

CAL-TEK Co. Inc.

Quality and Management System Manual Section 2

UNCONTROLLED DOCUMENT

Control Page

This manual is approved in its entirety at **Revision C**
By

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President

And
Will become effective on

March 13, 2008

Issued to: Customer

Originator: QC Manager	First Draft: December 20, 2005	This Copy: March 13, 2008
Approved by President:	Approved by QC Manager:	

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1.0 Introduction

1.1 Purpose

The purpose of this manual is to provide a document that defines the basis for the Quality Management System that is used at CAL-TEK Co. Inc.. Our Quality Management System is designed to meet the requirements of ISO/IEC 17025:2005 and is used to promote customer satisfaction by preventing nonconformity at all stages of product and/or service production.

1.2 Scope

This manual and the system it defines, applies to all the activities within the company that have an effect on calibration or service quality.

1.3 Exception to Standard

CAL-TEK Co. Inc. takes exception to the following sections of this standard.

Paragraphs 5.7 & 5.10.3.2, no sampling done.

Paragraph 5.10.3 on Test Reports

Paragraph 5.10.5, we do not provide opinions or interpretations.

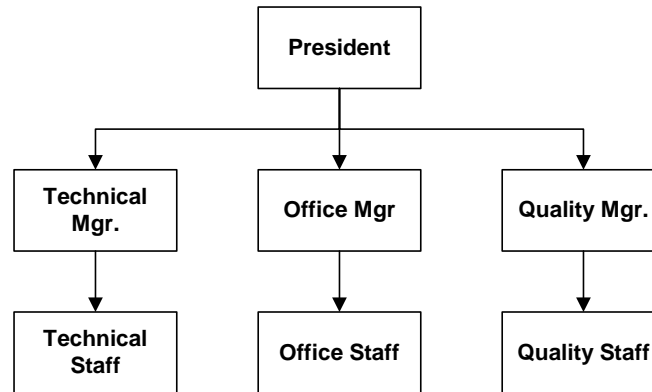
2. Company

2.1 History

CAL-TEK Co. Inc. was formed in 1989 we have operated as an independent calibration and service supplier for numerous industries, including:

- Heat Treatment of steel and aluminum parts
- Municipal and Industrial waste Treatment
- Food Industry
- Electroplating and Powder Coating
- Power Generation facilities
- Aerospace Manufacturing
- Military Facilities, "US Navy, Army COE and the US Air Force"
- Electronic Manufactures
- Telecommunications Facilities
- Paper and Pulp Industries
- Foundry and Casting Industry

2.2 Organization Chart



2.3 Quality Policy

2.3.1 Quality Policy Statement

Quality and continuous improvement are the basic operating principles for CAL-TEK Co. Inc.. Knowing and understanding the requirements of our customers and suppliers and consistently meeting or exceeding those requirements is our main objective, and is the responsibility of every CAL-TEK Co. Inc. employee. All Cal-Tek employees are required to read and understand the quality documentation and implement the policies and procedures in their work. The management of Cal-Tek is committed to compliance with ISO/IEC 17025:2005 and to continually improve the effectiveness of the management system. This Statement is also referred as QS200.

2.3.2 Quality Objectives for CAL-TEK Co. Inc.

CAL-TEK Co. Inc. I committed to a Quality and Management that will ensure customer satisfaction and provide continuous improvement and value for its customers.

Measurable objectives are:

- * Provide our customers with the highest quality services.
- * Provide these services on time in the best possible way.
- * Provide totally open communications with our customers in order to better understand and meet their needs.
- * Provide our customers with the best pricing and value for our products and services.

3. Definitions

- 3.1 Assessment** - An evaluation process including a documented review, an on-site audit and an analysis and report.
- 3.2 Audit** - An on-site verification activity based upon a sample used to determine the effective implementation of a supplier's documented quality system.
- 3.3 Calibration** – A set of operations which compare values taken from a piece of inspection, measuring and test equipment or a gage to a known standard under specified conditions.
- 3.4 Calibration Procedure** – A defined process for the review and adjustment of equipment
- 3.5 Certification Body/Registrar** – A certification body/registrar is a qualified organization accredited by a national accreditation body to perform audits to ISO 9000 and to register the audited facility for a given scope.
- 3.6 Client** – A company or organization that is provided with a product and/or service
- 3.7 Corrective Action** – The reactive process used to identify and resolve deficiencies in the product, process or Quality Management System.
- 3.8 Cost of Poor Quality** – The cost associated with production of nonconforming materials.
- 3.9 Customer Property** – It is any tooling, fixturing and/or measuring and test equipment that are owned by the customer. It is any product that is provided by the customer that may be modified and/or assembled into the final product. Customer supplier product may be items that are used to carry and/or protect the final product through the process and on to the final destination. Customer Property may include intellectual property information that is provided in confidence.
- 3.10 Documents** – Material (typically paper or electronic) defining the process to be followed.
- 3.11 Environment** – Environment is all of the process conditions surrounding or effecting the manufacture and quality of a part or product. Environment will vary for each site, but generally includes: housekeeping, lighting, noise, HVAC, ESD control and safety hazards relating to housekeeping.

