



CONSOLIDATED INDUSTRIES, INC

677 Mixville Rd, Cheshire, CT 06410

T (203) 272-5371, F: (203) 272-5672

WWW.Forgemetal.com

Supplier Quality Assurance Requirements (SQAR's)

Rev. Original

When any of the following SQAR codes appear on a Purchase Order, the supplier must comply with the requirement. If the supplier has questions or concerns about the requirement, they are to contact the Buyer prior to performing any work.

001 Right of Entry: During Contract performance, the Supplier shall grant reasonable access to Supplier's facilities to representatives of Consolidated Industries, Consolidated Industries customers, US government and/or regulatory agencies for the purpose of evaluating Suppliers conformance to all Contract requirements. When applicable, the access requirement shall be flowed down by Supplier to Suppliers' sub-tier sources.

002 Customer Source Inspection at Supplier

Consolidated Industry's customer representative shall be granted the right to verify at the subcontractors premises that subcontracted product and/or processes conform to specified requirements. Such verification will not be used by the supplier as evidence of effective control of quality. Verification by the customer does not absolve the supplier's responsibility to provide acceptable product nor will it preclude subsequent rejection by the customer. Contact Consolidated Industry's customer (minimum of 10 days prior to scheduled completion, for scheduling purposes). Release of product prior to source inspection is not allowed unless you are otherwise notified by Consolidated Industry and /or the customer scheduled to perform inspection.

003 Consolidated Industry Source Inspection at Supplier

Consolidated Industry's representative shall be granted the right to verify at the subcontractor's premises that subcontracted product and/or processes conform to specified requirements. Such verification will not be used by the supplier as evidence of effective control of quality. Verification by the customer does not absolve the supplier's responsibility to provide acceptable product nor will it preclude subsequent rejection by the customer. Contact Consolidated Industry (minimum of 10 days prior to scheduled completion, for scheduling purposes). Release of product prior to source inspection is not allowed unless you are otherwise notified by Consolidated Industry and /or the customer scheduled to perform inspection.

004 Quality Inspection System: MIL-I-45208 (or Higher)

Quality System: you must have a documented quality inspection system and agree to on-site assessments. You are required to have a quality inspection system in place that meets MIL-I-45208 requirements or higher.

005 Quality System AS9100

Compliance with AS9100 Quality System is required for this Purchase Order.

006 Raw Material Distributor

Certified Test Report – Chem/Mech Prop: Submit material test report with each shipment. Include actual results of all chemical analyses, mechanical property tests, and mechanical testing and any other information required by the applicable specification for each heat or lot of material. Limit certifications for chemical properties are acceptable for aluminum only. You must submit test reports from the original producer of the material.

Certifications must specify the country of origin of the material and any country where re-melting occurred. A chain of custody (traceability) of material from the original mill, to each time the material was sold, up to delivery to Consolidated Industries must be maintained and this information is to be included with shipment to Consolidated Industries. If the material is to be in accordance with a CONSOLIDATED INDUSTRY'S customer controlled specification, the acceptance criteria contained in that document shall apply



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007 Preference for Domestic Specialty Metals (DFARS 252.225-7014 ALTERNATE I):

Preference for domestic specialty metals applies to this order in accordance with DFARS 252.225-7014 and Qualifying Countries (DFARS 225.872-1). To view DFARS see website at: <http://farsite.hill.af.mil/>

008 Certificate of Compliance

The supplier shall submit with each shipment, a Certificate of Compliance, stating that products shipped against this Purchase Order are in compliance with all requirements and referenced specifications. The Certification shall include Purchase Order number, part number (including revision level) and must be signed by an authorized Quality Representative (including title). When the supplier is not the Manufacturer, the Manufacturer's Certificate of Compliance is required.

009 Re-Submission of Product

Reworked product being re-submitted for acceptance shall reference the Quality Action Request (QAR) number on the new Certificate of Compliance. If re-work involved replacement of materials, or any re-processing, appropriate new certifications are required.

010 Supplier Deviations / Waivers (SD/WR)

Delegation of Material Review Board authority by Consolidated Industry to its subcontractors is NOT PERMITTED. Requests for deviations/ waivers must be submitted for approval, to CONSOLIDATED INDUSTRY'S Buyer. When Engineering, Quality, and Purchasing have approved an SD/WR, the supplier shall enclose a copy of the approved request with each shipment of the affected product. If the quantity being shipped exceeds the quantity accepted on the Waiver, the affected parts must be tagged and segregated from the rest of the parts.

011 Standard Marking

Shall consist of Purchase Order Number, Part Number, Revision, and Quantity, legibly marked on the outer shipping label on all packages. Additional marking may be required by Consolidated Industry's customer flow-down. If required marking is not clear, contact the buyer for clarification.

012 Material Safety Data Sheets

Seller/Supplier shall supply, with the material ordered, the most recent copy of the Material Safety Data Sheet (MSDS) as published by the original material manufacturer. Legible copies of the MSDS must be attached to the material and sent separately to:

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Attn: Facilities /Safety Manager.

013 Shipment and Packaging Requirements:

You must comply with all requirements for shipping, packaging and labeling. In the absence of specific requirements, suitable protection from corrosion, contamination and handling damage during transit is required..

014 Raw Material Certification

The supplier shall submit a Certificate of Conformance from the producing mill, showing the ACTUAL Chemical and Physical properties. The Manufacturers Quality Representative must sign all certificates. When the supplier cannot provide a copy of the original Chemical and Physical test reports, a report from an accredited Independent Laboratory, within the USA, showing the ACTUAL Chemical and Physical data is required. If the material is to be in accordance with a CONSOLIDATED INDUSTRY'S customer controlled specification, the acceptance criteria contained in that document shall apply

Note: Material produced outside the USA or Canada will not be used or provided as raw material unless specifically authorized by the Buyer and Supplier Quality. If the supplier wants to use or provide foreign material, they must contact the buyer with the material type and country of origin. Written approval is required and a copy



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of the approval must be provided with each shipment containing that material. This approval must be obtained on each Purchase Order.

