales, while fulfilling the needs of our customers and employees by achieving a higher level of excellence.

QUALITY POLICY

Montana Metal Products, L.L.C. strives to provide quality custom products and services. Using a team approach, we concentrate on continuously improving key business drivers that include focusing on our processes, quality, customers, employees and growth within the market place.

We will continue to develop mutually beneficial partnerships with our customers and our employees in order to provide long-term profitability.

ENVIRONMENTAL POLICY

Montana Metal Products, L.L.C. is committed to minimizing our impact on the environment. We are active in complying with all local and federal regulations in the disposal of any waste materials that would pose an unreasonable risk to health, safety, or the environment.

We are dedicated to working with our customers and suppliers to eliminate the distribution of products that contain substances that are not in compliance with the RoHS directive.


PRACTICAL STEPS TO SUPPORT POLICIES

Customer Focus:
The Company shall consider the Customers needs in its every day operations and decision making and consider the impact on the Customer at all times.

Workplace Excellence:
The Company strives to encourage employees to strive for individual excellence in their work and in their association with other people inside and outside of the workplace. We aim to motivate employees by providing leadership, training, proper materials and facilities and a cooperative, safe environment.

Empowerment:
The Company managers are responsible for developing organizations and systems that accommodate the goal of achieving Customer satisfaction. Managers are to recognize and support employees charged with the responsibility of interfacing with Customers. Employees who are authorized to deal with Customers are responsible for carefully listening to Customers and fully understanding their requirements and expectations. These employees shall be as responsive as possible to those needs within the province and spirit of good business practices.

Intelligent Management:
Managers are directed to make decisions and guide operations based on facts, data and verifiable evidence whenever possible. Such management techniques eliminate bias and unfounded opinion wherever possible.

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Scope, Exclusions and Definitions

Scope

The quality management system described and referenced by this manual applies to the following Montana Metal Products LLC locations:

25 East Howard Street
Des Plaines, IL 60018

1985 Knoxville Highway
Wartburg, TN 37887

All manufactured products are included in the Quality Management system as outlined in the following pages.

This Manual corresponds to the quality system requirements of the AS9100:2004-01 standard for all aerospace customers (Des Plaines facility only) and the ISO 9001:2000 standard for all non-aerospace customers.

Each section starts with a policy statement expressing management's commitment to implementing procedures pertaining to the quality system.

This manual is a reference for implementation and maintenance of the Quality Management system at Montana Metal Products, L.L.C.

