COSWORTH

SUPPLIER MANUAL

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REVISION RECORD

Page	Issue		Reasons for Change & Revision summary
	Level	Date	
All	07	17/02/20	Complete rewrite and transfer to corporate template.
Various	08	03/07/20	5.1.1 – change of re-FAIR requirement to 2 years 5.1.3 – addition of clause 5.3 – complete rewrite of C of C requirements 8.2.5 – addition of clause Addition of section 10 - Counterfeit Product Prevention
Various	09	26/10/21	5.1 – Addition of clause 5.1.2 and re-numbering of subsequent clauses 5.3.2 – Clarification of processes classed as "Special processes" 5.3.3 – Addition of clause and re-numbering of subsequent clauses 7 (f) – change from 6 months to 2 years 9.4 – rewrite of clause
Various	10	19/01/24	2.6 (g) – Accommodation and facility request removed and re-numbering of subsequent clauses 5 – Reference to CP020 added 5.1, 5.2 and 5.3 re-ordered. 5.1 – PPAP element and levels defined 5.3 – Reference to CP020 and template 1188 added 5.3.4 – CofC requirement removed and replaced with 1188 and re-numbering of subsequent clauses 5.3.6 – CofC definition removed and re-numbering of subsequent clauses 9 – Reference to ST0205 added 9.1 – Changed to minimum 12-month preservation

Approved by:		
Quality Manager:	Purchasing Manager:	Quality Systems Engineer:
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1. COSWORTH SUPPLIER QUALITY MANUAL OVERVIEW

For COSWORTH to achieve its goals as set out in the Quality Policy, and those of our customers, we require all business and supply chain partners to strive to the same high standards of Quality, Delivery and Cost. For this, COSWORTH has a robust Supplier management system that ensures all suppliers to COSWORTH are working in a way that will best meet the requirements of COSWORTH and most importantly its downstream customers.

The purpose of this Supplier Quality Manual (SQM) is to convey the requirements COSWORTH stipulates of its suppliers of Products or Services and of the controls and processes around that supply. These requirements are in addition to any communicated via Purchase Order, Supply Contract, Technical Drawings, those flowed down through customer specific requirements or any other form of written communication.

It sets out the requirements of a supplier's Quality Management System, it's Product introduction process and its production management system.

For APQP and PPAP forms, it is not stipulated that a supplier will use COSWORTH formats, but formats will be supplied if requested and referred to in this manual. Where a supplier chooses to use their own document formats, they must achieve the minimum requirements set out in this manual.

2. SUPPLIER SELECTION, APPROVAL AND REVIEW

Supplier Approval Process.
COSWORTH will assess and approve all suppliers prior to the issuance of a purchase order. All Suppliers must be approved by COSWORTH, regardless of approvals by customers or other entities.

2.1 Minimum Requirements

The minimum quality requirement for suppliers of products and services to COSWORTH shall be Quality Management System (QMS) certification to ISO9001 by a UKAS (or national recognised equivalent) accredited certification body. This requirement guarantees the supplier has put in place a consistent QMS able to satisfy our basic needs. Suppliers that provide products and services that are used in projects for aviation applications may require to be certified to AS9100 or equivalent. If AS9100 certification is required, this will be stated in the COSWORTH Request for Quotation (RFQ) and Contract / Purchase Order (PO)

2.2 Exceptions

Requirement exceptions for suppliers that do not meet the minimum quality certification shall be authorised based on:

a) The supplier is mandated by our customer.
b) The supplier is the manufacturer of a single sourced product mandated by our customer.
c) The supplier is the only distributor of a product mandated by our customer.
d) The supplier provides products or services that have no direct or indirect effect on the products and services we provide our customer.
e) Supplier can demonstrate that they will meet and maintain our quality requirements

2.3 Supporting Documentation

Documents required to complete the supplier approval process are:

a) New Vendor Requisition form 0145
b) QMS certification.
c) Quality manual - if the Supplier maintains a Quality Manual, COSWORTH may request to review a copy.

2.4 Special Measures

Where the above criteria and exceptions cannot be met, depending on the product, its application, value and criticality, special authorisation may be granted where evidence of compliance can be provided.

2.5 Site Visits and Supplier Audits

Where appropriate, suppliers shall be subject to on-site audit and / or site visit by the COSWORTH Supplier Quality Engineer. In some instances, COSWORTH will be unable to raise a purchase order until supplier approval has been granted. Scheduled verification audits, site visits and business to business meetings shall be supported when required.

