

STALCOP LLC. SUPPLIER AUDIT

Supplier Name:	Star Enterprise						
Date:	29-07-2025		_				
Address:	Hyderabad, India , 500081						
	_						
Type of Survey:	Pre-Award:		Fol	llow-Up:		Yes	
Supplier Personnel Cor	ntacted:					Stalcop Representative(s):	
Peter Handscomb						Steve Smith	
Matt Renshaw						David Warner	
					56.5		
Phone #:	9988953673				Defect Prevention Focus:	85% of quality initiatives are p	preventive
Fax #:	040-3425262929				CO ₂ Emissions:	5 kg per 100 units shipped	
Supplier Information:				Н	Iazardous Emissioi	3.2 mg/m³ (within limits)	
Commodity/Service Pro	ovided:		IT Applications				Date Established: 1 January 1992,
All Applicable SIC Cod	les for this location:			#	62683		
Dun & Bradstreet Num	aber:		9181273737368			Dun & Bradstreet Rating:	5
No. of Facilities at this	Location:		3			_	Total Square Feet: 3000000
No. of Employees at thi	s Location:		10000	_	QA:	Yes	Inspect: Yes
Engr.:	Lance Morris	CDD	Prod.:	C	OK	Renewable Energy Usage:	40% of total energy
Energy Consumption:	120 kWh per 1,000 units	GPP Certificati on:	Certified (Valid till Augus	st 2025)	ESG Documentation:	Available (Last updated: Jan 2	2025)
Audit Summary:							

BM India Private Limited is the Indian subsidiary of IBM.[3] It has facilities in Ahmedabad, Bengaluru,Bhubaneshwar,
Chennai, Coimbatore, Delhi, Gurgaon, Hyderabad, Kochi, Kolkata, Mumbai, Noida, Pune, Mysore and Visakhapatnam.
Setween 2003 and 2007, IBM's head count in India has grown by almost 800%, from 9,000 in 2003[4] to nearly 74,000
a 2007. Since 2006, IBM has been the multinational with the largest number of employees in India.[6] IBM is very
ecretive about the geographic distribution of its employees. By most estimates, it has close to a third of its 288,000
mployees (~ 100,000) in India, and it likely has more employees there than in the US
BM, in an analyst meeting held at Bangalore on 6 June 2005 stated that IBM's India plans are for the long term
committed to invest \$6 billion in the next three years in India, triple the amount invested in the three years preceding.

Management Responsibility	Yes	No	N/A	
1. Does the company have a written quality policy or statement identifying the company's				
objectives and commitment towards quality?	Yes			
2. Is the written statement oriented towards reduction, elimination, and prevention rather than				
detection of product defects?	Yes			
3. Is the quality policy effectively communicated so that it is understood and maintained				
throughout the organization?	Yes			
4. Is there evidence that cross functional teams are involved in the quality planning process?	Yes			
5. Is there documented evidence, supported by appropriate records, that upper management is				
proactively involved in maintaining the quality system?	Yes			
6. Are quality responsibilities clearly defined and adequately staffed with qualified and				
experienced personnel to assure effective implementation of quality policies as well as of				
the achievement ofquality objectives?	Yes			Ш
7. Is there a clearly identified supplier representative whose function includes ensuring that the				
elements of customer standards are implemented and maintained?		No		
8. Do records on file indicate that the management of the organization periodically reviews the				
quality system adopted to assure compliance to the requirements of customer standards?		No		
9. Do records indicate a documented and controlled Business Plan which includes short and long term				
projections in financial, technological, sales, quality, manufacturing and involved resources as				
appropriate?		No		Ш
10. Are the company level data being used to monitor trends in terms of quality, operational and				
customer performance?			NA	Ш
11. Has the supplier developed a systematic determination of customer satisfaction levels based on a	-		-	