- 3.12 Internal Quality Audit** – An audit of those portions of the company’s Quality Management System retained under its direct control and within its structure.
- 3.13 Job Instruction** – Describes work conducted in one function in a company and is considered to be Level III Quality Management System documents.
- 3.14 Management Representative** – A member of management who, irrespective of other responsibilities, has been appointed to manage and maintain the Quality Management System.
- 3.15 Management Review** – The periodic review, by top management, of the Quality Management System.
- 3.16 Nonconforming Product** – Any product that does not meet the defined acceptance criteria.
- 3.17 Preventive Action** – The pro-active process used to identify and resolve potential and/or suspect deficiencies in the product, process or Quality Management System.
- 3.18 Procedure** – Documented processes that are normally used when work affects more than one function or department of an organization. Procedures are considered to be Level II Quality Management System documents.
- 3.19 Quality Management System** – The organizational structure, responsibility, procedures, processes and resources for implementing quality management.
- 3.20 Quality Manual** – The document that describes the clauses of the Quality Management System used to assure customer requirements, needs and expectations are met.
- 3.21 Quality Planning** – A structured process for detailing the methods that will be used in the production of a specific product, family of products or service. Quality planning embodies the concepts of defect prevention and continuous improvement as contrasted with defect detection.
- 3.22 Raw Data** – Test data that is generated or taken by the technician /analyst at the time the test is being run. It is generally not edited or manipulated in any fashion.
- 3.23 Records** – Any record or data that is generated in accordance with the Quality Management System.

- 3.24 Repair** – Action taken on nonconforming product so that the product will fulfill the intended usage although the product may not conform to the original requirements.
- 3.25 Rework** – Action taken on nonconforming product so that it will meet the specified requirements.
- 3.26 Site** – A supplier, subcontractor or client’s location at which value-added production processes occur.
- 3.27 Statistical Process Control** – A series of mathematical tools that are used to monitor and control the process and/or the product.
- 3.28 Supplier** – An organization that provides product and/or service.
- 3.29 Value Added Production Process** – Activities or operations for which a customer would be willing to pay, if given the option

4.0 Management requirements

4.1 Organization

- 4.1.1** CAL-TEK Co. Inc. can be held legally responsible for all actions taken.

It is the paramount responsibility of the Quality Assurance Manager (or designee) under direct supervision of the President to implement and dynamically supervise all aspects of the CAL-TEK Quality System to ensure that the requirements of the Standard are being met, and to ensure that the client and regulatory authorities or organizations are satisfied. Effective quality control is not a task-specific function; it is an integral part of all management activity and process planning.

See Section 11

- 4.1.2** We carry out calibration activities in such a way as to meet the requirements of this International Standard and to satisfy the needs of the client, the regulatory authorities or organizations providing recognition.
- 4.1.3** Our quality management system covers the work carried out in our permanent facility, as well as our mobile facilities.
- 4.1.4** We are an independent organization. This allows the key personnel total freedom and eliminates any form of real or potential conflict of interest.

4.1.5 CAL-TEK Co. Inc.:

- a) Has managerial and technical personnel with the authority and resources needed to carry out their duties and to identify the occurrence of departure from the quality system or from the procedures for performing calibrations, and to initiate actions to prevent or minimize such departures;
- b) Has made arrangements to ensure that its management and personnel are free from any undue internal and external commercial, financial and other pressures and influences that may adversely affect the quality of their work;
- c) Has policies and procedures to ensure the protection of its clients' confidential information and proprietary rights, including procedures for protecting the electronic storage and transmission of results;
- d) Has defined policies and procedures to avoid involvement in any activities that would diminish confidence in its competence, impartiality, judgment or operational integrity;
- e) Has defined the organization and management structure of the laboratory, and the relationships between quality management, technical operations and support services;
- f) Has specified the responsibility, authority and interrelationships of all personnel who manage, perform or verify work affecting the quality of the tests and/or calibrations;
- g) Has provided adequate supervision of testing and calibration staff, including trainees, by persons familiar with methods and procedures, purpose of each test and/or calibration, and with the assessment of the calibration results;
- h) Has technical management which has overall responsibility for the technical operations and the provision of the resources needed to ensure the required quality of laboratory operations;
- i) Has appointed a member of staff as quality manager (however named) who, irrespective of other duties and responsibilities, shall have defined responsibility and authority for ensuring that the quality system is implemented and followed at all times; the quality manager shall have direct access to the highest level of management at which decisions are made on laboratory policy or resources;
- j) Has appointed deputies for key managerial personnel.
- k) Has conveyed the relevance and importance of all activities and how they contribute to the achievement of the management system objectives through the monthly employee meetings.

4.1.6 CAL-TEK Co. Inc. top management has put in place audits and management review meetings to ensure and review the effectiveness of communications and the management system.

4.2 Quality system

- 4.2.1** We have established implemented and maintain a quality system appropriate to the scope of our activities. The laboratory has documented its quality policy, quality system, quality procedures and calibration instructions to the extent necessary to assure the quality of the calibration results. The Quality and Management system's documentation has been communicated to, understood by, available to, and implemented by the appropriate personnel.
- 4.2.2** Our quality system policy and objectives are defined in the Quality Manual. The overall objectives are documented as part of the Quality Policy statement, QS200.
- 4.2.3** The quality policy statement has been issued under the authority of the president. It includes the following:
- a) The management's commitment to good, professional practice and to the quality of its calibration in servicing its clients;
 - b) The management's statement of the laboratory's standard of service;
 - c) The objectives of the quality system:
 - d) A requirement that all personnel concerned with calibration activities within the laboratory familiarize themselves with the quality documentation and implement the policy and procedures in their work; and
 - e) The management's commitment to compliance with this International Standard.
 - g) This Quality Manual includes or makes reference to the supporting procedures Section 3 & 4 including technical procedures. It outlines the structure of the documentation used in the quality system.
- 4.2.4** The roles and responsibilities of technical management and the quality manager, including their responsibility for ensuring compliance with this International Standard, are defined in "Job Descriptions". **Section 8 Referenced by Title.**
- 4.2.5** The quality manual makes reference to Quality Procedures "QPXXX" and Technical Procedures "WIXXX". The structure of the documentation used in the management system is outlined in document MI100 "Master Index".
- 4.2.6** The roles and responsibilities of technical and quality management are defined in the "Job Descriptions", include their responsibility for ensuring compliance.
- 4.2.7** The integrity of the management system is maintained through the continued implementation of management and quality system reviews and any changes to the system will be planned and impact studies will be performed before implementation.