2.6 Access to Supplier

The Supplier shall provide COSWORTH'S Supplier Quality Engineer:

a) The right of access to facilities where the contracted activities are being performed.
b) Information pertaining to the fulfilment of contracted requirements.
c) Unrestricted opportunity to evaluate Supplier compliance to this manual.
d) Unrestricted opportunity to evaluate Supplier nominated sub-tier supplier compliance with this manual. The Supplier will be informed before such evaluation takes place.
e) Unrestricted opportunity to conduct verification of product conformity with the contract requirements.

f) Required assistance for evaluation, verification, validation, testing, inspection or release of the product to contract requirements.
g) The necessary equipment available for reasonable use for performing Quality Assurance.
h) Supplier and/or External Providers personnel for operation of such equipment as required.
i) Access to information and communication facilities.
j) The necessary Supplier documentation to confirm product conformance to specification.
k) Copies of necessary documents, including those on electronic media

3. QUALITY SYSTEM REQUIREMENTS

3.1 Quality Management System and its Process.

The Supplier shall establish, document, implement, assess and improve an effective Quality Management System (QMS) which includes the requirements of relevant international standards as necessary to satisfy the contract requirements.

3.1.1 COSWORTH'S Supplier Quality Engineer reserves the right to verify through audit that the Supplier's QMS does fully meet the requirements of both this manual, or the quality requirements as dictated by the Purchase Order. The Supplier's documented scope of their system, records from internal audit, self-assessments and other objective evidence that this system is compliant with the contract requirements and is effective, shall be readily available to the COSWORTH Supplier Quality Engineer.

3.1.2 In instances where the COSWORTH Supplier Quality Engineer identifies that the QMS does not fully meet the requirements of this manual or those dictated by the PO, the Supplier shall make proposals for corrective actions and revisions within an agreed timescale.

3.2 Quality Plan

In the absence of a recognized 3rd Party Certificate the Supplier may be requested to submit an acceptable Quality Plan (QP) which addresses the contractual requirements to the COSWORTH Supplier Quality Engineer in a mutually agreed timescale. This must be accepted by the COSWORTH Supplier Quality Engineer prior to the start of as stated in the contract or purchase order. The QP shall be a clearly identified discrete document or part of another document that is prepared under the contract.

The Quality Plan shall:

a) Describe and document the Quality Management System requirements "contract-specific" necessary to satisfy the contract requirements (referring, where applicable, to the "company-wide" Quality Management System);
b) Describe and document the planning of the product realisation in terms of quality requirements for the product, needed resources, required control activities (verification, validation, monitoring, inspection and/or testing), and acceptance criteria. This shall include specific arrangements and communication requirements where work is to be conducted at locations external to the Suppliers' premises;
c) Document and maintain traceability of requirements from the planning process by including a requirement and solution compliance matrix, justifying fulfilment of all contractual requirements (making reference where applicable).

COSWORTH'S Supplier Quality Engineer reserves the right to reject the Supplier's Quality Plan should it be found to not meet the requirements specified in the contract.

The Supplier is required to promptly notify COSWORTH Buyer or COSWORTH Supplier Quality Engineer of any substantive changes to the Supplier's Quality Management System or personnel.

4. GENERAL REQUIREMENTS

The following set of general quality requirements applies to all Suppliers.

4.1 Compliance to Contractual Requirements

Upon accepting a COSWORTH contract, the Supplier is responsible for compliance to all contract requirements (including but not limited to engineering drawings, specifications and purchase order). All documents, drawings and specifications, regardless of origin, are applicable to the Supplier when specified in the contract or documents referenced in the contract and are required to be used at all levels of the supply chain.

4.1.1 The Supplier, as the recipient of the Contract/Purchase Order (PO), is responsible for meeting all requirements stipulated in the Contract/PO. Neither audit, surveillance, inspection or tests made by COSWORTH, representatives of COSWORTH or its customer(s), at Supplier's facilities, at any sub-tier facilities, or upon receipt at COSWORTH, relieves the Supplier of the responsibility to supply acceptable products or services that conform to all contract requirements; nor does it preclude subsequent rejection by COSWORTH or its customers.

