



Title: WULCO Quality Assurance Sub-Contract Terms & Conditions

Scope: This process outlines the Wulco Inc Quality Control terms and conditions levied to suppliers providing product for Wulco Inc Companies. The QA codes identified on the purchase order correlate directly to the quality requirement of the individual purchase order contractual document. Example: QA-1, see below:

QA-1 GOVERNMENT SOURCE INSPECTION AND SURVEILLANCE

• SUPPLIER REQUIREMENTS:

- Upon receipt of this order, promptly notify the Government representative servicing your plant, so that Government inspections can be planned.
- Government inspection and/or release of product are required prior to shipment.
- Evidence of Government inspection and/or release of product are required on your shipping document.
- **Note:** QA-9 requirements also apply. See “Right of Entry” Clause in General terms and Conditions.

NOTES: If a Government representative does not service your plant, contact the nearest Defense Contracts Management Command (DCMC) inspection office. If you cannot locate the Government office, immediately notify our purchasing agent. During performance of this order, your System of Inspection, and Manufacturing Processes are subject to review, verification, and analysis by authorized Government representatives. A copy of this order will be furnished to your Government representative upon request.

Purchasing must submit the following information to QA in order to obtain WULCO and/or Government approval prior to releasing Purchase Order to the vendor:

QA-2 WULCO INC SOURCE INSPECTION:

• SUPPLIER REQUIREMENTS:

- Inspection by a WULCO INC Quality Representative is required at your plant prior to shipment of specified product.
- WULCO INC Quality Assurance Representative stamped or signed Supplier Inspection Summary is required with each shipment.

- The supplier shall furnish at no cost to WULCO INC inspection/test data, equipment and facilities necessary to accomplish product inspection to applicable drawings, specifications and other requirements.
- Final acceptance of purchased product shall be at WULCO INC facilities.
- **QA-9 requirement also applies with this QA-2 requirement.**

NOTES: WULCO INC Quality Representative reserves the right to re-inspect or re-test specified product, review processes and review/audit facilities.

QA-3 FIRST ARTICLE APPROVAL:

• **SUPPLIER REQUIREMENTS:**

- The supplier shall notify WULCO INC upon preparation of first article.
- WULCO INC and/or their customer will observe first article testing/inspection.
- The supplier shall perform first article inspection on the first deliverable article produced, utilizing all processes and equipment similar to those intended to produce the contracted quantity.
- The first article shall conform to all drawings and purchase order requirements.
- Reports of first article inspection shall accompany the first article delivered to WULCO INC.
- The supplier may only continue to manufacture additional items with written authorization from WULCO INC.
- **QA-9 requirement also applies.**

QA-4 - MAINTAIN OBJECTIVE EVIDENCE OF COMPLIANCE:

• **SUPPLIER REQUIREMENTS:**

- The supplier shall maintain on file, and make available to WULCO INC upon request, objective evidence of the following requirements, as applicable:

Physical and/or chemical test reports. Along with all inspection and test records.

Records indicating that special processing is performed by qualified process and/or certified personnel.

- Other objective evidence of compliance, as applicable.

QA-5 QUALITY SYSTEM AS9100:

• SUPPLIER REQUIREMENTS:

- The supplier shall maintain an effective quality management system in accordance with AS9100.

- NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times, for the purpose of surveillance assessment of the system as well as items procured under this purchase order. Said assessment does not constitute final acceptance of items produced.

QA-6 CERTIFICATE OF COMPLIANCE:

• SUPPLIER REQUIREMENTS:

- The supplier shall furnish a Certificate of Compliance with each shipment that attests to compliance of the purchase order requirements. The Certificate of Compliance shall certify that all materials, products, or services conform to the requirements listed within the purchase order to include any drawings, referenced specifications or documents, and associated WULCO INC Quality Assurance Codes. Where any other unspecified specifications and/or documents were used in addition to determine compliance they shall be annotated on the certificate.

QA-7 QUALITY SYSTEM ANSI/ISO/ASQC - 9001:

• SUPPLIER REQUIREMENTS

When heat treating or stress relieving 7075 series aluminum alloy product, a materials conductivity report shall be provided showing the percent IACS reading as taken following heat treatment. The IACS readings report shall show time and date the readings were taken.

QA-8 DRAWING REQUIREMENT:

• SUPPLIER REQUIREMENTS:

- The supplier shall furnish with the first shipment of this contract, a drawing or sketch and specification adequate to permit inspection and/or test of the product.

QA-9 CERTIFIED INSPECTION/TEST DATA:

• SUPPLIER REQUIREMENTS:

- Certified inspection/test data, indicating results of all required inspections shall accompany each shipment.
- For raw materials, the supplier shall furnish with each shipment, one copy of the chemical and physical analysis of the actual laboratory test, identifiable with the material, accomplished by the original supplier.

Wulco Incoming Inspection: For raw stock materials such as aluminum, steel and stainless steel, a material verification test should be performed per **WI740-1 (Alum) or WI740-2 (Steel)** as applicable.

