



## CASCADE GASKET QUALITY REQUIREMENTS

This Quality Assurance Specification establishes the specific requirements that apply when one or more of the following Quality Requirements (QR) are specified by code on Cascade Gasket Purchase Orders. These requirements are in addition to those set forth in any other contractual document. The provisions indicated herein are an integral part of the Purchase Order.

Compliance with these requirements does not reduce Seller responsibility for furnishing materials and services, which fully comply with all applicable Drawing(s) and Specification(s), nor does it guarantee acceptance of materials or services by Cascade Gasket. In the event that materials or services are found to be defective and cannot be demonstrated by the Seller to be in conformance with the Purchase Order, Cascade Gasket has the right to reject them.

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## QUALITY REQUIREMENTS

### **QR1. INSPECTION SYSTEM REQUIREMENTS:**

The Seller shall provide and maintain an inspection system in conformance with:

- D6-82479, Appendix B
- ISO-9001
- AS9100

Or Other Quality System approved by Cascade Gasket

In addition, **SPECIAL TOOLING (ST):** The Buyer and Seller shall maintain the appropriate organizational structure, staffing levels, training, processes, procedures and equipment to adequately perform at the designated level of capability. The Seller is required to communicate to the Buyer for evaluation of capability impact when changes to Seller's organizational structures, staffing levels, training, processes, procedures or equipment occur. Product shall meet all requirements of AS 9100 Rev C and the current revision of Boeing D950-11059-1."

### **QR2. CONTROL OF CHANGES:**

Supplier is to use latest drawing and/or specification revision level unless otherwise specified on the PO.

Seller agrees not to make any change in materials, design details or other product and/or process definition which would affect the part or any component part thereof without prior written Cascade Gasket approval. The Seller will identify, on the Statement of Conformance and/or packing sheet, the as built revision level of the end item product being delivered.

### **QR3. SUPPLIER CORRECTIVE ACTION:**

Seller shall, on request, on forms designated by Cascade Gasket, provide statements of corrective action on failures of seller's hardware or quality system. Corrective action statements, at Cascade Gasket option may require approval signature by Cascade Gasket and Government Quality representative.

### **QR4. RIGHT OF ENTRY:**

The customer reserves the right to enter, observe, record and or report on any activities and all applicable quality records at the Supplier during the manufacturing of the Customers Products. The right to verify at the seller's premises that subcontracted product conforms to specified requirements. Such verification shall not be used by the seller as evidence of effective control of quality by the supplier.

### **QR5. SHELF LIFE AND TEMPERATURE SENSITIVE MATERIALS:**

The Seller shall identify all materials and articles which have definite characteristics of quality degradation with age or environment. The Seller shall affix this information directly on the material container or article. This identification shall indicate the date useful life was initiated and the date or cycle at which the useful life will be expended. When environment is a factor in determining useful life, the identification shall include the storage condition (i.e., temperature, humidity, etc.) required to achieve the stated life. A minimum of 75% of the applicable material/article shelf life shall remain upon receipt of the material by Cascade Gasket or the material is subject to rejection and returned to the seller.

### **QR6. IDENTIFICATION/PACKAGING:**

Unless otherwise specified by Purchase Order, parts, assemblies and components shall be identified per the engineering drawing and marked with the date of manufacture. When identification is not specified on the engineering drawing, the product shall be identified with the part number specified on the Purchase Order. When items are too small to be easily identified, parts may be bagged or tagged, with the proper identification indicated on the bag or tag. Raw material procured to Federal, Military, Aerospace or other specifications shall be marked per the identification specification, which is referenced in the controlling specification. The seller is responsible for assuring that all items are delivered without damage or deterioration and are efficiently and economically packed for the method of transportation and type of handling involved. Unit and intermediate packaging will be employed as necessary to prevent damage or deterioration.

In addition, each shipment by the Seller shall be accompanied by a Statement of Conformance in accordance with the above. When the items or the items contained within an assembly, sub-assembly or detail part on this Purchase Order are supplied by a distributor, a copy of the Statement of Conformance from the true manufacturer must accompany each shipment.

