

ARISTO CAST

INVESTMENT CASTING

Quality Procedure QP-20-120 Quality Clauses for Sub-Tier Suppliers

1. Scope

- 1.1 Purpose- This procedure establishes the quality requirements for sub-tier processing of castings produced at Aristo-Cast.
- 1.2 Requirements- Aristo-Cast PO, customer drawings, specs, models, and other customer specific requirements.

2. Clauses

Q1 – DFAR regulations - All Material to be DFAR 252.225-7009 and DFAR 252.225-7014 Alt. 1, Mercury & other toxic substance free & no Foreign Object Debris.

Q2 - Certificate of Conformance (CofC) - Supplier shall prepare a Certificate of Conformance (CofC) with each shipment. This CofC shall certify that all items provided under this purchase order meet all applicable requirements. The CofC shall be included with the Supplier's shipper to Aristo-Cast Inc. and must provide at a minimum: Supplier name, part number, purchase order number, quantity of parts, serial numbers (if applicable), and title and signature of authorized Supplier representative.

- Metal certifications- Shall show quantitative analysis of each element as required by specifications referenced. Certifications must reference all related specifications.
- Heat Treat Certification - Shall show the type of treatment and specifications, hardness (where required), percentage of parts tested.
- Passivation Certificate of Conformance must reference the process specification used.
- NDT Certifications – Magnetic Particle, Radiographic, Fluorescent Penetrant - Inspection Certificates shall reference specifications used, number of pieces tested, with results and signed by a certified tester and must indicate level to which it is certified.
- Certs. for other misc. painting, coating, add on parts, etc. as applicable.

Q4 – Competence and qualified persons - Supplier will ensure that employees and people working on its behalf are competent and trained in accordance with the requirements of the tasks they are performing in fulfillment of this PO.

Q5 – Supplier Interactions – Interactions between Aristo-Cast and suppliers shall be documented preferably using email to provide a permanent record of these communications.

Q6 – Control and monitoring of Suppliers performance – Aristo-Cast shall evaluate suppliers' performance at least annually for on-time delivery, quality of products or services, supplier risks, and corrective actions. In the event there are issues with any of these items, corrective actions may be issued as appropriate. Unsatisfactory corrective actions may lead to removal of supplier from Aristo-Cast ASL (approved supplier list).

Q7 – Verification or Validation - Aristo-Cast Inc. shall have the right to perform in-process inspection, audits, and system surveillance at Supplier's and Supplier's sub-tier supplier's facilities as part of the verification of conformance to the requirements of this purchase order. Aristo-Cast Inc. shall have the right to utilize sample inspection methods for acceptance of product. If the sample is unacceptable, Aristo-Cast Inc. shall have the right to return all or part of the lot for credit or replacement.

Q8 – Special requirements, critical items, or key characteristics - Aristo-Cast customers may require inspection of critical items, or items that are designated as key characteristics. Flow down of these requirements will be made to the supplier as needed. Documentation shall be required as a requirement of this order. Details regarding reporting will be provided by Aristo-Cast.

Q9 - Calibration – Calibration shall be performed using equipment and standards fully traceable to NIST. Calibration supplier shall be certified to ISO/IEC 17025 or equivalent. The cert shall include:

- Actual measured values
- Acceptable limits/criteria
- Calibration method
- Environmental measuring capability
- NIST traceability and ISO/IEC 17025 or equivalent certification
- Signature certifying results

Q10 – Use of Statistical techniques for product acceptance – The supplier will use a C=0 sampling plan with AQL of 1.5 or 100% inspection unless otherwise specified or agreed upon with Aristo-Cast.

Q11- Supplier Quality system - Supplier shall provide and maintain a quality system acceptable to Aristo-Cast Inc. and Aristo-Cast Inc. customers for the supplies and services covered by purchase order. Suppliers will be provided a Supplier Survey (QF-22-101) to fill out once every 3 years. Active certifications for ISO 9001, AS9100, NADCAP, or other Quality systems are to be provided, as

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well re-certifications. Once approved, the supplier will be added to Aristo-Cast (ASL) approved supplier list.

Q12 – Customer designated or approved sources – When required by Aristo-Cast or Aristo-Cast customers, supplier shall use these specified sources.

Q13- Nonconforming processes, products, or services – Aristo-Cast will not accept any product that does not meet purchase order and/or customer requirements.