documented process?				
	Yes			
Quality System				
Is there a documented comprehensive quality system capable of meeting customer				
requirements?	Yes			
Are quality procedures aligned such that they are consistent in supporting the written statement				
of corporate quality policy?		No		
3. Does the supplier's procedures require that significant product and/or process changes must				
be communicated to and agreed upon by the customer prior to the actual action taken?	Yes			
Contract Review				
Does the supplier conduct a documented contract review per internal procedure(s) to ensure that				
all requirements are thoroughly understood and are within the supplier's capability prior to				
order acceptance?	Yes			
Is there documented evidence on file to indicate deployment of customer contract requirements				
into the quality system?	Yes			
Does the supplier have provisions to effectively document and deploy contract changes				
throughout the organization?		No		
4. Does the supplier adequately maintain records of contract reviews?			NA	
Document Control				
Has the supplier established and documented a procedure or procedures for controlling				
documents and data?	Yes	+ +		
Per the procedure(s) are all documents reviewed and approved for adequacy by authorized				
personnel prior to release for use?		No		
3. Are changes to existing documents reviewed and approved by the functions/organizations that				
performed the original approval?		No		
Are all changes (revisions) identified on each document and do these revision notes indicate the purpose/reason for the change?		No		
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4. Are all changes (revisions) identified on each document and do these revision notes indicate the purpose/reason for the change? 5. Are special characteristic symbols, where applicable, shown on process control plans and other pertinent documents such as control charts, in-process instructions, etc.?	Yes			
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10. Per the procedure(s) are appropriate controls maintained for the release and updating of			
electronic data and software?		NA	
Purchasing			
Is there a documented procedure for the qualification of sub-suppliers which includes an			
evaluation of their business practices, policies, and procedures?			
2. Is an on-site survey or assessment conducted at the sub-supplier's manufacturing location prior			
to the issuance of a purchase order and does it include a performance evaluation based on			
quality, delivery cost, and technical support?			
3. Does the supplier review and approve purchasing documents for their adequacy of clearly			
specified requirements prior to release of the purchasing document, i.e., quality requirements,			
description of the product or service being ordered, local government safety and environmental			
regulations, etc.?	No		
4. Does the supplier maintain up to date quality records used to evaluate sub-supplier's			
performance, including corrective actions when 100% on-time delivery is not achieved.?	No		
Product Identification and Traceability			
1. Is there a method and a procedure of identifying the product throughout its manufacturing, and		1	
delivery stages? Yes			
2. Do records indicate that lot identity and disposition are maintained throughout the supplier's			
manufacturing and delivery process to assure lot integrity and traceability to materials			T
used and processes performed?			
3. Does the method used indicate processing and inspection status of product throughout the			
system, including storage and in-process holding areas?	No		
4. Does the supplier identify parts returned from the field for rework or sort with a unique lot			
number for traceability?			
Process Control			_
Are individual operations specified by detailed work instructions on the traveler or posted at		1	
each operation per QS-9000 Element 4.9?			
2. Does the supplier's procedures require approval of the operator, process and equipment after			F
set-ups, tool changes, etc., prior to actual use?			-
3. Are workmanship standards defined to accept/reject criteria by written specifications,			
photographs, and/or labeled limit samples for operators?	No		-
4. Is there a process to identify all applicable government safety and environmental regulations,			F
i.e., handling, recycling, eliminating or disposing of hazardous material?		NA	H
5. Are the supplier's plant operating practices in accordance with these approved government	Ħ		Ħ
safety and environmental regulations as well as measures that include machine location/			T
operation, uncluttered aisles, slippery or dangerous floor conditions/markings and overhead/			 L