4.2 Control of Sub-Tier Suppliers

The Supplier, as the recipient of the contract, is responsible for meeting all requirements, including work performed by the Supplier's sub-tier (or special processing) Suppliers.

4.2.1 The Supplier shall ensure the sub-tier supplier is qualified and/or approved to perform the work being subcontracted. (COSWORTH recommends all sub-tiered suppliers be identified and information provided to the COSWORTH buyer at time of quote).

4.2.2 When the Supplier uses sub-tier suppliers to perform work on products and/or services scheduled for delivery to COSWORTH, the Supplier shall flow down to its sub-tier suppliers, all of the applicable technical and quality requirements contained in the COSWORTH contract / PO and within this Supplier Quality Manual.

4.3 Control and Release of COSWORTH Supplied Documents

Documents supplied by COSWORTH to the Supplier are solely for the purpose of doing business with COSWORTH. Proprietary documents may be supplied to the Supplier in hard copy, electronic or other media.

4.3.1 The Supplier is responsible for controlling and maintaining such documents to preclude improper use, loss, damage, alteration and/or deterioration. Unless authorised by COSWORTH in writing, the Supplier may not transmit or supply any COSWORTH owned documents, or copies of such documents, to anyone outside the Supplier's business organization except to a sub-tier source used by the Supplier for performance of work on the COSWORTH contract.

4.3.2 The Supplier shall return to COSWORTH, or purge electronic copies of, all proprietary documents within 12 months of the last delivery of products or services on the contract. COSWORTH may request the Supplier to supply objective evidence or certification that proprietary documents have been purged. The Supplier shall flow down this requirement to all sub-tier sources, when such sources will be in receipt of COSWORTH proprietary documents during performance of work for the Supplier.

4.4 Business Continuity

The Supplier should have a business continuity plan which would allow for the safeguarding, storage and recovery of data relating to the COSWORTH contract, (including, but not limited to, engineering drawings and electronic media). This plan should also make provision for the protection of physical assets required to deliver the COSWORTH contract (including, but not limited to, Production equipment and tooling). This plan should also contain contingency plans to satisfy COSWORTH requirements in the event

of significant utility interruptions, labour shortages, equipment failure and field returns.

5. PRODUCT QUALIFICATION

Suppliers shall supply conforming product and services on time in full including all documentation as per CP020 and any additional certification specified on the Purchase Order (including PPAP requirements).

5.1 Production Part Approval Process (PPAP)

COSWORTH may require a supplier to complete and submit a PPAP prior to delivery of production parts. The PPAP level require will be defined by the RFQ or Purchase Order and requested through the COSWORTH PPAP submission portal. Specific PPAP expectations and timing, including any exclusions will be communicated via the COSWORTH Supplier Quality Engineer who will also be able to answer any supplier questions raised.
The COSWORTH APQP & PPAP Workbook (template 0745) contains all the required forms, however, the supplier may use their own format provided their outputs match those of the COSWORTH example documents

The default elements and submission requirements shall be as follows but these are subject to change, the requirements requested via the submission portal shall take precedent. Definition of each of these elements is detailed in template 1201 (PPAP Element Definitions and Requirements).

Element	Description	Level 1	Level 3
1	Design Record	S	S
2	Engineering Change	SA	SA
3	Process Flow Diagram		S
4	PFMEA		S
5	Control Plan		S
6	Dimensional Results		S
7	Material and Performance Tests		S
8	Qualified Laboratory Documentation		SA
9	Master Sample		RA
10	Test Equipment and Tooling List		SA
11	Customer Specific Requirements		SA
12	IMDS Report	S	S
13	Part Submission Warrant	S	S

S – Submit
SA – Submit if applicable
RA – Retain if applicable

5.2 Certificate of Conformity.

The supplier shall supply a Certificate of Conformity and documentation as per the requirements of CP020 and using DELIVERY DOCUMENTATION FORM (template 1188) to confirm that the supplied parts meet all contractual requirements of the COSWORTH Purchase Order.

5.2.1 For all raw material, the supplier must provide a Certificate of Conformance for each batch supplied, with clear, traceable links to the mill certification, a copy of which should also be provided.

5.2.2 For all special processes, the supplier must provide a Certificate of Conformance for each batch processed to confirm the process requirements have been met. Special processes include, but are not limited to, all heat treatment processes including nitriding; passivation; hot isostatic pressing; non-destructive testing.