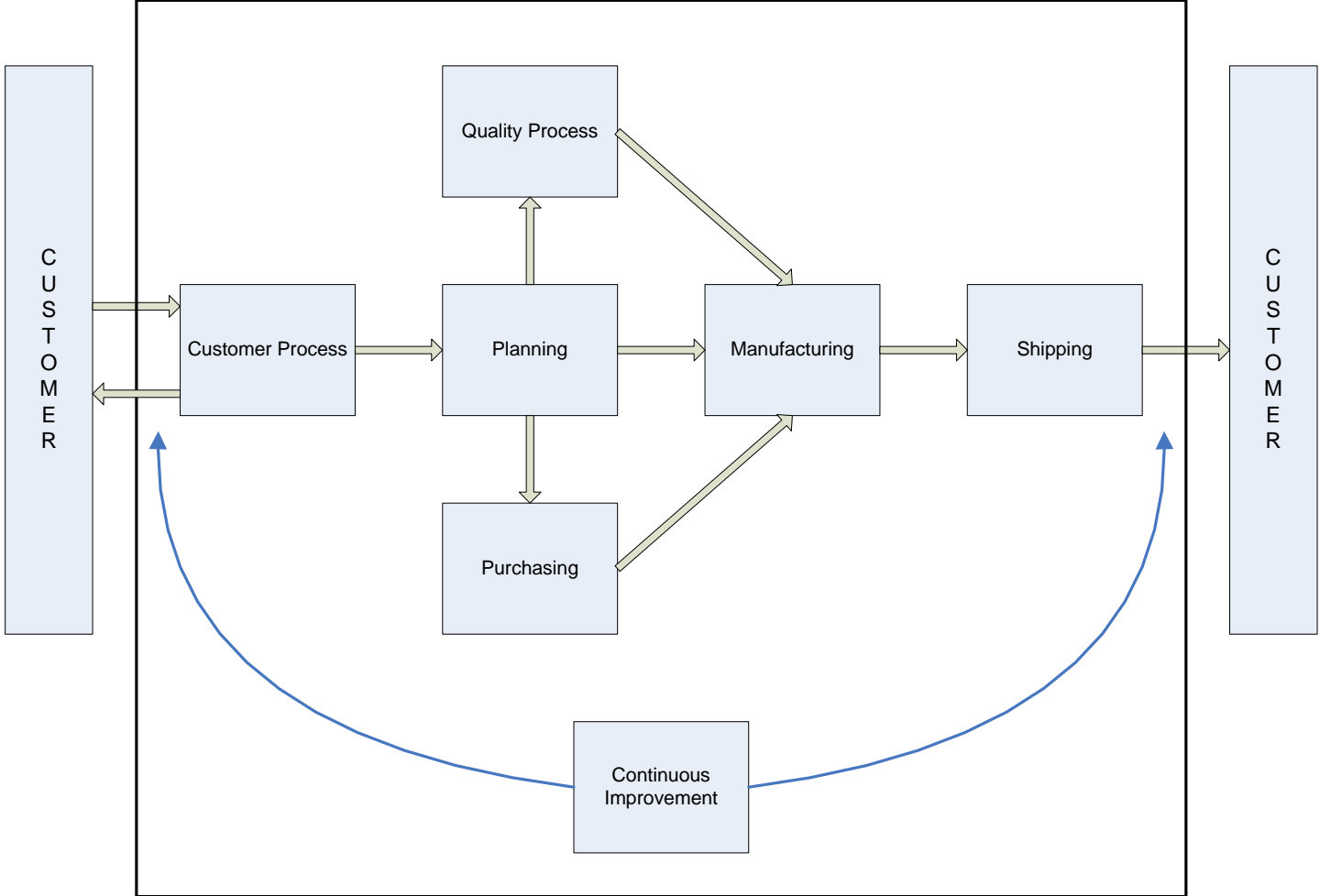
Exclusions

Montana Metal Products, L.L.C. cites the following exclusion to the ISO 9001 and AS9100 standards: Section 7.3 (Design and Development of Products) is excluded because all products are fabricated to customer provided specifications.