forklift or additional methods of material handling?	Yes		
6. Is there a process router/traveler that defines each step of the manufacturing process in use			
on the production floor?	Yes		
7. Has been prepared and implemented by the supplier a Contingency Plan to reasonably protect			
the customers supply in case of production interruptions?	Yes		
	1.00		
Incoming Materials Control			
Is there a procedure for the control and verification of purchased material prior to release to			
production and is there evidence of adherence to the procedure?	Yes		
2. Are purchased materials traceable to material certifications and used on a first-in, first-out basis?	Yes		
3. Does the supplier track purchased material rejection trends and rejection rates in Parts Per			
Million (PPM's) or by any other acceptable means?	Yes		
4. Does the procedure require positive identification of material released to production that is not			
verified, for the purpose of potential positive recall, should a discrepancy be detected afterward?		No	
5. Have established goals been directed towards the reduction of incoming inspection activities,			
where applicable, by "ship-to-stock" and/or certification programs?		No	
6. Is the material storage area clean, well organized, and sufficiently maintained to prevent damage,			
contamination, and/or loss of traceability on raw materials or components?		NA	
In-Process Inspection and Testing	Yes	No N/A	
<u>.</u>			
I. Is first piece inspection (set-up approval) required after each machine set-up, tool change,			
	Yes		
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I. Is first piece inspection (set-up approval) required after each machine set-up, tool change, or process change per a formal quality plan or documented procedure?	Yes		
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approved?				Yes			П
3. Are adequate records maintained of all inspections as	nd tests?			Yes	\vdash		Ħ
1				. 33			\pm
4. Does the supplier have adequate safeguards in place			d			NI A	1
without proper verification, acceptance, and authoriz	1					NA	_
5. Do records indicate that the supplier tracks outgoing		nds and rejection rates in				NI A	
Parts Per Million (PPM) or by any other acceptable n						NA	
6. Does the supplier perform layout inspection and func		ation for all products as	well as				
conduct scheduled audits of the packaged final produ	et?				No		
Inspection, Measuring and Test Equipment							
1. Does the supplier have a program or documented pro	cedures to co	ontrol, calibrate and mair	ntain				
inspection, measuring, and test equipment?				Yes			
2. Does the supplier establish, document and maintain of			ils of				
equipment type, identification number, location, freq							
acceptance criteria, and the action taken when results	1			Yes			
3. Are statistical methods (gage R&R and/or ISO-plot)							
inspection, measuring, and test equipment, and are a		rrective measures taken	when				
this equipment is deemed unsuitable for the specific	11			Yes			
4. Has the supplier determined and specified the require	d accuracy/p	precision?			No		
5. Does the statistical method(s) used demonstrate that							
equipment (including software when appropriate) ava	ilable is capa	ble of the required accur	racy				
and precision?					No		
6. Are all new/reworked, including employee-owned, g		to initial calibration prior					
to first use in order to validate the required bias and p	recision?			Yes			
Inspection and Test Status				Yes	No	N/A	
1. Is inspection and/or test status appropriately identifie	d throughout	the production process?		Yes			
2. Does the supplier maintain a record of the authorizat	on authority	for each of the inspectio	ns or				
tests conducted?					No		
3. Do records indicate the release of conforming produc	t only by aut	horized inspection perso	nnel?	Yes			
Control of NonConforming Product							_
1. Does the supplier have documented instructions to is	olate, identi	fy, and control all					Т
non-conforming material throughout the manufactur				Yes			t
2. Are the responsibilities for review and disposition of	1		l				Ħ
clearly defined in a documented procedure?				Yes			t
3. Does the supplier have a documented procedure for i	mmediate cu	stomer notification in the	2				Ħ
event that non-conforming material is suspected of be				Yes			t
				 	_		