4.3 Document control

4.3.1 General

We have established and maintain procedure QP120 "Document Control", to control all documents that form part of the quality system (internally generated or from external sources, such as regulations, standards, other normative documents, calibration methods, as well as drawings, software, specifications, instructions and manuals.

4.3.2 Document approval and issue

The procedure QP120 and QP130 control all documents that form part of its quality system (internally generated or from external sources, such as regulations, standards, other normative documents, calibration methods, as well as drawings, software, specifications, instructions and manuals.)

4.3.2.1 All documents issued to personnel as part of the quality system have been reviewed and approved for use by authorized personnel prior to issue. A master list "MI100" identifies the current revision status and distribution of documents in the quality system has been established and is readily available to preclude the use of invalid and/or obsolete documents.

4.3.2.2 The procedure(s) ensure that:

- a) Authorized editions of appropriate documents are available at all locations where operations essential to the effective functioning of the laboratory are performed;
- b) Documents are periodically reviewed and, where necessary, revised to ensure continuing suitability and compliance with applicable requirements;
- c) Invalid or obsolete documents are promptly removed from all points of issue or use, or otherwise assured against unintended use;
- d) Obsolete documents retained for either legal or knowledge preservation purposes are suitably marked.

4.3.2.3 Our quality system documents are uniquely identified. Such identification includes the date of issue and the identification, page numbering, the total number of pages and the issuing authority.

4.3.3 Document changes

4.3.3.1 CAL-TEK Co. Inc. is a small operation so all changes to documents will be reviewed and approved by the same function that performed the original review. The designated personnel will have access to pertinent background information upon which to base their review and approval.

4.3.3.2 Where practicable, the altered or new text will be identified in the document or the appropriate attachments.

4.3.3.3 Our documentation control system does not allow for the amendment of documents by hand pending the re-issue of the documents.

4.3.3.4 The procedure also describes how changes in documents maintained in computerized systems are made and controlled.

4.4 Review of requests, tenders and contracts

4.4.1 We have procedure QP100 "Contract Review", for the review of requests, tenders and contracts. The policies and procedures for these reviews leading to a contract for calibration will ensure that:

- a) The requirements, including the methods to be used, are adequately defined, documented and understood.
- b) The capability and resources to meet the requirements,
- c) The appropriate calibration method is selected and capable of meeting the clients' requirements.

Any differences between the request or tender and the contract will be resolved before any work commences. Each contract will be acceptable both to the laboratory and the client.

4.4.2 Records of reviews, including any significant changes, will be maintained. Records will also be maintained of pertinent discussions with a client relating to the client's requirements or the results of the work during the period of execution of the contract.

4.4.3 The review will also cover any work that is subcontracted (should we in the future choose to use such).

4.4.4 The client will be informed of any deviation from the contract.

4.4.5 If a contract needs to be amended after work has commenced, the same contract review process will be repeated and any amendments will be communicated to all affected personnel.

4.5 Subcontracting of calibrations

4.5.1 CAL-TEK Co. Inc. will use only appropriately accredited subcontractors when needed. Calibration subcontracting will only be awarded to a calibration laboratory that has demonstrated through the accreditation process competency in the scope of work to be performed.

4.5.2 Whenever a subcontractor is used a CAL-TEK Co. Inc. representative will inform the customer in advance that a subcontractor will be used and obtain the customers written approval.

4.5.3 CAL-TEK Co. Inc. recognizes a responsibility to our customers for the work performed by subcontractors contracted by us on behalf of a customer.

4.5.4 CAL-TEK Co. Inc. maintains an approved vendor log to track all vendors/subcontractors, this log includes a column for accreditation and or compliance with applicable standards for the work to be performed.

4.6 Purchasing services and supplies

4.6.1 We have procedure QP310 "Supplier Assessment", for the selection and purchasing of services and supplies we use that affect the quality of calibrations. QP140 "Purchasing" exist for the purchase, reception and storage of reagents and laboratory consumable materials relevant for calibrations.

4.6.2 We will ensure that purchased supplies and reagents and consumable materials that affect the quality of calibrations are not used until they have been inspected or otherwise verified as complying with standards specifications or requirements defined comply with specified requirements. Records of actions taken to check compliance will be maintained. We have QP280 "Receiving Inspection" to ensure compliance with this section of the standard.

4.6.3 Purchasing documents for items affecting the quality of our output will contain data describing the services and supplies ordered. These purchasing documents will be reviewed and approved for technical content prior to release.

4.6.4 We will evaluate suppliers of critical consumables, supplies and services that affect the quality of calibration, and shall maintain records of these evaluations and list those approved.