**QR7. MATERIAL SAFETY DATA SHEETS:**

Materials(s) noted on this purchase order must be supplied in accordance with OSHA's hazard communication standard 29CFR1910-1200, OSHA instruction CPL2-2.38 dated August 5, 1985 and Washington State codes 296-62-05413 a "Materials Safety Data Sheets". All first time orders MUST be supplied with "Materials Safety Data Sheets". Materials not received in compliance with aforementioned OSHA requirements and Washington State codes will be subject to immediate rejection and return at supplier's expense.

In addition, if Seller is aware of any additional precautions and/or handling techniques instituted with regard to other customers, seller is required to submit those safeguards with MSDS.

Seller is required to forward a Toxic Substances Control Act (TSCA) certification letter to the Cascade Gasket for the product(s) purchased on this purchase order with the statement that every chemical component of the product(s) is listed by the Toxic Substances Control Act Inventory (P.L. 94-94-969).

**QR8. CALIBRATION SYSTEM REQUIREMENTS:**

Seller shall have a calibration system that assures compliance with ANSI / NCSL Z540-1 "American National Standard for calibration". Any deviation or waiver to this requirement must be approved by Cascade Gasket's Material and Quality Assurance Representatives.

**QR9. STATEMENT OF CONFORMANCE:**

The Seller shall certify that the product delivered conforms in every aspect to the contractual and technical requirements of the Purchase Order, engineering drawings(s), specifications and standards referenced therein. Where required by the Cascade Gasket purchase order, inclusive of all documents referenced therein, parts, materials and processes have been procured from approved sources. The Statement of Conformance document shall be signed by a representative of the Seller and shall contain the specification revision level when applicable, the cure date / shelf life date that might include date of manufacture and a shelf or an expiration date. The C of C will also include at a minimum Cascade Gasket's Purchase Order Number, lot and or batch number, manufacture identification number, part number and quantity.

**QR10. MATERIAL TEST REPORTS:**

A legible copy of material test reports shall accompany each shipment. Test reports shall be identified with specification number and heat and/or cure lot number and cure date, as applicable. Chemical and physical test reports shall include actual numerical values for each property tested in accordance with the applicable specification. When more than one specimen is required, test results of each are required on the report. Specification and revision shall be shown on each test report furnished.

In addition, a legible unaltered copy of the test report must accompany each shipment, unless verified and validated by the Cascade Gasket Quality Assurance Representative at the Sellers facility.

Raw Material Suppliers and Distributors may be exempted for material not controlled by specification requirements to provide test reports.

**QR11. APPROVED PROCESS REQUIREMENTS:**

Special processes (i.e. testing, heat treat, nondestructive testing, etc.). When required by the process specification must be performed by sources approved by the customer (process document owner).

The Seller is responsible for assuring that the processing source has in their possession a current customer approval of their process capability for the processes to be performed, prior to their performing the process.

In addition, each shipment must be accompanied by a legible unaltered copy of the certification from the processing source demonstrating compliance with the specification for the processes performed and that the processor is/was approved by the customer to perform the processes at the time the product was processed. If this certification is verified and validated by a Cascade Gasket Quality Assurance Representative at the Sellers facility, it may be retained by the Seller.

**QR12. FIRST ARTICLE INSPECTION:**

A legible and reproducible copy of the Sellers First Article Inspection (FAI), compliant with AS9102 latest revision, on the initial part or lot (as applicable) at the detail, subassembly and/or assembly level or after no orders produced for Cascade Gasket within 2-years. The results of the FAI shall indicate 100% conformance to engineering drawing characteristics, special processes, and functional test and laboratory requirements. Subsequent FAI's shall be performed under the conditions: (1) Engineering changes (configuration changes affecting form, fit and/or function) require a Delta FAI for those characteristics affected by the change.(2) If major changes are made in the Sellers method of manufacturing, a Delta FAI shall be performed for those characteristics affected by the change.