4. Are products which have been dispositioned to rework or repair, handled with documented				
instructions that include re-inspection and re-identification (customer returns) prior to returning				
to the customer?		No		
5. Are customer returns subject to the same documented instructions and controls used to handle				
non-conforming material from the manufacturing process?		No		
6. Does the supplier track the rejection rate of returned goods from customers in Parts Per Million				
(PPM) or by any other acceptable means?	Yes			
7. Are non-conforming materials and products, including customer returns, reviewed and recorded				
to permit defect analysis and establishment of a prioritized reduction plan?	Yes			
Corrective and Preventive Action	Yes	No	N/A	
Does the supplier have documented corrective action procedures for all non-conformances				
detected either in their facility or their customer's facility?	Yes			
2. Do records indicate that adequate analysis has been performed to determine and eliminate the				
root cause of a nonconformance using appropriate methods of problem solving?	Yes			
3. Do records indicate that the supplier has verified the implementation and effectiveness of				
corrective action measures on subsequent production runs using mistake proofing methodology				
as appropriate?		No		
4. Is the relevant documentation, i.e., Process Flow Diagram, PFMEA, Control Plan, work				
instructions, etc., updated and re-submitted for review and approval?		No		
5. Are CUSTOMER complaints and/or reports of non-conformances handled effectively and				
resolved in a timely manner to prevent recurrence?	Yes			
Handling, Storage, Packaging, Preservation, and Delivery				
Does the supplier have a procedure for handling, storage, packaging, and delivery of product?	Yes			
2. Does the supplier's records indicate conformance to the procedure and any additional customer				
specifications?	Yes			
3. Do material handling methods prevent product damage and deterioration?		No		
4. If delivery performance is not 100% to schedule, are there appropriate analyses to determine root				
causes and corrective actions to prevent recurrence?			NA	
5. Does the supplier have an inventory management system to optimize inventory turns and stock				
rotations?	Yes			
Quality Records	Yes	No	N/A	
1. Does the supplier have a procedure for the retention of quality record, i.e., PPAP approvals,				
control charts, FMEAs, quality audits, etc., and does the procedure specify the types and				
length of time records are to be retained?	Yes			
2. Are all quality records (hard copy or electronic) readily available, legible, and identified to the				
product involved?	Yes			

Yes		
	No	
Yes		
Yes		
Yes		
Yes		
	No	
	No	
Yes		
Yes		
	No	
	No	
Yes		
Yes		
Yes		
	Yes	Yes Yes Yes Yes No No No No No Yes

5. Has the supplier developed any specialized inspection equipment to perform 100% checking of				
1 7 1		+		H
possibility of operator error?			NA	
4. Does the supplier use any automation techniques to improve product quality by eliminating the		\mp		
improved quality, capacity, or resulted in a cost reduction?	Yes			
3. Is there evidence in the supplier's records of set-up or cycle-time improvements which directly		+		
Process Development with any existing customers?	Yes	\top		
2. Does the supplier have records that indicate the supplier has participated in Concurrent product/				
cost, and delivery of products and services provided?	Yes			
Is the supplier involved in activities for the purpose of continuously improving the quality,				
Continual Improvement				
concurrence of proposed changes prior to instituting any action?	res			 <u> </u>
6. Are all revised Process Flowcharts, Process FMEA's and Control Plans sent for customer	Yes	++		
		INO		H
Updated when changes occur in design, processes, or when new failure modes are identified by subsequent rejections and root cause analysis?		No		
5. Is there evidence that the Process Flowcharts, Process FMEA's, and Control Plans are actually		+		
from the purchase of raw material through shipment to the customer?		No		
4. Do the Process Flowcharts, Process FMEA's, and Control Plans identify all significant activities		NI-		
Analysis) and a asubsequent Control Plan?		INO		
3. From this flowchart, does the supplier prepare a Process FMEA (Failure Mode and Effects		No		
processes?	Yes	\dashv		
2. Does the supplier prepare a detailed Process Flowchart for each of his new/revised products or	· · · · · · · · · · · · · · · · · · ·	\bot		
techniques on all new or changed products/processes?	Yes			
Is there a documented procedure and/or stated commitment to use advanced quality planning				
Advanced Quality Planning				
techniques?	Yes	+		
Does the supplier use advanced quality planning to determine the appropriate statistical	100	+		
process for all activities related to process variability activities in their areas?	Yes	+		
Are production personnel involved in the investigative, decision making, and problem solving		110		
processes which they are monitoring?		No		
Do production personnel possess adequate statistical skills and knowledge to understand Control Plan requirements, analyze data, and make the necessary corrections (if required) to the		No		
initial sample parts?	res			
3. Are short-term capability studies conducted on all new or changed processes prior to running	Yes	+		
			1	