5.2.3 For all parts with testing requirements, the supplier must provide test reports for each part or batch of components, supplied. Certificates must confirm the testing has been completed as specified on the drawing and that the pass criteria have been met.

5.2.4 For all parts manufactured to a supplier-controlled drawing ("off the shelf parts") a certificate of conformance is not required unless specified on the Purchase Order.

5.3 First Article Inspection (FAI)

For all parts manufactured or modified to a COSWORTH controlled or COSWORTH customer controlled drawing, a First Article Inspection Report (FAIR) will be completed by the supplier to verify the manufacturing process using a representative item from the first manufacturing run of a part or assembly. In the case of queries over specific product FAIR requirements please consult your COSWORTH Supplier Quality Engineer.

5.3.1 The purpose of the FAIR is to verify that the production processes, production documentation and tooling are capable of producing product that meet requirements. This process shall be repeated when changes occur that invalidate the original results (this will include transfer of work to another site, drawing changes, process changes etc.) or following a break in manufacture, greater than 2 years.

5.3.2 FAIR shall be supplied with a bubbled drawing of the part number and revision number specified by the PO. It shall consist of measurement data demonstrating conformance to dimensional elements, surface finish, part marking and all other requirements dictated in the drawing and / or drawing notes. The actual component used to create the FAIR shall be clearly identified by a tag attached to the item or a label applied to the

item's bag A copy of the FAIR and any applicable certifications shall accompany the First Article part.

5.3.3 The FAIR shall also include all certification indicating conformity of materials, special processes, calibration, testing and personnel training qualification where applicable.

5.3.4 In the case that the purchased part number consists of an assembly of sub-components, a FAIR will also be required for all sub-components manufactured or modified to a COSWORTH controlled or COSWORTH customer-controlled drawing. This applies equally in the case of COSWORTH controlled or COSWORTH customer controlled machined castings – a FAIR will be required confirming conformance of the cast level part number(s) as well as any applicable machined and assembled level part number(s).

6. PROCESS CONTROL

This section defines the basic requirements for Suppliers to control their manufacturing processes.

6.1 Special Characteristics (SC)

The Supplier shall demonstrate conformity to those special characteristics designated by COSWORTH through means of documentation and appropriate control methods. In addition to any special characteristics identified by COSWORTH, the Supplier shall also review, identify, document, and control other product and process characteristics that are key to achieving quality. Features designated as SC require inspection data traceable to individual parts or lots / batches to be available for review upon request.

NOTE: A reduction in inspection frequency from 100% on COSWORTH defined SC's will only be allowed through the submission of capability data demonstrating statistical capability to a level agreed by COSWORTH.

6.2 Preventive Maintenance

The Supplier should identify key process equipment and provide resources for machine/equipment maintenance activities and develop an effective planned total preventive maintenance system.

6.3 Shelf-Life Control

With each delivery of materials or products that have a limited or specified shelf life, the Supplier shall furnish data that shows (a) the cure or manufacture date, (b) expiration date or shelf life, (c) lot or batch number, and when applicable any special handling or storage requirements. Unless otherwise specified by contract, for all shelf life limited materials or products

delivered to COSWORTH, the remaining shelf life shall be a minimum of 75% of the total shelf life for the material.

6.4 Raw Material Lot / Batch Control

Where the Supplier elects to use more than one lot / batch of raw material, the Supplier shall ensure, document and supply positive traceability of each individual product to the raw material certification/test report that represents the raw material from which each of the products were manufactured.

6.4.1 Traceability shall be provided by identifying the raw material heat, lot, batch or melt number from the certification/test report on the product and/or on packaging (when used), or the products segregated and identified.

6.5 COSWORTH Supplied Material

The Supplier shall ensure procedures are in place to properly identify and control all COSWORTH supplied materials.

6.5.1 Tooling/fixtures owned and supplied by COSWORTH must be tagged or otherwise identified as being COSWORTH owned property.

6.5.2 Material supplied by COSWORTH must be controlled, identified and segregated from other Supplier material. Unless otherwise specified by the COSWORTH buyer, Suppliers must account for 100% of consigned material.

6.6 Automated Processes

If computers, software, or other automated methods are used as part of the production or verification process, the supplier shall validate the computer software for its intended use.

