



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	1 of 7
Issuer	Yousef Younesi

Vendor Quality Requirements Manual

Nasco Aircraft Brake, Inc.
13300 Estrella Ave.
Gardena California 90248
Telephone No. 310-532-4430
Fax. No. 310-532-6014
www.Nascoaircraft.com



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	2 of 7
Issuer	Yousef Younesi

INTRODUCTION

Nasco Aircraft Brake, Inc. (herein referred to as Nasco) is responsible for assuring the quality of the products we deliver to our customers. The quality management system at Nasco is based on ISO9001:2008 and 14 CFR part 21, which requires that Nasco establish procedures for selecting and controlling of vendors who can consistently deliver conforming products.

This manual contains the contractual quality assurance requirements to which Nasco vendors should comply.



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	3 of 7
Issuer	Yousef Younesi

Nasco Aircraft Brake Inc.

Purchase Order

Quality Control Requirements

General Requirements

1- Sub-Tier Control

The vendor shall be responsible for flow down of all the requirements of the Nasco purchase order applicable to vendor's sub-contractors. The vendor is also required to have sub-tier control program in place for their sub-tiers.

2- Facility Access

During the performance of this purchase order, your quality control or inspection and manufacturing process are subject to review, verification and analysis by Nasco, Federal Aviation Administration, customer, and or customer representative. This requirement is applicable to the vendor's facilities where Nasco products and services are processed as well as vendor's sub-tiers.

3- Reworked / Replaced Material

When returning previously rejected material to Nasco, the vendor must reference the rejection report number on the shipping document, and must state if the items have been replaced or reworked.

4- First Production First Article

It is advisable that vendor submit a first article with a first article inspection report to Nasco for evaluation and approval prior to commencing production. First Article inspection report may be performed according to AS9102

Note: Vendor is not required to submit First Article unless purchase order specifically calls for it. First Article inspection report must include serial numbers (when applicable), all dimensions, general notes, tolerance ranges, actual measurements, material test reports.



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	4 of 7
Issuer	Yousef Younesi

5- Departure from Approved Design Data

Customers and FAA have approved the design data that are communicated to vendors, through purchase orders and prints. No departure from the approved design data is allowed.

6- Non-Conforming Material

Upon Notification from Nasco that material furnished by the vendor is found nonconforming upon receipt, the vendor will notify Nasco, in writing, of adequate and acceptable corrective action taken to eliminate the root cause of the nonconformity.

7- Vendor Notification to Nasco of Nonconforming Material / Product / Released

Vendor must report to Nasco if a material/product released from the Vendor, shipped against Nasco purchase order, and subsequently found nonconforming to the applicable design data.

8- Corrosion Protection

Vendor should use adequate corrosion procedure to protect the material supplied to Nasco.

9- Statement of Conformity

A statement of conformity must be supplied with each shipment. The statement of conformity must certify that all inspections and tests have been performed and results of these inspections and tests have determined conformance to the approved design data.

10- Certification Form and Content

Vendor must provide certification for every shipment made to Nasco. Certifications must be traceable to the material submitted and must contain the signature and title of the authorized representative of the vendor. Certifications must contain Nasco part number, approved design data, Nasco specification number, blend number, and furnace run number, if applicable.



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	5 of 7
Issuer	Yousef Younesi

11- Record Retention

The vendor must maintain adequate records of all First Article, In Process, Receiving Inspection, Final Inspection and Tests. The records must indicate the nature and number of observations made the number and type of nonconformity found, the quantities approved and rejected, and the nature of corrective action taken, as appropriate. The first Article Inspection reports must include all drawing dimensions, general notes, and tolerance range along with actual measurement results.

The vendor must retain this information and all supporting documentation such as raw material certifications, special processing records and certifications, manufacturing records, operation / routing sheets / travelers.

These records must be maintained and available to Nasco, Nasco's customers, FAA, on request for period of not less than (10) years from the closing of the closing of the purchase order.

12- Drawings Specifications and Quality requirements

The vendor quality management system must assure that the latest applicable drawings, specifications, and quality requirements are compatible with current purchase order. Military standards and specification utilized must be to the latest revision in effect on the date of the purchase order. Unless otherwise specified.

13- Marking, Packaging and Handling

The vendor must assure that all parts and material supplied to Nasco are packaged in a manner and with material necessary to prevent deterioration, corrosion or damage. The baskets, boxes, containers, packages must be identified with all the information contained in the purchase order and vendor packing slip or shipper for traceability

14- Inspection Sampling

Unless otherwise specified in the purchase order, the vendor may use sampling procedures when tests are destructive or when quality history, inherent characteristics or operation repeatability due to numerically controlled machine justify less than 100% inspection. Sampling plan must be according to ANSI/ASQ Z1.4-2008 or later, with all sample plans must be modified to Zero based acceptance :Accept=0 reject=1

Exceptions:

- 1- NDT sample size must be 100%
- 2- Heat Treatment Hardening sample size must be at least equal to Level 2 AQL 1.0 accept=0 reject=1.



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	6 of 7
Issuer	Yousef Younesi

15- Process Capability

The vendor must assure that processes used to manufacture and produce parts and material supplied to Nasco are inherently capable to continuously and consistently produce conforming material and parts. These processes should be in state of “**statistical control**”.

16- Software Control

The vendor should implement appropriate control on software used in manufacture of deliverable article or product.

The software include: Computer-Aided-Manufacturing CAM, Computer-Aided-Inspection CAI, or Computer Aided Testing CAT.

17- Vendor Inspection Report

The vendor shall provide with each shipment a detailed inspection report. Acceptability of each characteristic (including drawing notes) shall be indicated, including acceptability and action taken in connection with an identified non-conformance.

18- Metallurgical Inspection/Test

The vendor shall furnish evidence that all material qualification tests and inspection have been performed and results meet the applicable material specification and drawing.

19- Facility or Organization Changes

The vendor is required to notify Nasco in writing when there are significant facility or organization changes such as company name, location, or senior quality management.

Special Requirements

The special quality requirements contained in Nasco’s purchase orders shall be in addition to the general quality requirements.



QCP	32
Date Released	05/07/10
Revision Level	D
Last Review Date	03/14/16
Page	7 of 7
Issuer	Yousef Younesi

LIST OF REVISIONS		
REVISION LETTER	DATE AND APPROVED BY	DESCRIPTION OF CHANGES
A	05/27/2010 YOUSEF YOUNESI	Initial release at Revision A
B	10/13/2011 YOUSEF YOUNESI	1.0 was added to Paragraph 14.
C	03/18/2014 YOUSEF YOUNESI	Paragraph 17 and 18 were added.
D	03/14/2016 YOUSEF YOUNESI	1- Paragraph 1 amended. 2- paragraph 19 added.