1. Is the supplier's plant layout clean, efficient, organized, a	nd well lighted with demonstrate	ed .				
evidence of "good housekeeping" being practiced throug	ghout the manufacturing process?	?	Yes			
2. Is the quantity of equipment, size and physical plant layout	ut capable of handling increased					
production volumes without serious detriment to overall	operations and part quality?			No		
3. Can the supplier show examples of Mistake-Proofing on	fixtures, operations, or processes	to				
eliminate the possibility of producing a defect?				No		
4. Does the supplier have resources available for the support	t of tool and gage design and					
fabrication?			Yes			
5. Does the supplier have resources available for tool and go	age complete dimensional inspec	tion?	Yes			
Preventative Maintenance						
1. Does the supplier have a documented preventative maint	enance system to assure that					
machinery, tooling, and equipment are maintained to suppo	rt quality and production require	ments?	Yes			
2. Is there a schedule of planned regular maintenance on all	machinery, tooling and equipme	ent used				
to produce products including parts cleaning equipment?				No		
3. Are records available for all maintenance conducted with	nin the facility (both regularly sch	neduled				
and any unscheduled emergencies) whether done by outs	side contractor or company emplo	oyees?		No		
4. Are modifications or revisions of regular maintenance sc	hedules based on tooling life stud	dies				
and previous maintenance histories including emergence	cies?			No		
5. Does the supplier use statistical data to reduce downtime	(such as average number of part	s run				
prior to tool sharpening or insert change)?				No		
6. Does the supplier monitor uptime/downtime on a real time	ne basis as a measure of mainten	ance				
program effectiveness?					NA	
7. Is there a documented training program for all personnel	involved in performing maintena	ance				
Sustainability Compliance			Yes	No	NA	
Sustainusinty Compilance						
1. Is the energy consumption level under control as per the c	onsumption thresholds.		Yes			
2. Is the waste re-cycling done periodically.				No		
3. Is the emission of hazardous chemicals under control?				No		
				1		
4. Is there usage of renewable sources of energy?			Yes			
General Supplier Information			Yes	No	NA	
I. Is the supplier registered with a valid D-U-N-S number?			Yes			

T			
Yes			
	No		
Yes No NA Yes No No Yes No No Yes No No Yes No No Yes No NA Yes No NA Yes No NA Yes No NA	•		
Yes	No	NA	
Yes			
Yes			
	No		
Yes			
Yes			
	No		
Yes			
Yes	No	NA	
Yes			
Yes			
	No		
Yes			
Yes			
	No		
Yes			
	Yes	Yes No Yes Yes Yes No Yes Yes No Yes Yes No Yes Yes Yes Yes No Yes Yes No No Yes No No Yes No	Yes No NA Yes No NA Yes No No Yes No NA Yes No NA Yes No No Yes No No Yes No No No No No No No No

