



## **Bescast, Inc.**

### **Supplier Quality Requirements**

The following are the minimum quality requirements for Bescast Suppliers. These requirements are applicable to all suppliers providing production material or services to Bescast, Inc. Please report immediately any exceptions to these minimum quality requirements. Bescast will review your request for exception to stated minimum quality requirements and respond accordingly. Failure to report an exception means you agree to accept fully the minimum quality requirements.

#### **A. GENERAL**

1. Bescast requires that suppliers will provide assure us of consistent quality of product and/or services. This requires that a supplier must agree to, and be able to meet all of the specified or implied requirements of our purchase orders. Although we recommend third party certification such as ISO9000, it is not required at this time. But we do expect that a quality system be in place that is appropriate for the type of goods and services provided. In most cases the system should be documented and, in all cases, the system must provide evidence of adequate control.

#### **B. RIGHT OF ENTRY**

1. The Supplier's quality system shall be subject to initial and periodic review and acceptance by Bescast and its Customers or regulatory agencies to the extent required (including all applicable records) to determine the Supplier's continued conformance to this specification's requirements. The purpose of this review is to evaluate the Supplier's quality system and the continued capability to provide material and/or services to Bescast

2. Bescast reserves the right to conduct or witness manufacturing operations, inspections and tests as necessary to verify conformance of material or services to purchase order requirements. The Supplier shall provide Bescast personnel with reasonable facilities, equipment, records, and assistance as required in the course of verifying conformance.

#### **C. QUALITY SYSTEM**

1. The Supplier shall establish, implement, and monitor an effective and economical quality system, which shall provide for control and identification of material throughout the processing cycle; prevention and detection of non-conformances; timely corrective action; disciplines required to produce material that is representative of good workmanship; and analysis of information to evaluate quality effectiveness.

2. The Quality System shall be documented, generally taking the form of a manual. The documentation shall describe the sub-systems utilized to fulfill these system requirements, including exhibits of the various forms, tags and other control documents. Instructions and procedures shall be under revision control and maintained current by authorized Supplier personnel with a revision history maintained. The system and revisions are subject to Bescast's disapproval. Bescast may identify certain elements of the system which, when changed, will require our Customer's prior approval. The system documentation shall be available for review and, when requested, shall be forwarded to Bescast.

3. The requirements of this document shall be satisfied, in addition to all detailed requirements specified or referenced in the purchase order, drawings, and specifications. Any deviations from these product/process requirements must be approved by Bescast. Acceptance of the Supplier's quality system and any other plans or procedures shall not be construed as cause for acceptance of material or service. Our Customer's surveillance shall not be used to fulfill any of this specification's requirements without Bescast's prior concurrence.

4. In the event of supplier's change in certification status, significant changes in ownership/management, notification to Bescast is required within 5 business days in writing.

**D. QUALITY PLANNING** - The Supplier shall review the requirements prior to acceptance of the purchase order to assure the requirements can be satisfactorily met. Prior to initiation of work, provisions shall be made for all necessary processes, fixtures, equipment, facilities, skills, and controls required for assuring compliance.

**E. PRODUCT/PROCESS CHANGES** - The supplier shall notify Bescast in writing prior to implementation of changes in product or process including manufacturing locations. Bescast and/or Bescast customer approval may also be required prior to implementation.

**F. FLOW-DOWN TO SUB-TIER SUPPLIERS** - The subcontracting of work to other suppliers that are not specified on the PO can only be performed with Bescast approval. If approved, all of the requirements outlined in this document and the PO applies and must be flowed-down to the sub-tier supplier.

**G. DOCUMENTATION / TRAINING** - Documentation shall be in place in a form appropriate to the circumstances, for work that affects quality (including such things as purchasing, handling, inspection/test, machining, fabricating, assembly, etc.). It shall describe the activities and responsibilities of the work functions that affect quality, and shall be provided for use by personnel responsible for performing the work. The extent of documentation required shall be dependent on the type and complexity of the material or services provided and the skills and training required by personnel carrying out the activity.



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**H. CONTROL OF PURCHASES** - Suppliers are responsible for the quality of purchased materials and services, and shall develop plans to assure they are appraised to the extent required for adequate assurance of quality. The nature and extent of control shall be dependent upon the type of material or services, demonstrated capability, and the quality evidence furnished.

**I. INSPECTION / TESTING** - Inspection and testing activity should be established to adequately verify the conformances of the product or material at incoming, in-process, and final production activities. This should include a uniform method for performing inspection and test, and reporting results.