4.7 Service to the Customer

4.7.1 We will afford clients or their representative's cooperation to clarify the client's request and to monitor CAL-TEK Co. Inc. performance in relation to the work performed, provided that the customer ensures confidentiality to other clients. QP300 "Servicing" defines how service is provided to the client.

4.7.2 CAL-TEK Co. Inc. maintains a system of "Report Cards", Form F300-1, to request feedback from our customers. Form F300-1 request and encourages both positive and negative comments about our services. This information is used with our management system and during our management meets it improve customer relations and service.

4.8 Complaints

Customer complaints are covered as part of procedure QP190 "Corrective and Preventive Action". Records will be maintained of all complaints and of the investigation and corrective actions taken by the laboratory.

4.9 Control of nonconforming calibration work

4.9.1 We have procedure QP225 "Nonconformance", it will be implemented when any aspect of our calibration work, or the results of this work, do not conform to our procedures or the agreed requirements of the client. The policy and procedure ensures that:

- a) The responsibilities and authorities for the management of nonconforming work are designated and actions (including halting of work and withholding of calibration certificates, as necessary) are defined and taken when nonconforming work is identified;
- b) An evaluation of the significance of the nonconforming work is made;
- c) Corrective actions are taken immediately, together with any decision about the acceptability of the nonconforming work;
- d) Where necessary, the client is notified and work is recalled;
- e) The responsibility for authorizing the resumption of work is defined.

4.9.2 Where the evaluation indicates that the nonconforming work could recur or that there is doubt about the compliance of the laboratory's operations with its own policies and procedures, the corrective action procedures will be promptly followed.

4.10 Improvement

4.10.1 CAL-TEK Co. Inc. has systems in place to monitor the effectiveness of its management system through the use of quality policies, quality objectives, management reviews, corrective actions, preventative actions and through the use of customer report cards.

4.11 Corrective action

4.11.1 General

The procedure QP190 “Corrective and Preventive Action” designates the appropriate authorities for implementing corrective action when nonconforming work or departure from the policies and procedures in the quality system or technical operations has been identified.

4.11.2 Cause Analysis

The procedure for corrective action starts with an investigation to determine the root cause(s) of the problem.

4.11.3 Selection and Implementation of Corrective Actions

Where corrective action is needed, our laboratory will identify potential corrective actions. We will select and implement the action(s) most likely to eliminate the problem and to prevent recurrence.

Corrective actions will be to a degree appropriate to the magnitude and the risk of the problem.

We will document and implement any required changes resulting from corrective action investigations.

4.11.4 Monitoring of Corrective Actions

We will monitor the results to ensure that the corrective actions taken have been effective.

4.11.5 Additional Audits

Where the identification of nonconformance or departures casts doubt on the compliance with set policies and procedures, or on compliance with this International Standard, we will ensure that the appropriate areas of activity are audited in accordance with 4.14 as soon as possible.

4.12 Preventive Action

4.12.1 Needed improvements and potential sources of nonconformance, either technical or concerning the quality system, will be identified. If preventive action is required, action plans will be developed, implemented and monitored to reduce the likelihood of the occurrence of such nonconformance and to take advantage of the opportunities for improvement. Quality Procedure QP190 quality forms F190-1, F200-1 and quality logs R190-1, R190-2 and R190-3.

4.12.2 The procedure includes the initiation of such actions and application of controls to ensure that they are effective.

4.13 Control of Records**4.13.1 General**

4.13.1.1 We have procedure QP130 "Records Control" for identification, collection, indexing, access, filing, storage, maintenance and disposal of quality and technical records. Quality records include reports from internal audits and management reviews as well as records of corrective and preventive actions.

4.13.1.2 All records will be legible and will be stored and retained in such a way that they are readily retrievable in facilities that provide a suitable environment to prevent damage or deterioration and to prevent loss. Retention times of records have been established and documented in QP130 "Records Control".

4.13.1.3 All records will be held secure and in confidence.

4.13.1.4 As part of QP130 a system exists to protect and back-up records stored electronically and to prevent unauthorized access to or amendment of these records, virus scanning software is used weekly to ensure electronic media integrity.

4.13.2 Technical records

4.13.2.1 We will retain records of original observations, derived data and sufficient information to establish an audit trail, calibration records, staff records and a copy of each test report or calibration certificate issued, for a defined period. The records for each calibration will contain sufficient information to facilitate, if possible, identification of factors affecting the uncertainty and to enable the calibration to be repeated under conditions as close as possible to the original. The records will include the identity of personnel responsible for the sampling, performance of each calibration and checking of results.

4.13.2.2 Observations, data and calculations will be recorded at the time they are made and will be identifiable to the specific task.

4.13.2.3 When mistakes occur in records, each mistake will be crossed out, not erased, made illegible or deleted, and the correct value entered alongside. All such alterations to records will be signed or initialed by the person making the correction. In the case of records stored electronically, equivalent measures will be taken to avoid loss or change of original data.

4.14 Internal Audits

4.14.1 We will periodically, and in accordance with a predetermined schedule and procedure QP250 "Internal Audits", conduct internal audits of its activities to verify that its operations continue to comply with the requirements of the quality system and this International Standard. The internal audit program will address all elements of the quality system, including the calibration activities. It is the responsibility of the quality manager to plan and organize audits as required by the schedule and requested by management. Trained and qualified personnel, who are, wherever resources permit, independent of the activity to be audited, will carry out such audits. An "Internal Audit" checklist has been created to aid in performing this task and is designated as F400 in the "Forms and Reports" manual.

