



W-8-7 SUPPLIER QUALITY CONTROL REQUIREMENTS

Rev. E

Date: 1/26/23

Approved by: Cindy Cerrigione

Scope:

This procedure defines the general quality control requirements applicable to Sterling Engineering Corporation's suppliers of purchased materials, components, and outside services incorporated into the products sold to Sterling Engineering Corporation's customers. It does not pertain to non-product related purchases for office supplies, tooling inserts, cutters, etc.

General:

When referenced on the Sterling Engineering purchase order, this procedure sets forth the general quality control requirements applicable to Sterling Engineering Corporation's suppliers as defined in the scope statement above.

Supplier Quality Control Requirements:

1. Supplier Quality Control

- a. The supplier shall assign one of their personnel to be familiar with the requirements of this document and ensure compliance.
- b. If the requirements of the purchase order cannot be met, the supplier is to contact the Sterling Engineering Purchasing Department before beginning work.
- c. The supplier is required to have an implemented quality management system.
- d. The supplier shall demonstrate competence, including any required qualification of persons.

2. Operation and Specification Control

- a. The supplier shall ensure that personnel work to the purchase order instructions, including operation sheets as applicable and required specifications.
- b. The supplier shall notify Sterling of changes in the QMS or business operations, including changes to their external providers or location of manufacture, and obtain Sterling's approval.



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- c. The supplier shall establish and maintain an effective FOD prevention program that meets the requirements of AS 9146.

3. Material Control

The supplier shall:

- a. Inspect material upon receipt for shipping damage, correct material, and quality.
- b. Inspect material periodically and take precautions to assure adequate storage conditions, guarding against damage from handling and deterioration.
- c. Identify and protect material from improper use or disposition.
- d. Maintain all marking and identification of parts supplied, including all software.
- e. Material and special process test reports/certifications must reflect all requirements of the drawing and/or specification and conform to drawing and/or specification limits. Documented evidence of this conformity, including listing of each material element or test result, must be documented in the applicable test report. This test report must be signed by a cognizant test laboratory person, clearly confirming which of the following is correct:
 - All tests and inspections have been performed and results meet the drawing and/or specification requirements, or
 - All tests and inspections have been performed and the results meet all the drawing and/or specification requirements,
 - except _____, which does not meet requirements, or
 - All tests and inspections have been performed and the results meet all drawing and/or specification requirements,
 - except test(s) _____, which was not performed in accordance with the drawing and/or specification requirements.
- f. The supplier shall not use any repair procedure such as welding, heat treatment, or conditioning by any process not approved by Sterling Engineering in writing or directed by purchase order instructions.
- g. Sterling Engineering maintains design and development control.
- h. Supplier shall complete all special requirements, critical items, and key characteristics communicated on the PO.



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- i. Supplier shall provide test, inspection, and verification (including production process verification).
- j. Supplier shall only use customer-designated or approved external providers, including process sources.
- k. The supplier shall provide test specimens for design approval, inspection/verification, investigation, or auditing.
- l. The supplier shall plan, implement, and control counterfeit part prevention processes in accordance with AS6174 or AS5553, as applicable. The supplier shall ensure that the counterfeit part prevention process includes a mechanism for reporting counterfeit parts to SEC's purchasing representative within 3 working days of it being confirmed.

4. Inspection

- a. The supplier shall maintain a positive system for the identification of inspection status of supplied material.
- b. Identified critical/key characteristics must be inspected 100% and variable data recorded if possible.
- c. The supplier shall use statistical techniques for product acceptance and related instructions for acceptance.

5. Sub-Contracted Work

- a. The supplier shall not subcontract any work without prior approval from Sterling Engineering.
- b. Applicable requirements in the purchasing documentation, including key characteristics where required, must be flowed down to the sub-tier suppliers.



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- c. If approval is granted, the supplier must use Sterling-approved subcontractors for special processes, and ensure all proper flow-down requirements to sub-tier suppliers.
 - d. The supplier shall control and monitor external providers' performance.

6. Calibration

- a. The supplier shall maintain a calibration system in accordance with Calibration Specification ANSI/NCSS Z540.3, Calibration Specification, ISO 17025, ISO 10012-1 or equivalent.

7. Nonconforming Material

- a. Sterling Engineering must be notified immediately of any nonconformance. Written reports must be initiated and forwarded to Sterling Engineering Quality Assurance Manager.
- b. Nonconforming material shall be segregated and properly identified at all times in the Supplier facility, pending disposition.

8. Marking

- a. When marking is removed by supplier processing, the marking shall be reapplied to the part using an approved Sterling Engineering method. The method shall not be detrimental to the part.

9. Right of Inspection

- a. Sterling Engineering, and/or our customer, and regulatory authorities have right of access to your facility and all applicable records (i.e., quality requirements, inspection reviews, certifications, etc.). If Sterling's customer contacts you directly to survey your facility, you must notify Sterling Engineering immediately. This will give Sterling Engineering an opportunity to accompany the customer at your facility.



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10. Records

- a. Records are to be retained on file by supplier for a period of at least ten years unless otherwise specified by end-user record retention requirements after completion of the order.

11. General

- a. The supplier is responsible for product conformity.
- b. The supplier must maintain product safety.
- c. The supplier must maintain a high level of ethical behavior.

12. OEM End Use – Requirements Flow Down

12.1 If Pratt & Whitney end use is specified on the purchase order, the latest version of ASQR-01, AS 13100, and AS9100 shall apply.

12.2 If GE Aviation end use is specified on the purchase order, the latest version of S-SPEC-1 (S-1000), AS 13100, and AS9100 shall apply.



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Revision History

REVISION	DATE	SECTION	PARAGRAPH	SUMMARY OF CHANGE	AUTHORIZED BY
B	04/16/21	N/A	N/A	Revision Block added	Sandra Rogers
C	1/21/22	N/A	12	Par. 12-12.2 added	Cindy Cerrigione
D	11/1/22	SCOPE	N/A	Scope heading added. Subsequent paragraph revised	Cindy Cerrigione
		General	N/A	Revised to clarify application of procedure	
		Calibration	6.a.	ISO 17025 added to this paragraph	
E	1/26/23	Operation and specification control	2b	Revised to clarify intent	Cindy Cerrigione
			2c	Paragraph added	
		Material and specification control	3e	Revised to clarify requirements for test reports	
			3l	Paragraph added	
		Nonconforming Material	7c	Deleted paragraph because requirement specified in par. 3.l	
		OEM Flow Down	12.1-12.2	Revised to flow down AS 13100	