**J. MEASUREMENT AND TEST EQUIPMENT**

1. Appropriate measuring and testing equipment (including instrumentation) shall be employed, subject to a calibration control system. Equipment removed from the calibration control system shall be appropriately identified and not used in determining acceptability of material, product, or process for Purchaser use.

2. The Supplier shall control, calibrate and maintain inspection, measuring and test equipment, whether owned by the Supplier, on loan, personally owned or provided by Bescast, to demonstrate the conformance of product to the specified requirements.

3. Measurement standards used for calibration shall be traceable and have the accuracy, stability, range and resolution required for the intended use.

**K. NON CONFORMING MATERIAL / CORRECTIVE ACTION**

1. The Supplier shall have a documented system that addresses the control of non-conforming material, including provisions for:

a. Prompt identification, segregation, documentation and disposition of non-conforming material. Identification shall be in a manner to prevent unauthorized use, shipment, or combination with conforming material.

b. Identification of cause and consideration of corrective action on non-conforming material.

2. In those instances where it is indicated that non-conforming material may have been shipped, the system shall provide Bescast with prompt notification.

**L. RECORDS AND RETENTION** - Data shall be generated and used to provide objective evidence of conformance to established product and process requirements, and to assure the quality systems employed are effective and economical. All manufacturing and inspection data, collected as documentation for part acceptance, is to be retained by Bescast's suppliers for a minimum of ten (10) years. Records are to be documented in a manner in ink or other permanent marking that if altered, would be obvious that changes were made. Corrections to work instructions or documents shall be recorded, dated and signed in ink or other permanent marking method with the original data being legible and retrievable after the change. No erasures or "white-out" is allowed. All electronic records must be controlled, retained and retrievable per the same requirements identified for hard copy records. The storage media must be capable of maintaining the data integrity for the full retention period.

**M. HANDLING AND STORAGE** - The system shall provide for handling and storage of material and parts in a manner to protect product quality by preventing damage, loss, commingling deterioration, contamination, corrosion, degradation or substitution. Storage control shall be such that prevents unauthorized withdrawal of materials or parts.

**N. PRODUCT / MATERIAL / PROCESS CERTIFICATION –**

1. Bescast may require the submission of material or product certifications to ensure compliance with applicable standards and/or specification. In many cases these certifications are required by our customers and could be passed along with the final product. The requirements for these certificates will be identified on the Bescast Purchase Order. In the event of changes to the approved significant processes, notification to Bescast is required within 5 business days in writing.

2. As a minimum, where certifications are required in the Purchase Order the following items shall be listed on the Certification of Conformance (COC): Date, Part Number, Quantity, Specification(s), Serial numbers (where applicable), Lot traceability, Work Order Number (referenced in the "Used By" field on the P.O.)

3. ITAR/EAR: the PO and all flow-downs are subject to Export Control Law, meaning Export Administration Regulations EAR (CFR part 730-774) or International Traffic in Arms Regulations, ITAR (CFR 22 part 120-130).

**O. PREPARATION FOR SHIPMENT** - The Supplier shall assure that parts are completed to P.O. requirements and that the Seller shall not deliver any products to Buyer that contain any "counterfeit parts" or materials. Seller represents and warrants that only new and authentic materials are used in products sold to Bescast. Seller shall indemnify and hold harmless Buyer and its officers, directors and affiliate companies from any losses, damages, claims, costs and expenses from Seller's failure to provide non-counterfeit parts or materials. The Supplier shall maintain that all manufacturing and product acceptance requirements have been satisfied prior to shipment. The system shall ensure the material is packaged adequately to prevent damage to material or product shipped to Bescast.



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**P. FOREIGN OBJECT DEBRIS/DAMAGE (FOD)** – The Supplier shall maintain a FOD program that shall include the review of manufacturing processes to identify and eliminate foreign object entrapment areas and paths through which foreign objects can migrate. Supplier shall ensure work is accomplished in a manner preventing foreign objects/material in deliverable items. Supplier shall maintain work areas and positive control of tools, parts and materials in a manner sufficient to preclude the risk of FOD incidents.

**Q. AWARENESS (AS9100D 8.4.3m)** – Suppliers personnel performing work on Bescast product must be aware of their contribution to product/service conformity, product safety and the importance of ethical behavior.

**R. Calibration** - All calibration services must be ISO 17025 or equivalent certified. Outside sources for calibration must provide certifications that include the following:

1. Statement of uncertainty.
2. Statement of environmental conditions during the calibration.
3. Statement identifying the measurement standard used and its traceability to national or international measurement standards via a certificate or report number. (e.g. NIST number)
4. Statement of conformance to the requirements of ISO 10012 or ANSI Z540.3.
5. Instrument calibration “as found - as left” conditions