4.14.2 When audit findings cast doubt on the effectiveness of the operations or on the correctness or validity of the laboratory's calibration results, we will take timely corrective action, and will notify clients in writing if investigations show that the laboratory results may have been affected.

4.14.3 The area of activity audited, the audit findings and corrective actions that arise from them will be recorded.

4.14.4 Follow-up audit activities will verify and record the implementation and effectiveness of the corrective action taken.

4.15 Management Reviews

4.15.1 In accordance with a predetermined schedule and procedure QP105 "Management Review", our executive management will periodically conduct a review of our quality system and calibration activities to ensure their continuing suitability and effectiveness, and to introduce necessary changes or improvements. The review shall take account of:

- The suitability of policies and procedures;
- Reports from managerial and supervision personnel;
- The outcome of recent internal audits;
- Corrective and preventive actions;
- Assessments by external bodies;
- The results of inter-laboratory comparisons or proficiency tests;
- Changes in the volume and type of the work;
- Client feedback,
- Complaints
- Other relevant factors, such as quality control activities, resources and staff training.

4.15.2 Findings from management reviews and the actions that arise from them will be recorded. The management will ensure that those actions are carried out within an appropriate and agreed upon timescale.

5.0 Technical requirements

5.1 General

5.1.1 Many factors determine the correctness and reliability of the calibrations performed by a laboratory. These factors include contributions from:

- Human factors;
 - Accommodation and environmental conditions;
 - Temp. **70 deg +/- 5 deg F** Relative Humidity **35 to 55%**
- Calibration methods and method validation;
- Equipment;
- Measurement traceability;
- Sampling;
- The handling of calibration items.

5.1.2 The extent to which the factors contribute to the total uncertainty of measurement differs considerably between types of calibrations. We will take account of these factors in developing calibration methods and procedures, in the training and qualification of personnel, and in the selection and calibration of the equipment we use.

5.2 Personnel

5.2.1 Our management will ensure the competence of all who operate specific equipment, perform calibrations, evaluate results, and calibration certificates. When using staff that is undergoing training, appropriate supervision will be provided. Personnel performing specific tasks will be qualified on the basis of appropriate education, training, experience and/or demonstrated skills, as required.

5.2.2 Our management will formulate the goals with respect to the education, training and skills of the laboratory personnel. We have procedure QP270 "Training" that identifies the training needs and providing training of personnel. The training program will be relevant to the present and anticipated tasks. Our training effectiveness is evidenced by the use of Appraiser Variation Studies, Intermediate Testing and Proficiency testing.

5.2.3 We will use personnel who are employed by, or under contract to, the laboratory. Where contracted and additional technical and key support personnel are used, the

laboratory will ensure that such personnel are supervised, competent and that they work in accordance with the laboratory's quality system.

5.2.4 We maintain current job descriptions for managerial, technical and key support personnel involved in calibrations.

5.2.5 The management has authorized specific personnel to perform particular types of sampling, calibration, to issue test reports and calibration certificates, to give opinions and interpretations and to operate particular types of equipment. We maintain records of the relevant authorization(s), competence, educational and professional qualifications, training, skills and experience of all technical personnel, including contract personnel. This information is readily available and includes the date on which authorization and/or competence is confirmed.

5.3 Accommodation and Environmental Conditions

5.3.1 Our facilities for calibration, including but not limited to energy sources, lighting and environmental conditions, shall be such as to facilitate correct performance of the calibrations.

We will ensure that the environmental conditions do not invalidate the results or adversely affect the required quality of any measurement. Particular care will be taken when sampling and calibrations are undertaken at sites other than a permanent laboratory facility. The technical requirements for accommodation and environmental conditions that can affect the results of calibrations will be documented.

5.3.2 We will monitor, control and record environmental conditions as required by the relevant specifications, methods and procedures or where they influence the quality of the results. Due attention will be paid to temperature and humidity as appropriate to the technical activities concerned.

5.3.3 There is effective separation between neighboring areas in which there are incompatible activities. Should there be a need; measures will be taken to prevent cross-contamination.

5.3.4 Access to and use of areas affecting the quality of the calibrations is controlled. The laboratory has determined the extent of control based on its particular circumstances.

5.3.5 Measures have been taken to ensure good housekeeping in the laboratory. Special procedures will be prepared where necessary.

5.4 Calibration Methods and Method Validation

5.4.1 General

We have procedure QP150 “Process Control”, for all calibrations within our scope. These include sampling, handling, transport, storage and preparation of items to be calibrated, and, where appropriate, an estimation of the measurement uncertainty as well as statistical techniques for analysis of calibration data.

We will have instructions on the use and operation of all relevant equipment, and on the handling and preparation of items for calibration, or both, where the absence of such instructions could jeopardize the results of calibrations. All instructions, standards, manuals and reference data relevant to the work of the laboratory will be kept up to date and will be made readily available to personnel. Deviation from calibration methods will occur only if the deviation has been documented, technically justified, authorized, and accepted by the client.

5.4.2 Selection of Methods

We will calibrate to the original manufactures specifications. We will use calibration methods which meet the needs of the client and which are appropriate for the calibrations it undertakes. Methods published in international, regional or national standards will preferably be used. We will ensure that it uses the latest valid edition of a standard unless it is not appropriate or possible to do so. When necessary, the standard will be supplemented with additional details to ensure consistent application.