- Supplier disposition of customer design non-conforming items are limited to scrapping of the material, elimination of the nonconformance by rework to engineering drawing, or return to supplier. For items of customer design, Supplier shall submit nonconforming material reports to Aristo-Cast Inc. for disposition. Electronic medium for processing requests for material shall be via email.
- Supplier shall not incorporate any nonconformance into any product, process, procedure, or data unless and until Supplier has obtained written approval from Aristo-Cast Inc. Supplier's continued processing of Aristo-Cast Inc. provided material containing a nonconformance prior to Aristo-Cast Inc. MRB disposition is at Supplier's risk. Aristo-Cast Inc. and Aristo-Cast Inc. customers shall have the right to refuse to accept any non-conformances. When Government Source Inspection (GSI) is a requirement of this purchase order, supplier shall submit material review dispositions to supplier's local Government representative for concurrence.
- Supplier shall implement, and maintain a system that provides for identification, documentation, segregation, and disposition of nonconforming material and shall assure effective and positive corrective action is taken to prevent, minimize or eliminate non-conformances.
- Aristo-Cast Inc. shall have the right to utilize sample inspection methods for acceptance of product. If the sample is unacceptable, Aristo-Cast Inc. shall have the right to return all or part of the lot for credit or replacement.
- Upon return of nonconforming material by Aristo-Cast Inc., Supplier shall assess the identified nonconformance, complete an appropriate cause and corrective action form and submit to Aristo-Cast Inc.

Q14 – Prevention of counterfeit parts or materials- The use of counterfeit parts or materials is prohibited in the fulfillment of this order.

- Supplier shall flow down requirements to suppliers to reduce the risk of receiving counterfeit parts.

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- Ensure parts are sourced from original manufacturers (OEM), authorized distributors, or other approved sources that can provide traceability of parts and components to their original manufacturers.
- Monitor receipt of products at receiving to detect counterfeit.
- Monitor counterfeit product reporting from external sources, i.e. access to databases, information letters from OEMs.
- Quarantine and report suspect or detected counterfeit product through appropriate government and industry reporting systems. Any receipt of suspect or counterfeit parts shall be reported to Aristo-Cast. Supplier shall evaluate, disposition, and dispose of any products deemed to be counterfeit. Failure of supplier to detect and remove any counterfeit product or material may cause supplier to be removed from Aristo-Cast Approved supplier list.

Q15 – Changes to processes, products, or services, including changes of external suppliers, location of manufacture, or change in ownership.

- Supplier will notify Aristo-Cast of any change in ownership, management, or location and are subject to re-survey and approval.
- Supplier shall notify Aristo-Cast of any changes to product or process. These changes may require Aristo-Cast customer approval.
- Supplier will notify Aristo-Cast of any product or process changes or changes in approval status that affect Aristo-Cast product and are subject to re-survey and approval.

Q16 – Flow down to external suppliers - Supplier's purchase orders to sub-tier suppliers shall clearly reflect and define all processing and nondestructive testing requirements including special procedures, inspections, tests, and approval criteria as required by purchase order. Supplier shall assure appropriate specifications and other directives are available and used by Supplier's sub-tier suppliers.

- Supplier shall require sub-tier suppliers likewise to incorporate documents and requirements in purchase orders to their subcontractors.

Q17 - Provide Test Specimens for approval – When requested by Aristo-Cast or its customers, Supplier will provide test specimens for inspection/verification, investigation and/or auditing purposes.

Q18 – Record Retention - Supplier shall maintain complete records of all manufacturing, inspection, and test. Records shall be made available to Aristo-Cast Inc. and Aristo-Cast Inc. customers during the performance of this purchase

order and at least (10) years after completion of the purchase order and for such longer periods, if any, as may be specified elsewhere in this purchase order. Upon request by Aristo-Cast Inc., records shall be forwarded to Aristo-Cast Inc. at no additional cost within 30 days of request.

Q19 - Prevent Foreign Object Debris (FOD) - Supplier is required to establish and maintain a Foreign Object Debris (FOD) prevention program that employs appropriate housekeeping practices to assure timely detection and removal of residue/debris generated, during operations and normal daily tasks.

Q20 Facility access – Aristo-Cast and Aristo-Cast’s customers reserve the right to perform an on-site inspection of the Supplier’s facility. Aristo-Cast will give reasonable notification to the Supplier prior to the on-site inspection. The on-site inspection may include surveillance of the Supplier’s facilities, procedures, production methods, processes, and the Supplier’s Quality System. The Supplier shall furnish, at no cost, the necessary data as required by applicable drawings, Purchase Order, specifications, and inspection instructions to facilitate the on-site inspection. Access rights shall also be granted for regulatory agencies to the applicable areas of the facilities and to applicable documented information, at any level of the supply chain.