QA-10 X-RAY REQUIREMENT:

• SUPPLIER REQUIREMENTS:

- The supplier shall furnish with the shipment x-ray film traceable per ASTM E-1742 (applicable class and grade).
- The supplier shall furnish sufficient detail illustration of the location identifiable with each new view taken.

QA-11 TRACEABILITY REQUIREMENT:

• SUPPLIER REQUIREMENTS:

- Device Manufacturers

NOTE: (For government contracts levied to our suppliers): During performance of this order, your Quality System, and Manufacturing Process are subject to review, verification and analysis by authorized Government representatives. Refer to "Right of Entry" clause in general terms and conditions.

- Other Suppliers

• NOTE: During performance of this order, your control of device lot traceability documentation and your inventory control for MIL-PRF-19500 JAN branded devices are subject to review, validation and verification by an authorized

- Government representative. Government release (DOD stamp) of shipment is not required unless you are otherwise notified.

QA-12 AGE CONTROL REQUIREMENT:

• SUPPLIER REQUIREMENTS:

- The supplier shall provide material that contains at least 75% of its remaining shelf life.
- The supplier shall provide pertinent shelf life data with each shipment.
- The supplier shall ensure that all materials, which are harmful to human health and/or property, are properly contained in accordance with applicable Government specifications.
- The containers will be plainly marked as to contents with appropriate warnings, precautions, instructions and storage conditions.

QA-13 MATERIAL SAFETY DATA SHEET (MSDS):

• SUPPLIER REQUIREMENTS

- The supplier shall provide MSDS information for each affected item on the purchase order.

NOTE: Chemical Manufacturers and Importers must develop an MSDS for each hazardous chemical they produce or import, and must provide the MSDS automatically at the time of the initial shipment of a hazardous chemical to a distributor or user. Distributors must also ensure that customers are similarly provided an MSDS.

QA-14 FOREIGN OBJECT SENSITIVE ITEMS / FLIGHT CRITICAL COMPONENTS:

• SUPPLIER REQUIREMENTS:

- The supplier shall include in their final inspection procedures, before closing, the inspection for Foreign Objects (loose parts/debris), which may impede the mission of this Aviation related equipment.
- A copy of the procedure shall be made available to WULCO INC, or its customer upon request.

QA-15 SPECIAL QUALITY REQUIREMENTS:

• SUPPLIER REQUIREMENTS:

- The supplier must comply with the special requirements as depicted on the purchase order.

QA-16 FIRST PIECE INSPECTION:

• SUPPLIER REQUIREMENTS:

- The supplier shall clearly identify and furnish the first deliverable product to WULCO INC for inspection.
- The supplier shall furnish at no cost to WULCO INC, inspection/test data supporting product compliance.
- The first piece shall conform to all drawings and purchase order specifications.
- The supplier shall destroy all drawings after final product delivery IAW purchase order requirements as follows: For unclassified, limited documents, destroy by any method that will prevent disclosure of contents or reconstruction of the document. For classified documents, follow the procedure in DOD 5200.22-M.
- When welding requirements per AWS D17.1 class A or B, the supplier shall submit a copy of their qualifying Welding Procedure Specification (WPS) and Procedure Qualification Report (PQR) with the first shipment.

NOTES: The supplier may, at their own risk, continue to manufacture additional items prior to notification of inspection results and written authorization from WULCO INC.

• WULCO INC REQUIREMENTS:

- Receiving shall notify QA upon receipt of product that requires first piece inspection.
- WULCO INC shall perform first piece inspection on the first deliverable product.
- WULCO INC will notify the supplier of inspection results and provide instructions for continuation of production/shipments.

NOTES: The supplier may, at their own risk, continue to manufacture additional items prior to notification of inspection results and written authorization from WULCO INC.

QA-17 CERTIFICATE OF CALIBRATION:

• SUPPLIER REQUIREMENTS:

- The supplier is required to provide calibration certificate with shipment of equipment.
- Certified inspection/test data, indicating results of all required certification shall accompany each shipment.
- The supplier/subcontractor shall maintain an effective Calibration System in accordance with ANSI/ISO/ASQC 10012.
- A written description of this system shall be made available to WULCO INC, upon request.
- NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times for the purpose of surveillance assessment of the Calibration System as well as items procured under this Purchase Order.

QA-18 MECHANICAL FABRICATION & INSPECTION REQUIRMENTS:

• SUPPLIER REQUIREMENTS:

- Product acceptance is based upon WULCO INC inspection results.
- The supplier shall maintain on file, and make available to the WULCO INC upon request, objective evidence of the following requirements, as applicable:

Physical and/or chemical test reports. Along with all inspection and test records.

Records indicating that special processing is performed by qualified process and/or certified personnel.

Exception: If a QA-9 has been applied in addition, the supplier shall furnish at no cost to WULCO INC, inspection/test data supporting product compliance.