015 Classified Part(s)

This purchase order is for an product that contains "primary", "critical", or "flight safety" part requirements. The complete manufacture of this part or a manufacturing operation involving a significant or critical characteristic can only be performed by (or subcontracted to) an approved Primary, Critical or Flight Safety approved supplier. Suppliers must also be approved by CONSOLIDATED INDUSTRY'S Customers and personnel performing final acceptance inspections may be individually approved to do so by Consolidated Industry's customer.

Note: Codes 001-Customer Source Inspection at Supplier, 002 - Consolidated Industry Source Inspection at Supplier, and 021 – 100% inspection may also be invoked.

016 Conflicting Technical Requirements:

In the event of conflicting technical requirements, the order of priority you should follow is the purchase order, the drawing, then the specification. You must bring all conflicting requirements to the attention of your Buyer as soon as possible.

017 Special Process Certification

The supplier shall provide certification of all special processes performed. The supplier shall use ONLY current CONSOLIDATED INDUSTRY'S approved special process suppliers. In some cases, process suppliers must also be approved by CONSOLIDATED INDUSTRY'S Customers (see Code 17a).

NOTE: If seller wants to use a process supplier that is not currently CONSOLIDATED INDUSTRY'S approved, they may request such approval. Requests for approval of additional sub-tier processors must be made to the Buyer PRIOR to use of that processor. No product may be sent to the processor until approval is granted. This includes the use of CONSOLIDATED INDUSTRY'S customer approved processors, who do not appear on the CONSOLIDATED INDUSTRY'S Approved Supplier List.

017A Customer Approved Processors

When this code appears on the Purchase Order, use of current Consolidated Industry's customer approved suppliers is required. The name of the Consolidated Industry's customer will be identified on the face of the Purchase Order (i.e. Boeing, Lockheed, Sikorsky, etc).

NOTE:

1. When use of Consolidated Industry's customer approved suppliers is required, the Supplier must be Consolidated Industry approved as well.
2. If you are unable to determine whom the appropriate customer approved suppliers are, contact your Consolidated Industry's Buyer for assistance.

018 Use of Sub-Tier Suppliers

All certifications provided to the Consolidated Industry's supplier from their sub-tier suppliers must flowdown the Consolidated Industry's Purchase Order number to ensure complete traceability. Where the use of sub-tier suppliers is permitted, the Consolidated Industry's supplier shall flowdown all Consolidated Industry's Purchase Order requirements on their sub-tier suppliers.

019 First Article Inspection

The supplier shall perform a complete 1st Article Inspection to the requirements of AS9102, latest revision. The 1st Article Report shall include 100% inspection of one part, and a record of all dimensional (actual), including all drawing notes and part specific Purchase Order requirements. The First Article part shall be clearly identified by a suitable method such as tagging and submitted with the First Article Report.



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020 Submit Supplier Inspection Checklist

You must provide inspection results with each shipment. For each characteristic inspected, provide the characteristic, the quantity inspected, and quantity accepted/rejected. Report actual results if required by Consolidated Industries' drawing or purchase order.

021 100% Inspection Required

The Supplier shall perform 100% inspection of all characteristics on all products delivered on this Contract. The Supplier's 100% inspection data shall show the part number and drawing revision and the actual values obtained during inspection versus the requirements of the drawing (including block data and notes) or specification. When applicable, copies of material and/or process certifications shall be attached to the inspection report.

022 Magnetic Particle Inspection

Non-Destructive Test requirements for Magnetic Particle Inspection as called out on the drawing or Purchase Order is required. The acceptance criteria will be to ASTM E-1444. Acceptance Magnetic Particle inspection must be performed by a Level II, or III that has been qualified and certified to the requirements of NAS 410 .

NOTE: If the process is to be performed to a CONSOLIDATED INDUSTRY'S customer controlled specification, the acceptance criteria contained in that document shall apply.

023 Penetrant Inspection

Non-Destructive Test requirements for Penetrant Inspection as called out on the drawing or Purchase Order is required. The acceptance criteria will be to ASTM E1417. Acceptance Penetrant inspection must be performed by a Level II, or III that has been qualified and certified to the requirements of NAS 410 .

NOTE: If the process is to be performed to a Consolidated Industry's customer controlled specification, the acceptance criteria contained in that document shall apply.

025 Calibration Services

In addition to the purchase order requirements, Certification of Calibration, traceable to NIST, with reference to appropriate specification (ANSI-Z-540-1, ISO-10012-1, etc.) is required.

026 Significant Changes to Your Process

You must notify Consolidated Industries of any intended significant changes to your process, methods, material, or product and obtain our approval prior to implementation. You must also make this a condition to your entire supply chain. Samples and documentation may be required as determined by Consolidated Industries as part of the approval process.

027 Product Serialization Requirements

Serial numbers for all products on this Contract have been assigned by Consolidated Industries and are defined in the Contract or reference documents. The Supplier shall apply the specified serial numbers on all products and record the serial numbers on all applicable documentation. The assigned serial numbers may not be altered or replaced without written authorization from Consolidated Industries.

028 Manufacturing Quality Instruction

The Supplier shall comply with the special engineering, manufacturing and/or quality instructions and requirements that apply to the products ordered on this Contract. Such requirements may be described in document(s) such as Engineering Work Instruction, Quality Assurance Requirements , Quality Work Instruction, Manufacturing Work Instruction, Heat Treat Work Instruction or other designation referenced on the Contract.