Definitions & Conventions

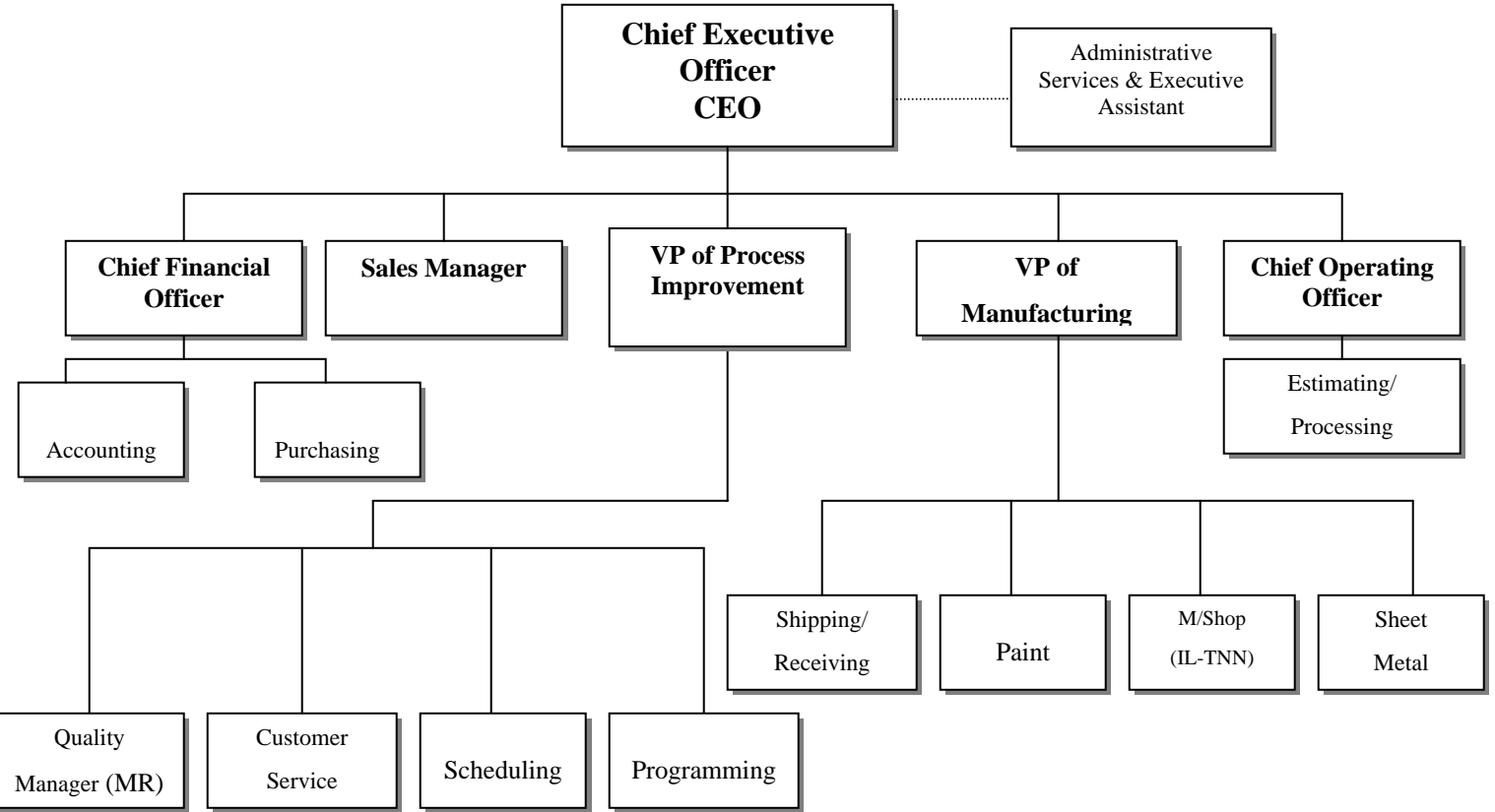
Unless otherwise noted, the Company applies the definitions of key terms according to ISO 9001 and AS9100.

Q MS Process Overview



Montana Metal Products, L.L.C.

Organization Chart



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Quality Management System Process Descriptions

Continuous Improvement						
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact	
Internal	Data from other processes	<ul style="list-style-type: none"> communicate to employees the importance of meeting customer as well as statutory and regulatory requirements, if any establish quality policy establish quality objectives define responsibilities and authorities and assure these are communicated assignment of Quality Assurance Manager as QMS Management Representative 	<ul style="list-style-type: none"> determine and provide resources manage document control system manage record control system Analyze data manage internal audits corrective and preventive actions Annual review of QMS (see Management Review Agenda) 	QMS compliance	all processes	
External	Customer input			continual improvement		customer satisfaction
	QMS requirements					
Related Documents: <ul style="list-style-type: none"> 4.2.3 Control of documents procedure 4.2.4 Control of records procedure 6 Resource Management and Training 8.2.2 Internal Audits Procedure 8.5.2 Corrective Action Procedure 8.5.3 Preventive Action Procedure 						
Related Primary Standard Elements: 4.1, 4.2, 5, 6, 8						