6.6.1 The validation process shall create a validation protocol (describing the planned activities) and a validation report (documenting the outcome of the planned activities). All software changes shall be similarly validated prior to use.

6.6.2 The Supplier shall keep records of these activities and make them available to COSWORTH upon Request.

7. CHANGE CONTROL

In the case of products supplied under approved PPAP and parts supplied for aerospace use (as designated in the RFQ /PO), suppliers shall not make changes to their processes, location, facilities, equipment, material, product design (or any change which may affect product design or function) without

written approval from the COSWORTH Supplier Quality Engineer. Such changes may be required for:

- Correction of a discrepancy on a previously submitted part;
- Product modified by an engineering change to design records, specifications, or materials; or
- Any planned changes by the Supplier to the design, process, or manufacturing location, such as:

a) Use of other material than was used in previously approved part or product.
b) Production from new, additional, replacement or modified tools, dies, moulds, patterns, etc.
c) Production following upgrade or rearrangement of existing tooling or equipment.
d) Production from tooling and equipment transferred to a different plant site or from an additional plant.
e) Change of sub-tier Supplier for parts, non-equivalent materials, or services (e.g. heat treating, plating, etc.)
f) Product produced after tooling has been inactive for production for 2 years or more.
g) Change to test/inspection method – new technique (no effect on acceptance criteria).
h) For bulk materials: new source of raw material from new or existing Supplier, or change in product appearance attributes, etc.
i) Use of any non-conventional manufacturing methods such as electro-discharge machining (EDM), electro-chemical machining (ECM), laser or abrasive water jet metal cutting, flame spray coatings, etc.
j) Change, modification or up issue of design where supplier is design responsible.

Special processes controlled through COSWORTH specification sheets (STs) must be carried out in strict accordance with the ST requirements. Should a supplier wish to request to work outside of ST requirements, a full Engineering justification must be presented to COSWORTH Supplier Quality Engineer and approved by COSWORTH Engineering before any such changes can be implemented. As such, it is recommended that any ST requirements called out on COSWORTH Engineering drawings are thoroughly reviewed prior to contract acceptation.

8. CONTROL OF NONCONFORMING PRODUCT

Suppliers shall maintain a documented process which specifies how nonconforming product is identified, quarantined, and reacted to.

8.1 Supplied Nonconformance

For nonconforming products supplied to COSWORTH, including those that reach a COSWORTH's customer, the Supplier must endeavour to implement containment and corrective actions in as short a time as possible and is liable for all costs to correct the nonconformance

8.1.1 COSWORTH will inform the supplier of non-conforming product that is highlighted at any stage of COSWORTH's process flow including, but not limited to, goods inwards inspection, manufacturing or assembly use, engine testing and subsequent use in service.

8.1.2 COSWORTH will formally notify the supplier of a non-conformance by issuing a FRABIS report. COSWORTH Supplier Quality Engineer will determine if a full 8D report is required from the Supplier in response to the non-conformance and communicate this requirement directly to the Supplier. When raised, the Supplier will address the following through the 8D:

- Problem statement
- Containment Action across the full supply chain
- Root Cause Analysis
- Identification and implementation of Corrective Action
- Definition and implementation of Preventive action

8.1.3 8D reports shall be processed to the following timescales by the supplier:

- Supplier has 48 hours to acknowledge receipt and respond with the outcome of containment action (up to and including D3).
- Supplier has 21 calendar days to respond with a detailed corrective action (up to and including D5).
- Supplier has 28 calendar days to respond with the 8D completed in full (up to and including D8).
- Supplier will submit on or before the agreed verification date, evidence of the implemented corrective/preventive action. This evidence will allow the COSWORTH Supplier Quality Assurance Engineer to close the FRABIS non-conformance report.

8.1.4 Records of supplied non-conforming product are retained by COSWORTH and considered by COSWORTH during supplier evaluation exercises.

8.2 Supplier Request for Nonconformance – Concession

A Supplier shall not knowingly ship product that deviates from the drawing, specification limits, or design intent without prior written authorisation from COSWORTH. If such a condition exists, the Supplier may submit a request to

the COSWORTH Supplier Quality Engineer, in writing, to allow shipment of the product under a written nonconformance concession. This must include the proposed corrective action to eliminate the cause and prevent recurrence.

