

MYERS CONTAINER CORPORATION
PROCUREMENT QUALITY CLAUSES-RING MANUFACTURING

Revised 4/24/2004

Clauses are applicable to Rings for New Drum Manufacturing

QUALITY ASSURANCE AND SUPPLIER FABRICATION

- WI-101 Weld Inspector and Off-Specification Welds
- WI-102 Welding Procedures and Qualifications
- WI-103 Lug and Ring Welding Specifications-Dimensions and Tolerances

WI-101 WELD INSPECTOR AND OFF- SPECIFICATION WELDS

Supplier personnel performing weld inspections shall be trained to the Suppliers requirements for GMAW or MIG Welding.

The inspection of the lug to ring weld shall be in accordance with the Suppliers internal training procedures and in accordance with the requirements specified in training documents, and performed by personnel trained to those procedures.

For purposes of Lug to ring fillet weld or resistance weld inspection, during any on-site audit, the Supplier shall submit documentation of the qualifications, training records and working instructions of specific inspectors for buyer review.

Gas metal Arch Welding (GMAW or MIG) and resistance Weld training procedures are to be written and implemented. Welders and weld inspectors are to be trained to identify welds defects (off-specification welds), how to take corrective measures, and criteria for acceptance and rejection of work containing welding defects. The supplier training must state clearly to what degree or tolerance each defect is acceptable (when not critical or only cosmetic), and small variations remain conformance.

Off Specification or defect welds not held, rejected or scrapped from the lot (during in-process or final inspection) must be recorded on an inspection summary document. Product which is held, rejected or scrapped must be identified according to the implemented work instructions for Quality Procedures 4.12 – Inspection and Test Status and 4.13 – Control of Nonconforming Product.

Off-specification welding defects which are non-critical to the performance of the ring or ring to lug weld, may not be shipped without expressed documented approval of the Buyers Operating or Quality Supervision. All rings shipped to the buyer with welds containing off-specification defects must be expressly guaranteed by the Supplier to perform in the same manner as product containing conforming welds.

Accepted of rings with off-specification welds is subject to downgrading and pricing adjustments Prior to shipment (or if discovered during the Buyers Receiving Inspection) as predetermined by agreement. If the Buyers receiving inspection reveals excessive non-conforming welds, the entire lot may be subject to rejection and return to the Suppliers.

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WI-102 WELDING PROCEDURES AND QUALIFICATIONS

Welding procedures and personnel shall be qualified in accordance with the applicable Supplier developed procedures. All welding procedures must be controlled and approved by the seller, and their personnel shall be train/qualified in accordance with these procedures. Supplier shall submit copies of the:

- Welding Procedure
- Welder Qualification Records

WI103 Lug and Ring Welding Specifications – Dimensions and Tolerances

For each ring, the Offeror shall supply a **Ring Cross - section** drawing, a **lug** drawing (including supplier part number and specifications (i.e., weight, dimensions, chemistry, physical properties and appropriate national consensus standards indicated)). And a **Lug to Ring Fillet Weld** drawing indicating dimensions and tolerances of Weld Length on each side of the weld, Leg Length, welds throat, welds crown, and root penetration.

The drawings shall also indicate the **position** and the **center line** dimensions / tolerance of both lugs relative to the **ring cross-section** and **ends of the ring** from a horizontal position (facing the lugs). A maximum equal distance tolerance of both lugs from the ends of the ring shall also be established and clearly indicated on the drawing and in a narrative.

Appropriate symbols shall be indicated for all welds. The drawing will be submitted and maintained by submitting a current issue when revised to the Buyers Quality Supervisor.

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