- **WULCO INC** reserves the right to re-inspect or re-test specified product review processes.
- The supplier shall destroy all drawings after final product delivery IAW purchase order requirements as follows: For unclassified, limited documents, destroy by any method that will prevent disclosure of contents or reconstruction of the document. For classified documents, follow the procedure in DOD 5200.22-M.

- Unfinished parts incurring services such as heat treatment or plating shall be identified per the designated part number on the PO by bagging or tagging.
- Items that are fabricated complete to drawing requirements shall be marked IAW the governing drawing.
- All parts shall be properly packaged to ensure that damage does not occur to material during transit. Different parts shall not be commingled together.

NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times for the purpose of surveillance assessment of the Calibration System as well as items procured under this Purchase Order.

QA-19 VENDOR SUPPLIED KITS:

• SUPPLIER REQUIREMENTS:

- Items requiring kitting for WULCO INC shall require a comprehensive packing list of all parts contained within the kits, to include any approved substituted parts. As a minimum, the following information should be included on the vendor supplied packing list:

.. Part number (to include substitute part numbers and P.O. identified part number, quantity and nomenclature).

.. Shelf life items shall be identified according to MIL-STD-129 and should have at least 75% of the existing shelf life remaining at time of shipment.

.. Hazardous materials (HAZ-MAT) should be packaged IAW CFR-49 and IATA requirements based on method of transportation.

.. The vendor shall identify all line items in the kit IAW MIL-STD-129.

NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times for the purpose of surveillance assessment of the Calibration System as well as items procured under this Purchase Order.

• WULCO INC REQUIREMENTS:

- The packing list will be used as a basis for Kit acceptance as well as approval of substitute parts.

QA-20 FIRST ARTICLE INSPECTION (AS9102 REQUIREMENT):

SUPPLIER REQUIREMENTS:

- The supplier shall notify WULCO INC upon preparation of first article.
- The supplier shall perform first article inspection on the first deliverable article produced, utilizing all processes and equipment similar to those intended to produce the contracted quantity.
- The first article shall conform to all drawings and purchase order requirements.
- First article inspection reports shall be completed and submitted to WULCO INC QA for approval prior to shipment.
- Completed and approved first article inspection reports shall accompany the first article delivered to WULCO INC.
- QA-9 requirement also applies.

NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times for the purpose of surveillance assessment of the Calibration System as well as items procured under this Purchase Order.

QA-21 ITAR / EAR Restrictions Apply for this Order:

SUPPLIER REQUIREMENTS:

Safe Guard the technical data and drawings from view or handling from other than US Citizens. This technical data shall not be transmitted over the internet or FAX systems.

NOTES: WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times for the purpose of surveillance assessment of the Calibration System as well as items procured under this Purchase Order.

QA -22 Latent Defects or Discrepancies: (Supplier Notification to Wulco)

The supplier shall notify Wulco Inc notification of latent defects of product or materials after delivery of suspected nonconforming product or materials to allow Wulco the opportunity to accept said product and or notify our customer (s) of the nonconformance issues with the delivered product (s).

QA -23 Suppliers Notification in product / product definition, product configuration:

The supplier shall notify Wulco Inc notification of all issues and obtain contract approval concerning product or materials product definition, product configuration, material substitution or other issues that are outside the scope of the contractual engineering documents.

QA –24 Supplier Flow Down (Sub-Tier suppliers) Requirements:

The supplier shall notify Wulco and obtain permission to use sub-tier suppliers prior to sub-contracting Wulco products or materials.

QA-25 Right of Entry:

WULCO INC, along with its customer, reserves the right to enter the supplier's plant at all times, for the purpose of surveillance assessment of the system as well as items procured under this purchase order. Said assessment does not constitute final acceptance of items produced.

QA-26 Fabrication Filler Material Identification

GTAW filler material shall be ordered as “Flag Tagged” or “Wire Stamped” material. When flag tagged or wire stamped material is not available the material shall be color coded using a color traceable to the heat/lot number and so identified on the purchase order and material Certification. The material shall be color coded by the supplier or when receiving the product by Jet Weld Quality Personnel.

QA-27 Record Retention Time

The supplier shall retain all Jet Machine records maintained by the supplier for a minimum of 7 years or as specified in the purchase order.

Revision No.	Date	Author	Approved By	Changes / Remarks
Initial Release	02/17/2009	Ken Smith		Initial
Rev-01	02/26/2009	DAS		Added QA 22 thru 25 Clauses
Rev-02	10/22/2009	DAS		QA 9 Insp. of raw stock material and numbering per QB 423-1
Rev-03	01/26/2010	Ken Smith		Added QA 26
Rev-04	08/19/2010	Ken V.		Changed QA-9 WI740-2 & WI740-3 to WI740-1 & WI740-2
Rev-05	12/15/2011	Ken V		Added QA-27 Record Retention time.
Rev-06	1/30/12	JNP	KV	Added approval column to history / added copies are uncontrolled to footer / removed rocket from header

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