Yes

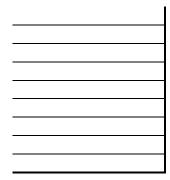
No

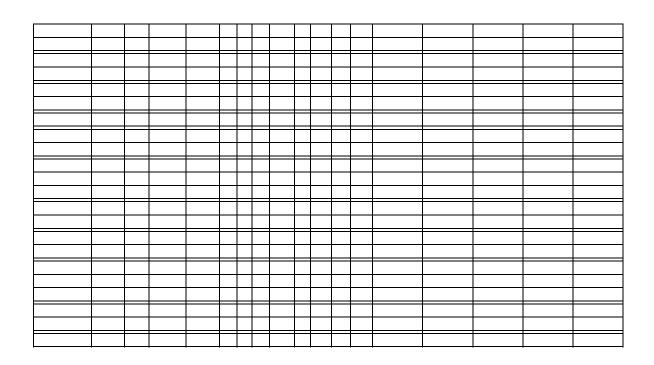
NA

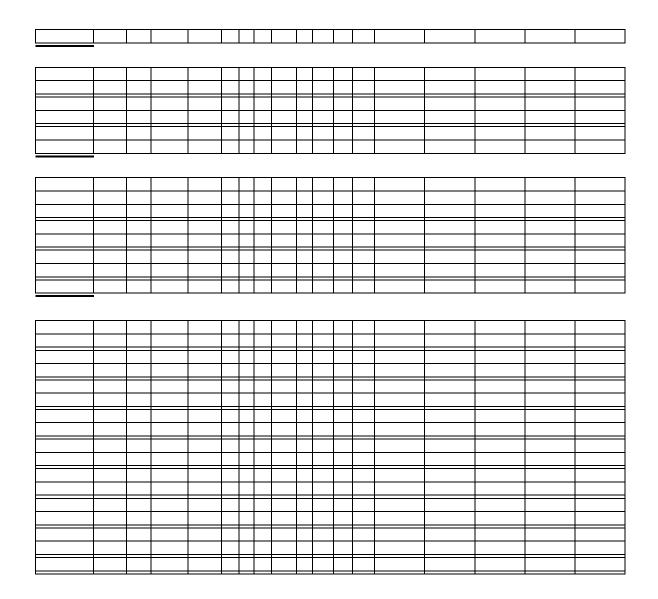
Audit Summary & Risk

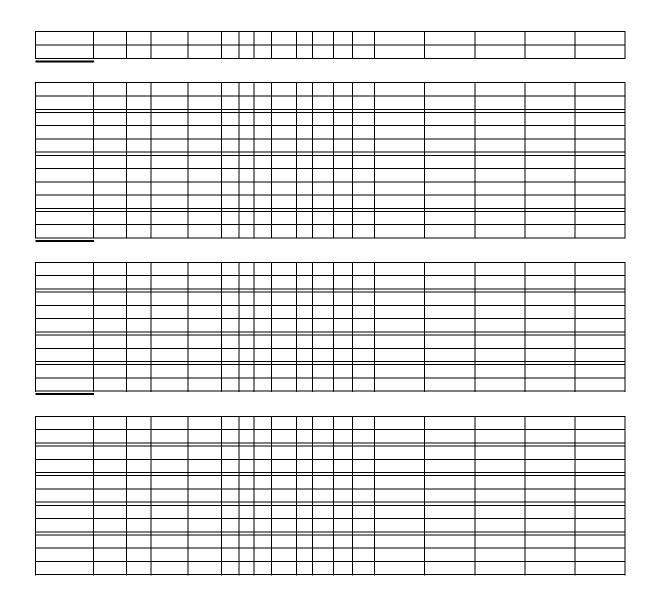
1. Are there any critical non-compliance issues identified	in the audit summary?	Yes			
2. Has the supplier provided a remediation plan for any no	on-compliance?	Yes			
Internal Procurement Policy		Yes	No	o NA	
Internal Procurement Policy 1. Is the supplier listed on the approved supplier list?		Yes Yes	No	NA	
•			No	NA NA	