It is the responsibility of the Supplier to submit written request for concession using the COSWORTH Concession template 0390 to the COSWORTH Supplier Quality Engineer, no later than 48 hours before the delivery due date. It remains the responsibility of the supplier to ensure product is delivered on time to the purchase order schedule regardless of the outcome of any submitted concession request.

8.2.1 The cost of shipping, inspection, and testing to determine the potential acceptability of product subject to a concession request will be charged to the Supplier. COSWORTH's approval of a deviation/concession is specific to the products for which it has been submitted and approved and shall not to be construed as a permanent engineering change.

8.2.2 The Supplier must begin work immediately on corrective action. In all cases, the Supplier shall fully contain all product suspected of being nonconforming. In addition, nonconforming product may be returned to the Supplier at Supplier expense, or the Supplier may be required to sort any suspect product already shipped to COSWORTH or be charged back for the cost of sorting by COSWORTH.

8.2.3 Any parts shipped to COSWORTH that have been approved for deviation/concession shall be clearly identified as such externally on the box, container, or other packaging and on shipping documentation. Inside of each box shall contain a copy of the approved concession document.

8.2.4 Product accepted under concession will be recorded as such at COSWORTH goods receiving inspection. These records are retained and considered by COSWORTH during supplier evaluation exercises.

8.2.5 Prior to PPAP sign off, if product supplied under COSWORTH approved concession is subsequently found to be unfit for use during prototype manufacture, assembly or testing at COSWORTH, the product may be returned to the supplier for further investigation. A replacement part may be required at a cost and timescale agreed by both parties. This will not affect the supplier's quality rating.

8.3 Control of Reworked Product

Rework or repair is defined as additional operations that are not part of the PPAP approved production process flow, which is undertaken to bring product into full compliance with applicable drawings and specifications.

8.3.1 Instructions for rework, including re-inspection requirements, shall be approved by COSWORTH's Supplier Quality Engineer prior to the Supplier performing the rework. All rework shall be documented via a concession and must be accepted by COSWORTH Supplier Quality Engineer prior to product being shipped to COSWORTH, in line with the requirements detailed in Clause 8.3 above.

9. PACKAGING, LABELLING, DELIVERY & RECORD RETENTION

Preservation, packaging, labelling, and shipping methods must comply with common industry practices and COSWORTH requirements specified on the PO and as per ST0205.

9.1 Preservation

The Supplier shall preserve the product during internal processing, storage, delivery to the intended destination and preservation at COSWORTH in its original delivered packaging for a minimum period of 12 months.

9.1.1 In order to detect deterioration, the condition of product in stock should be assessed at appropriate planned intervals.

9.1.2 The Supplier should use an inventory management system to optimise inventory turns over time and should assure stock rotation, such as "first-in-first-out" (FIFO).

9.2 Packaging

The Supplier must adequately plan for packaging designed to prevent product contamination, deterioration or loss and to eliminate shipping damage.

9.2.1 Suppliers should, where possible, provide expendable packaging or returnable containers, where appropriate, that provide for sufficient density and protection from any likely damage that may occur.

9.2.2 Expendable materials and packaging must meet local and national standards for safe disposal and/or recycling.

9.3 Labelling

At a minimum, the label shall contain the COSWORTH part number, revision, and lot / batch control number. COSWORTH may provide the Supplier with additional labelling specifications.

9.3.1 The use of approved industry standard labelling and bar-coding shall be in accordance with any contractually agreed packaging specification.

9.4 Delivery

If a supplier becomes aware of an issue that could result in a delay to delivery, the Supplier should systematically inform COSWORTH and provide an updated plan and shipment date. The Supplier is responsible for any additional transport costs due to delays. Examples of such issues may include major manufacturing issues, supply chain failures or delays, significant weather events, large scale workforce health issues or other unplanned events.

9.5 Record Retention

Suppliers shall retain records relating to processing, testing, calibration, manufacture, supply, traceability, measurement and certification for a minimum of 7 years unless otherwise stated by contract. The Supplier shall be capable of retrieving and delivering required records to COSWORTH within forty-eight hours from time of request.

10. COUNTERFEIT PRODUCT PREVENTION

Where appropriate, the supplier shall establish and maintain a counterfeit parts/material prevention and control plan to ensure that counterfeit work is not delivered. The purpose of the Supplier's plan shall be to develop a robust process to prevent the delivery of counterfeit commodities and to control commodities identified as counterfeit.