Customer Process					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Customer	Request for quote	<ul style="list-style-type: none"> Review customer RFQ Resolve differences / discrepancies with customer Estimating 	<ul style="list-style-type: none"> Approve quotes prior to submission Review customer orders / approve Interface with customers regarding changes or inquiries 	Approved quote to customer	Customer
	Customer prints / specifications			Confirmed order	Planning
	Sales order				
Related Documents: <ul style="list-style-type: none"> 7.2 Quoting and Order Entry 					
Related Primary Standard Element: 7.2					

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Planning					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Customer Processes	Customer prints / specifications	<ul style="list-style-type: none"> Programming Tooling development Process control documentation Inspection requirements 	<ul style="list-style-type: none"> Packaging and labeling requirements Develop bill of materials Schedule jobs Configuration management through print control and entry of job specifics into Vantage 	Bill of material	Purchasing
	Approved customer orders			Routers	Manufacturing, Quality, and shipping
				Customer prints	Manufacturing
				Tools	
				CNC programs	Manufacturing, Quality, Shipping
				Work instructions	Purchasing, Manufacturing
Scheduling reports					
Related Documents: <ul style="list-style-type: none"> 7.1 Scheduling and Planning 					
Related Primary Standard Elements: 4.3, 7.1					

Purchasing					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Planning	Bill of Material	<ul style="list-style-type: none"> Selecting suppliers Evaluating suppliers Viewing, approving, and communicating purchasing requirements 	<ul style="list-style-type: none"> Receiving Receiving Inspection Warehousing pending production use 	Purchase Orders	Suppliers
	Time Phase Report			Material / components available for production	Manufacturing
	Routers and customer prints for outside services				
Related Documents: <ul style="list-style-type: none"> 7.4.2 Purchasing procedure 8.3 Control of Non-Conforming Product Procedure 					
Related Primary Standard Elements: 7.4, 7.5.3, 7.5.5, 8.3					

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Quality Process					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Planning	Router	<ul style="list-style-type: none"> Perform full layout inspections when required Approve sequence operations Disposition non-conforming product 	<ul style="list-style-type: none"> Request print changes or product deviations Control of measurement devices Maintain inspection records 	Product approved for release	Manufacturing
	Customer prints and specifications			Accurate measurement gauges	Manufacturing, Purchasing
				Product certifications	Shipping
Related Documents: <ul style="list-style-type: none"> 8.3 Control of non-conforming product Procedure 7.6 Control of monitoring and measuring devices Procedure 8.2.4 Manufacturing Procedure 					
Related Primary Standard Elements: 7.5.1.4, 7.6, 8.2.4, 8.3					

Manufacturing					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Planning	Schedule shipment report	<ul style="list-style-type: none"> Setting up jobs Configuration management through completion to specifications in Vantage Perform 1st Piece Inspections Producing product 	<ul style="list-style-type: none"> Monitoring product Final Inspection Maintaining equipment 	Approved product available for shipping	Shipping
	Routers, customer prints / specifications, BOM, work aids, work instructions				
Quality	Sequence approvals				
Purchasing	Purchased materials, components, and services				
Related Documents: <ul style="list-style-type: none"> 7.5. Manufacturing Procedure 8.3 Control of Non-conforming Product Procedure 					
Related Primary Standard Elements: 4.3, 7.5, 8.2.4, 8.3					

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Shipping					
Previous Process / Contact	Inputs	Description of Key Activities		Output	Subsequent Process / Contact
Manufacturing	Scheduled Shipment Report, Product, Customer prints / specifications, Routers	<ul style="list-style-type: none"> Package product Stage products for shipments Contact carriers and schedule shipments Load trucks 	<ul style="list-style-type: none"> Generate all necessary paperwork for shipping product (Packing slips, Shipping labels, Bill of Materials, Certificate of Origin, Shipped product) Deliver product to customers and service vendors using MMP truck Ship product to service vendors or customers 	Shipped product	Customers or Service Suppliers
Quality Process	Product certifications				
Related Documents: <ul style="list-style-type: none"> 7.5.5 Packing and Shipping 					8.3 Control of Non-conforming Product Procedure
Related Primary Standard Elements: 7.5.3, 7.5.4, 7.5.5					