**QR13. REPORT OF DISCREPANCYS:** Any departure from drawing specifications or other Purchase Order requirements shall be documented by the Seller and submitted to Cascade Gasket & Mfg. Inc., within 24 hours for consideration and disposition. A copy of the dispositioned document shall accompany each affected shipment.

In addition, **REPORT OF ESCAPE:**

The Seller upon discovery of a shipment / delivery of nonconforming product must provide a notice of disclosure to the Cascade Gasket within 24 hours of discovery.

**QR14. TRACEABILITY/LOT AND BATCH CONTROL:** Seller shall maintain lot and batch control of raw materials and details to purchased items through the use of lot, batch, serial number, or date of manufacture, as applicable, for all items in the shipment. Shipping documents shall identify the lot/batch or serial number, as applicable, for all items in the shipment.

**QR15. Quality ASSURANCE RECORDS RETENTION:** Seller shall retain manufacturing planning, all certifications, and test reports required to assure that commodity conforms to the contractual and technical requirements of the Purchase Order for a minimum of 7 years after closure of the Purchase Order.

**QR16. SUPPLIER FLOW DOWN:** Seller shall notify Buyer prior to outsourcing any requirements pertaining to Buyer's purchase order. After approval for outsourcing, in writing by Buyer, Seller must flow down all requirements outlined on Buyer's purchase order, including any key characteristics, to their supplier.

**QR17. ITAR WARNING:** International Traffic in Arms Regulation (ITAR) Warning. Equipment and/or technical data generated or delivered in performance of this contract may be controlled by the Code of Federal Regulations, International Traffic in Arms Regulation (ITAR), 22CFR, Chapter 1, Part 120, Sections 120-130, and may require an export license before assigning any foreign person or foreign national to perform work under this contract or before granting access to foreign persons or foreign nationals to any equipment/technical data generated or delivered in performance of this contract (See 22CFR, Ch. 1, Section 123). A foreign person is any natural person who is not a lawful permanent resident of the U.S. or who is not a protected individual. It also means any foreign corporation, business association, partnership, trust, society or any other entity or group that is not incorporated or organized to do business in the U.S., as well as international organizations, foreign governments and any agency or subdivision of foreign governments (e.g., diplomatic missions). It also includes any foreign interest and any U.S. person effectively owned or controlled by a foreign interest. A foreign national is any person who is not a citizen or national of the U.S. If you have any questions about the proper application of ITAR restrictions, immediately contact your Imaginetics, Inc., Procurement Representative for resolution.

**QR18. WARNING CONCERNING TECHNICAL DATA SUBJECT TO U.S. EXPORT LAWS & REGULATIONS:** Seller agrees to comply fully with all applicable U.S. Laws and Regulations as they may apply to the export of any hardware, software, defense service or technical data (collectively "Data") provided by, through or with the cooperation of Seller in the performance of this subcontract in the U.S. or abroad or under any export license or exemption issued to Cascade Gasket. Seller agrees that it will not permit the re-export of data, including to foreign persons, employed by or associated with, or under contract to Seller or Seller's lower-tier suppliers, without the prior written consent of Cascade Gasket and under authority of an Export License or applicable License Exemption. In addition, Information furnished to Seller under this solicitation/Purchase Contract may contain data subject to U.S. Export Laws and Regulations. Seller is advised that such data may not be exported or re-exported to foreign persons, employed by or associated with, or under contract to Seller or Seller's lower-tier suppliers, without the prior written consent of Cascade Gasket and under authority of an Export License or applicable License Exemption. If such data is marked as Export Controlled, Seller indemnify and hold Cascade Gasket harmless from and against any and all claims, liabilities and expenses resulting from Seller's failure to comply with the Export Laws and Regulations of the United States.

**QR19. SIKORSKY APPROVED SUPPLIERS:** All special processes for details and assemblies shall be processed using Sikorsky-approved suppliers. All material and hardware used in details and assemblies shall be obtained from Sikorsky-approved sources.