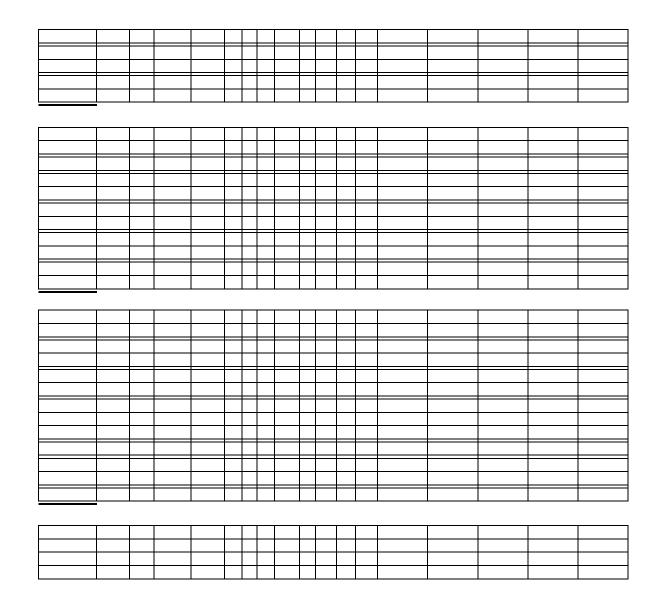
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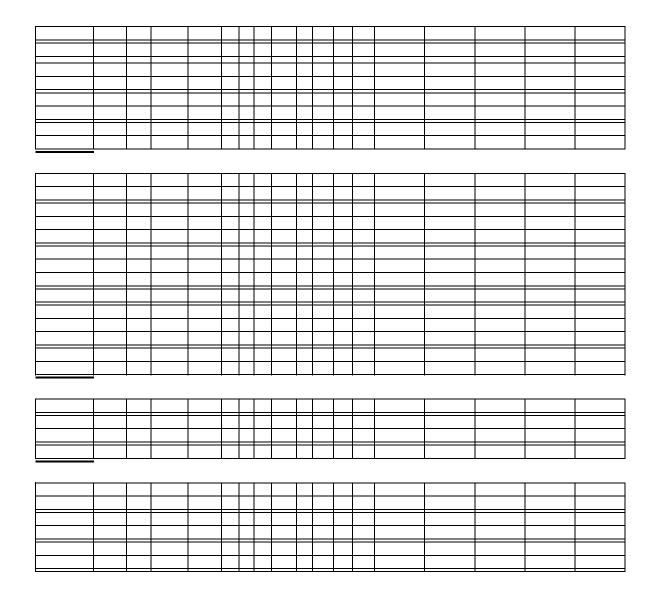