When the client does not specify the method to be used, we will select appropriate methods that have been published either in international, regional or national standards, or by reputable technical organizations, or in relevant scientific texts or journals, or as specified by the manufacturer of the equipment. Laboratory-developed methods or methods adopted by the laboratory may also be used if they are appropriate for the intended use and if they are validated. The client will be informed as to the method chosen. We will confirm that we can properly operate standard methods before introducing the calibrations. If the standard method changes, the confirmation will be repeated.

We will inform the client when the method proposed by the client is considered to be inappropriate or out of date.

5.4.3 Laboratory-Developed Methods

The introduction of calibration methods developed by CAL-TEK Co. Inc. for its own use will be a planned activity and will be assigned to qualified personnel equipped with adequate resources. This process is defined in procedure QP110 "Methods Development".

Plans will be updated as development proceeds and effective communication amongst all personnel involved will be ensured.

5.4.4 Non-Standard Methods

When it is necessary to use methods not covered by standard methods, these will be subject to agreement with the client and will include a clear specification of the client's requirements and the purpose of the calibration. The method developed will have been validated appropriately before use.

5.4.5 Validation of Methods

5.4.5.1 Validation is the confirmation by examination and the provision of objective evidence that the particular requirements for a specific intended use are fulfilled.

5.4.5.2 We will validate non-standard methods, laboratory-designed / developed methods, standard methods used outside their intended scope, and amplifications and modifications of standard methods to confirm that the methods are fit for the intended use. The validation will be as extensive as is necessary to meet the needs of the given application or field of application. We will record the results obtained, the procedure used for the validation, and a statement as to whether the method is fit for the intended use.

5.4.5.3 The range and accuracy of the values obtainable from validated methods (e.g. the uncertainty of the results, detection limit, selectivity of the method, linearity, limit of repeatability and/or reproducibility, robustness against external influences and/or cross-sensitivity against interference from the matrix of the sample / test object), as assessed for the intended use, will be relevant to the clients' needs.

5.4.6 Estimation of Uncertainty of Measurement

5.4.6.1 A calibration laboratory, performing its own calibrations, will have and apply a procedure to estimate the uncertainty of measurement for all calibrations and types of calibrations.

5.4.6.2 We have procedure QP350 “Estimation of Measurement Uncertainty” for estimating uncertainty of measurement, this along with Quality Statement QS300 defines our systems for measurement uncertainty. CAL-TEK Co. Inc. also uses AutoPro II and Fluke MET/CAL & MET/TRACK software and hardware for measurement uncertainty calculations as this software has been approved for this purpose and has been validated in VR100-1.

5.4.6.3 Our laboratory has a procedure QP350 and QS300 for estimating uncertainty of measurement.

5.4.6.4 When estimating the uncertainty of measurement, all uncertainty components, which are of importance in the given situation, will be taken into account using appropriate methods of analysis.

5.4.7 Control of data

5.4.7.1 Calculations and data transfers will be subject to appropriate checks in a systematic manner.

5.4.7.2 When computers or automated equipment are used for the acquisition, processing, recording, reporting, storage or retrieval of calibration data, we will ensure that:

- a) Any computer software developed by our staff will be documented in sufficient detail and be suitably validated for adequacy before use;
- b) Procedures have been established and are implemented for protection of data; such procedures include, but not be limited to, integrity and confidentiality of data entry or collection, data storage, data transmission and data processing;
- c) Computers and automated equipment are maintained to ensure proper functioning and are provided with the environmental and operating conditions necessary to maintain the integrity of calibration data.

5.5 Equipment

- 5.5.1** CAL-TEK Co. Inc. maintains sufficient measuring and test equipment for correct performance of the calibrations within our scope. In those cases where we use equipment outside our permanent control, only equipment with a valid accredited calibration certificate and appropriate handling will be used to ensure that the requirements of this International Standard are met.
- 5.5.2** All equipment and software used in the calibration of customer owned equipment have been validated for use and all equipment will be checked and/or calibrated before use. All of our equipment is calibrated in accordance with procedure QP220 "Calibration".
- 5.5.3** CAL-TEK Co. Inc. maintains Work Instructions on the use and maintenance of our equipment. All field technicians are properly trained in the use of our equipment as evidenced by their respective training files. We maintain a library of manuals related to Lab owned and Customer owned equipment.
- 5.5.4** Each item of equipment and its software used for calibration and is significant to the results will, when practicable, be uniquely identified.
- 5.5.5** Records will be maintained of each item of equipment and its software significant to the calibrations performed. The records will include at least the following:
- a) The identity of the item of equipment and its software;
 - b) The manufacturers name, type identification, and serial number or other unique identification;
 - c) Checks that equipment complies with the specification;
 - d) The current location, where appropriate;
 - e) The manufacturer's instructions, if available, or reference to their location;
 - f) Dates, results and copies of reports and certificates of all calibrations, adjustments, acceptance criteria, and the expiration date of calibration;
 - g) The maintenance plan, where appropriate, and maintenance carried out to date;
 - h) Any damage, malfunction, modification or repair to the equipment.
- 5.5.6** We have procedure QP230 "Handling and Storage", for safe handling, transport, storage, use and planned maintenance of measuring equipment to ensure proper functioning and in order to prevent contamination or deterioration.

