



<b>QCP</b>	<b>32</b>
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# Vendor Quality Requirements Manual

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## **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 ISO9001:2015 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.



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## **Nasco Aircraft Brake Inc.**

### **Purchase Order**

## **Quality Control Requirements**

### **General Requirements**

#### **1- Sub-Tier Control**

The vendor will 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 should reference the rejection report number on the shipping document, and should 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 Rev. 16/04/2015.

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



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## **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 should 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 should 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 should be supplied with each shipment. The statement of conformity should 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 should provide certification for every shipment made to Nasco. Certifications should be traceable to the material submitted and should contain the signature and title of the authorized representative of the vendor. Certifications should contain Nasco part number, approved design data, Nasco specification number, blend number, and furnace run number, if applicable.



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## 11- Record Retention

The vendor should maintain adequate records of all First Article, In Process, Receiving Inspection, Final Inspection and Tests. The records should 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 should include all drawing dimensions, general notes, and tolerance range along with actual measurement results. The vendor should 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 should 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 should assure that the latest applicable drawings, specifications, and quality requirements are compatible with current purchase order. Military standards and specification utilized should be to the latest revision in effect on the date of the purchase order. Unless otherwise specified.

## 13- Marking, Packaging and Handling

The vendor should 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 should 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 should be according to ANSI/ASQ Z1.4-2008 or later, with all sample plans should be modified to Zero based acceptance :Accept=0 reject=1

Exceptions:

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



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## **15- Process Capability**

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

## **18- Metallurgical Inspection/Test**

The vendor should 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.

## **20- Partial Shipments**

Unless otherwise specified in the purchase orders, partial shipments are allowed.



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## **21- Counterfeit Material and Parts Prevention**

The vendor should be familiar with counterfeit material and parts prevention program to ensure that material and or parts supplied to Nasco are not counterfeit.

### **Special Requirements**

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



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**LIST OF REVISIONS**

<b>REVISION LETTER</b>	<b>DATE AND APPROVED BY</b>	<b>DESCRIPTION OF CHANGES</b>
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.
E	11/21/17 YOUSEF YOUNESI	ISO 9001:2008 was replaced with 9001:2015
F	02/12/18 YOUSEF YOUNESI	Rev. 16/04/2015 was added to AS9102. Paragraph 20 was added.
G	03/13/19 YOUSEF YOUNESI	Paragraph 21 was added.
H	02/05/2020 YOUSEF YOUNESI	Inspection report charges was added and paragraphs were renumbered.
I	02/07/2020 YOUSEF YOUNESI	Vendor may charge for inspection was deleted. The procedure was reworded.