Q21 – Supplier contribution to product/service conformity, product safety, and ethical behavior.

- Supplier must be committed to the highest standards of ethics and business conduct.
- Supplier must comply with the law, honor commitments, act in good faith, and be accountable.
- Supplier must strive to maintain full compliance with all laws and regulations applicable to the operation of the business and customer relationships. Supplier must not offer, promise, authorize, or provide, directly or indirectly, anything of value (including business gifts or courtesies) with the intent or effect of inducing anyone to engage in unfair business practices.
- Supplier will avoid involvement in activities that may be perceived as a conflict-of-interest.
- Supplier will respect the legitimate proprietary rights and intellectual property rights of customers and Suppliers and take proper care to protect sensitive information, including confidential, proprietary, and personal information.

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- If there are concerns with respect to product safety, Supplier will communicate them to Aristo-Cast. If there is a concern at the Supplier's premises with respect to safety during the manufacture of the product, Supplier will notify its own employees of the concern and whenever possible, mitigate the concern.
- Supplier will ensure that employees and people working on its behalf are aware of:
 - Their contribution to product or service conformity
 - their contribution to product safety,
 - The importance of ethical behavior.

Q22 – Source inspection (Aristo-Cast, Aristo-Cast customer, or Government) When Source Inspection is required, Supplier shall comply with the following:

1. Supplier shall present with each shipment, for review by a source representative, the final inspection and test results, as applicable, and the CofC.
2. Supplier shall obtain evidence of source representative's acceptance. If GSI is specified on this purchase order, Supplier shall obtain evidence of Government acceptance prior to shipment.
3. When modifications, repairs, or replacements occur after Supplier's final inspection or test, Supplier shall perform re-inspection and test of affected characteristics prior to presentation for Buyer acceptance.

Q23 – Export Control/ITAR flow down information:

Items covered under this PO are subject to Export Controls in accordance with the Arms Export Control Act, or the Export Administration Act of 1979 or the Atomic Energy Act of 1954. The following controls must be applied to parts and services provided to fulfil this PO. ECI (Export Controlled Information).

- Access Control:
 - ECI information and items shall be maintained in a secured area to prevent inadvertent release or disclosure to foreign persons.
 - Foreign persons (non-US persons), including employees, consultants, visitors, and/or sub-contractors, shall be restricted from having access to ECI information and items through any means (this includes overhearing conversations, observing material or information, or otherwise obtaining access in any way).
- Storage:

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- ECI information and material shall be stored in a secured area to restrict access from foreign persons.
- Transmission:
 - ECI information shall be sent through a secure method when transmitting electronically (i.e. encryption, password protection, or secure FTP site).
- Destruction:
 - ECI articles/information shall be destroyed when no longer needed as appropriate for their industry as follows:
 - Service Providers – documents and electronic media shall be destroyed when no longer needed.
 - Distributors -- documents and electronic media shall be destroyed when no longer needed.
 - Laboratories – documents, electronic media, and test samples (less returned to the Buyer) shall be destroyed when no longer needed.
 - Destruction shall make said items unrecognizable and shall subsequently be disposed using normal waste processing.
- These requirements must be flowed down to sub-tier suppliers who supply products and services in the fulfillment of this order.

Q24 – First Article Inspection

First Article inspection and report is required for first time build and any subsequent builds when there is change to the product's configuration.

- The data submitted shall be parametric data to show compliance with drawing requirements (dimension and notes).
- The data shall consist of, as a minimum, each variable measured, its tolerance, drawing zone and actual measurement for each item.
- The Supplier shall complete and a First Article report AS9102. The report shall

Accompany the first lot of materials shipped against this order. Dimensional approval by Aristo-Cast and/or Aristo-Cast customers is required prior to shipping.

Q25 - Packaging and Shipping

Materials are to be shipped by the Supplier in containers in keeping with commercial practices to preclude any damage during shipping and storage to Aristo-Cast.

Q26 – Dimensional inspection report

Dimensional inspection reports with actual measurements are required. The format and a list of the dimensions will be arranged between Aristo-Cast and the supplier.

3.0 Revisions

- Initial Release 3.21.22 Bri Summerfield