- 5.5.7** Equipment that has been subjected to overloading or mishandling, gives suspect results, or has been shown to be defective or outside specified limits, will be taken out of service. It will be isolated to prevent its use or clearly labeled or marked as being out of service until it has been repaired and shown by performance testing and or calibration to perform correctly. We will examine the effect of the defect or departure from specified limits on previous calibrations and will institute procedure QP340 "Customer Property" and or QP330 "Identification and Traceability".
- 5.5.8** CAL-TEK Co. Inc. uses calibration labels with the unique serial or asset number of the instrument to identify instrument, indicate the status of calibration, calibration date and date of expiration or calibration recall. Procedure QP330 "Identification and Traceability", defines the process for controlling client equipment.
- 5.5.9** When, for whatever reason, equipment goes outside the direct control of the laboratory, the laboratory manager will ensure that the function and calibration status of the equipment is checked and that the equipment is not returned to service until performance testing is completed. Quality Procedure QP430, defines the process for performance testing.
- 5.5.10** CAL-TEK Co. Inc. uses Intermediate Testing to maintain confidence in the calibration status of our equipment. This test is defined in QP440 and Form R240-1 is used for recording results. Our interval for this testing is every 90 days.
- 5.5.11** CAL-TEK Co. Inc. records "Correction Factors" applied during a calibration on the calibration documents, R200-1, related to the calibrated instrument.
- 5.5.12** CAL-TEK Co. Inc. owned test and calibration equipment is safeguarded against undocumented adjustments by the use of void seals. Our software is safeguarded against unauthorized adjustments through the use of password protection.

5.6 Measurement Traceability

5.6.1 General

All equipment used for calibrations, including equipment for subsidiary measurements (e.g. for environmental conditions) having a significant effect on the accuracy or validity of the result of the calibration or sampling will be calibrated before being put into service. CAL-TEK Co. Inc. has an established program and procedures for the calibration of its equipment.

5.6.2 Specific requirements

5.6.2.1 Calibration

5.6.2.1.1 CAL-TEK Co. Inc. maintains a calibration program for our equipment that requires the use of only accredited calibration vendors to ensure that calibrations and measurements made by the laboratory are traceable to N.I.S.T.

The calibration certificates issued by these laboratories will contain the measurement results, including the measurement uncertainty and/or a statement of compliance with an identified metrological specification.

5.6.2.1.2 There are certain calibrations that currently cannot be strictly made to N.I.S.T. In these cases calibration shall provide confidence in measurements by establishing traceability to appropriate measurement standards such as:

- The use of certified reference materials provided by a competent supplier to give a reliable physical or chemical characterization of a material;
- The use of specified methods and/or consensus standards that are clearly described and agreed by all parties concerned.

Participation in a suitable program of inter-laboratory comparisons is required where possible.

5.6.3 Reference standards and reference materials

5.6.3.1 Reference standards

CAL-TEK Co. Inc. has a program and procedures for the calibration of our reference standards. Our reference standards will be calibrated by an accredited source that can provide traceability. CAL-TEK Co. Inc. reference standards are not used for any other purpose outside of calibration, e.g. "no standard is used as a voltage supply to a device under test". Our policy is that any reference standard needing adjustment will be sent for full re-calibration.

5.6.3.2 Reference materials

Reference materials will, where possible, be traceable to N.I.S.T., or to certified reference materials. Internal reference materials will be checked as far as is technically and economically practicable.

5.6.3.3 Intermediate checks

Checks needed to maintain confidence in the calibration status of reference, primary, transfer or working standards and reference materials will be carried out according to defined procedures and schedules using QP440.

5.6.3.4 Transport and storage

CAL-TEK Co. Inc. maintains quality procedure QP230 for the proper handling, transport and storage of our calibration standards.

5.7 Sampling

5.7.1 At the present time we do not do sampling. If in the future we change our processes we will address this requirement.

5.8 Handling of calibration Items

5.8.1 We have a procedure "Handling and Storage", for the transportation, receipt, handling, protection, storage, retention and/or disposal of calibration items, including all provisions necessary to protect the integrity of the calibration item, and to protect the interests of the laboratory and the client.

5.8.2 We have a system for unique identification of calibration items. The identification will be retained throughout the life of the item in the laboratory. The system is designed and operates so as to ensure that the items cannot be confused physically or when referred to in records or other documents. The system will, as appropriate, accommodate a sub-division of groups of items and transfer of items within and from our facility.

5.8.3 Upon receipt of the calibration item, abnormalities or departures from normal, calibration VIOD seals broken or specified conditions, as described in the calibration method, will be recorded. When there is doubt as to the suitability of an item for calibration, or when an item does not conform to the description provided, or calibration required is not specified in sufficient detail, we will consult the client for further instructions, as defined in procedure "Customer Property", before proceeding and will record the discussion.

5.8.4 The appropriate facilities and procedures provide for avoiding deterioration, loss or damage to the calibration item during storage, handling and preparation.

Handling instructions provided with the item shall be followed. When items have to be stored or conditioned under specified environmental conditions, these conditions shall be maintained, monitored and recorded. Where a calibration item or a portion of an item is to be held secure, the laboratory shall have arrangements for storage and security that protect the condition and integrity of the secured items or portions concerned.