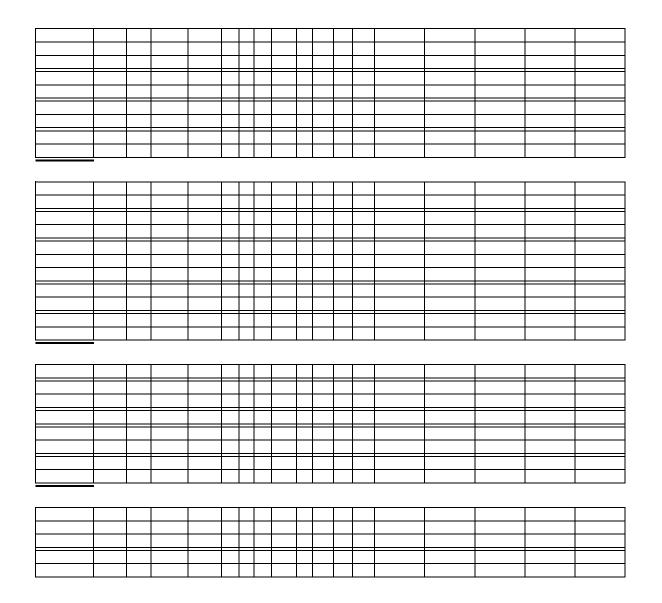


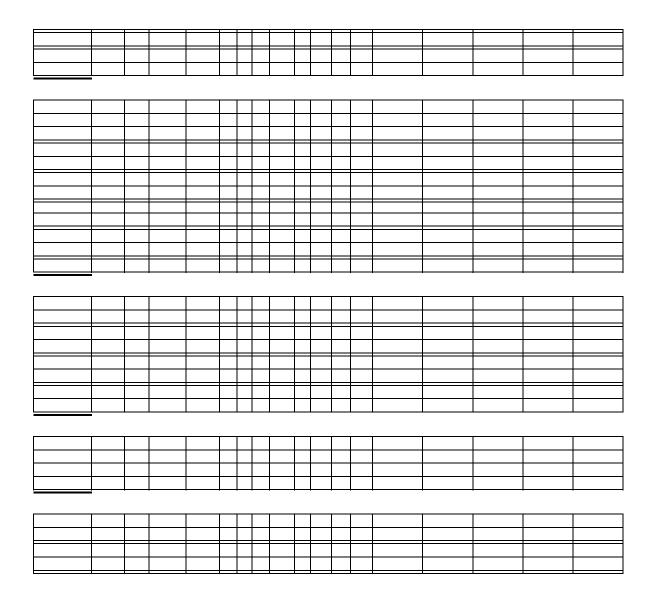


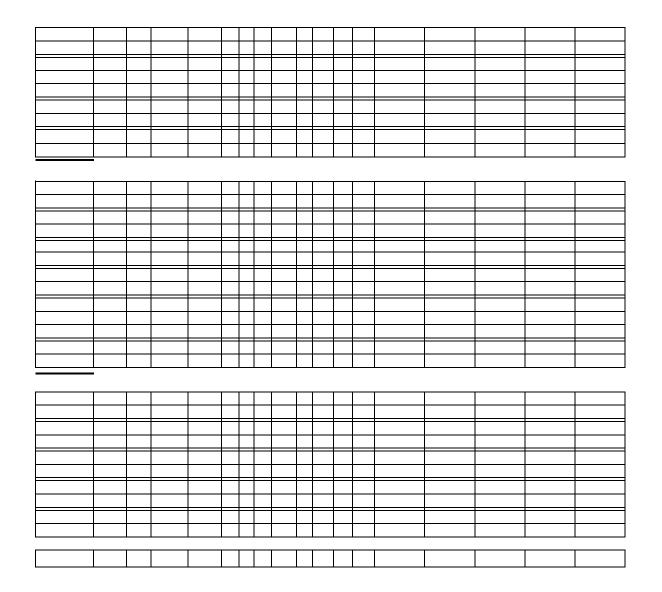


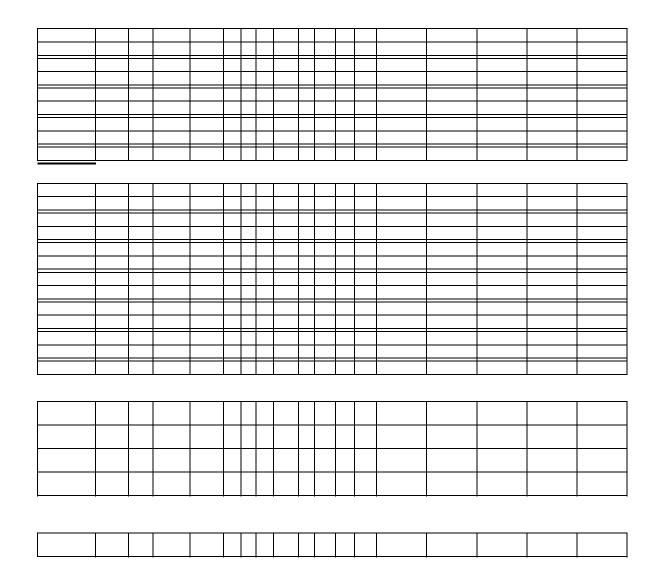


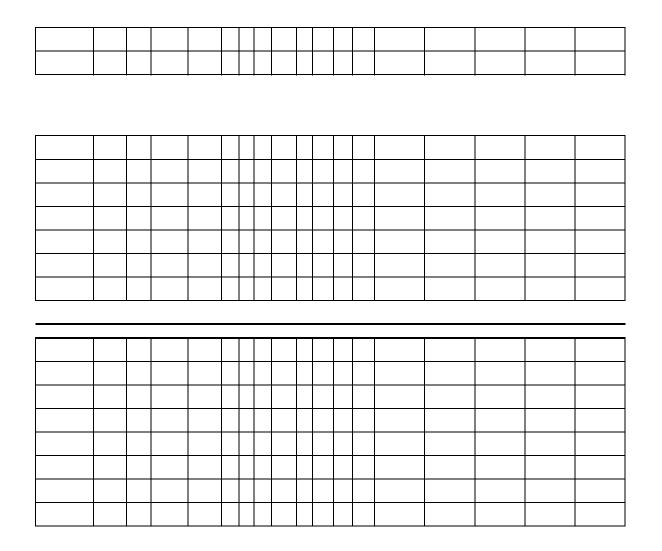












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