5.9 Assuring the quality of test and calibration results

5.9.1 We have quality control procedures for monitoring the validity of calibrations undertaken. The resulting data will be recorded in such a way that trends are detectable and, where practicable, statistical techniques shall be applied to the reviewing of the results. This monitoring will be planned and reviewed and may include, but not be limited to, the following:

- a) Regular use of certified reference materials and/or internal quality control using secondary reference materials and intermediate testing;
- b) Participation in inter-laboratory comparison or proficiency-testing programs;
- c) Replicate calibrations using the same or different methods;
- d) Recalibration of retained items;
- e) Correlation of results for different characteristics of an item.

5.9.2 CAL-TEK Co. Inc. has controls in place to include review and signing of all calibration reports by quality personnel. Quality personnel have been trained in the analyses of calibration reports and calibration data to ensure results are not reported outside pre-defined criteria. The calibration reporting software currently in use also has built in report criteria and will not print reports with data outside the pre-defined criteria as having passed calibration.

5.10 Reporting the results

5.10.1 General

The results of each calibration, or series of calibrations carried out, will be reported accurately, clearly, unambiguously and objectively, and in accordance with any specific instructions in the calibration methods.

The results will be reported, usually in a test report or calibration certificate, and will include all the information requested by the client and necessary for the interpretation of the calibration results and all information required by the method used.

In the case of calibrations performed for internal clients, or in the case of a written agreement with the client, the results may be reported in a simplified way.

5.10.2 Test reports and Calibration Certificates

Each test report or calibration certificate shall include at least the following information, unless the laboratory has valid reasons for not doing so:

- a) A title (e.g. "Test Report" or "Calibration Certificate");
- b) The name and address of the laboratory, and the location where the calibrations were carried out, if different from the address of the laboratory;
- c) Unique identification of the calibration certificate (such as serial number), and on each page an identification in order to ensure that the page is recognized as part of the calibration certificate, and a clear identification of the end of the calibration certificate;
- d) The name and address of the client,
- e) Identification of the method used;
- f) A description of, the condition of, and unambiguous identification of the item(s) calibrated;
- g) The date of receipt of the calibration item(s) where this is critical to the validity and application of the results, and the date(s) of performance of the calibration;
- h) Reference to the sampling plan and procedures used by the laboratory or other bodies where these are relevant to the validity or application of the results;
- i) The calibration results with, where appropriate, the units of measurement;
- j) The name(s), function(s) and signature(s) or equivalent identification of person(s) authorizing the test report;
- k) Where relevant, a statement to the effect that the results relate only to the items calibrated.

5.10.3 Test Reports

5.10.3.1 We are a calibration provider only and do not issue test reports

5.10.3.2 We do not perform sampling.

5.10.4 Calibration Certificates

5.10.4.1 In addition, the calibration certificates will include the following, when necessary for the interpretation of calibration results:

- a) The conditions (e.g. environmental) under which the calibrations were made that have an influence on the measurement results;
- b) The uncertainty of measurement and/or statement of compliance with an identified metrological specification or clauses thereof;
- c) Evidence that the measurements are traceable.

5.10.4.2 The calibration certificate will relate only to quantities and the results of functional tests. If a statement of compliance with a specification is made, this will identify which clause of the specification are met or not met.

When a statement of compliance with a specification is made omitting the measurement results and associated uncertainties, the laboratory will record those results and maintain them for possible future reference.

When statements of compliance are made, the uncertainty of measurement will be taken into account.

5.10.4.3 When an instrument for calibration has been adjusted or repaired, the calibration results before and after adjustment or repair, if available, will be reported. In cases where adjustment is not possible a "Limited Calibration" certificate and calibration label will be issued.

5.10.4.4 A calibration certificate (or calibration label) will not contain any recommendation on the calibration interval except where this has been agreed with the client. This requirement may be superseded by legal regulations.

5.10.5 Opinions and Interpretations

We do not provide opinions and interpretations on our Calibration Certificates.

5.10.6 Calibration results obtained from subcontractors

CAL-TEK Co. Inc. will evaluate and file all sub contractors calibration certificates and issue new certificates of calibration with notes as to how the data was obtained. See (4.5.1).

5.10.7 Electronic transmission of results

In the case of transmission of calibration results by telephone, telex, facsimile or other electronic or electromagnetic means, the requirements of this International Standard shall be met.

5.10.8 Format of reports and certificates

The form will be designed to accommodate each type of calibration carried out and to minimize the possibility of misunderstanding or misuse.

5.10.9 Amendments to test reports and calibration certificates

Material amendments to a calibration certificate after issue shall be made only in the form of a further document, or data transfer, which includes the statement:

- Supplement to Calibration Certificate, serial number ... (or as otherwise identified);
- or an equivalent form of wording.

Such amendments shall meet all the requirements of this International Standard.

When it is necessary to issue a complete new calibration certificate, this will be uniquely identified and shall contain a reference to the original that it replaces.

5.10.10 Out of Tolerance Conditions

Client Out of tolerance conditions will include the size of error and an out of tolerance report will be issued the client. This report can be in the form of a service report with the error conditions noted in the comment section or in a verbal communication to the client

Cal-Tek Out of tolerance conditions will include the size of error and an out of tolerance report will be issued to all client standard was used on. This report will be **written** in the form of a Notification of Standard Failure of the out of tolerance condition. This process is tracked by MetCal.

Appendix A

Revision Control Log

12-20-05	Released at Rev. A against ISO17025
03-13-06 PJLA	Updated Quality Policy to reflect changes per audit finding NCR#2 by PJLA
03-13-2008	Updated Quality Manual to reflect requirements of ISO/IEC17025:2005 and Z540.3

End of Document