



SUPPLIER QUALITY REQUIREMENTS

Revision: F

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UNCONTROLLED WHEN PRINTED

VSF-0042 Rev. F

Vulcan Steam Forging Company Inc. (hereinafter referred to as “Vulcan”) retains a quality management system (QMS) that is international third-party certified to AS9100:2016 Rev D, ISO9001:2015, and provisions of the Pressure Equipment Directive (PED) 2014/68/EU (Annex I, Paragraph 4.3). In order to do business as an approved supplier, Vulcan requires that your organization shall be in compliance with the QMS standards of ISO9001:2015 as well as the following applicable customer, statutory and regulatory requirements with immediate effect:

- A.) Vulcan purchase orders and any revision must be acknowledged upon receipt to confirm processes, products and services to be provided, including the identification of all relevant technical data.
 - If a purchase order is not acknowledged it shall be assumed that all terms are in agreement. Terms include non-standard terms contained within documentation such as prints, specifications, and any supplementary flow down documents which accompany a purchase order.
 - This information shall be handled in accordance with all applicable U.S. control laws and regulations, including, but not limited to, the Defense Federal Acquisition Regulation Supplement (DFARS) control requirements when required.
- B.) It shall be the responsibility of the supplier for the performance of all inspections and test requirements, to include methods in which they occur, as necessary to certify products and services conform to all purchase order requirements.
 - The supplier has no authority to furnish products or services that are not in full compliance with their corresponding purchase order.
- C.) All persons performing work affecting the compliance of any product or service corresponding with a Vulcan purchase order shall be competent and qualified based on established criteria regarding education, experience, skills and training.
 - The supplier organization is responsible for determining acceptable standards and monitoring all persons conformance to said standards without issue.
- D.) Vulcan shall provide a purchase order to all supplier organizations which may dictate processes, products and services to be provided with their applicable flow down requirements. Communication and collaboration efforts directly affecting performance of purchase order compliance must be documented and identified as objective evidence.
- E.) Vulcan will routinely monitor conformance to the requirements of its purchase order, including those related to product quality, scheduled delivery and required documentation.
 - Unsatisfactory performance may result in additional actions such as formal corrective action requests, cost recovery and/or suspension from Vulcan’s approved supplier list.
- F.) When a Defense Priorities & Allocation System (DPAS) rating and/or government source inspection (GSI) is defined on any given purchase order, it shall be the responsibility of the supplier to ensure all requirements are met, to include scheduling and on-site inspection.
- G.) All design and development control shall be at the sole discretion of Vulcan’s customer associated with a given purchase order. Vulcan does not perform any aspect of AS9100’s design and development of products and services.
- H.) Key characteristics of the product or service shall be identified on the purchase order by denoting the ♦ symbol and indicate an elevated level of importance for compliance. When key characteristics are denoted the supplier organization will be required to similarly identify them in all applicable documentation used to process Vulcan’s purchase order.

- I.) The supplier organization must comply and perform all applicable testing, inspections, and verifications (including production process verification) as required through Vulcan purchase order flow downs.
- J.) Statistical process control (SPC) techniques, when required, shall be used to monitor and accept key characteristics denoted in purchase order flow down requirements. Additionally, at a minimum, the following SPC requirements apply to key characteristics:
- X-bar and R charts to control variable data
 - np chart to control attribute data
 - Minimum process capability index (PCI) Ppk of 1.33 for all key characteristics for new product launches
- K.) Vulcan-approved suppliers shall comply with the following:
- Supplier organization shall have a developed, implemented and maintained QMS that is compliant with the standards of ISO9001:2015, or equivalent.
 - The use of external providers, including process sources, shall be customer-designated or approved in writing by a representative of Vulcan prior to use.
 - Vulcan must be notified within 48 hours of any known non-conforming processes, products or services affecting its purchase order requirements. The supplier organization shall obtain written approval of disposition of the non-conformance prior to continued processing or return shipment, as applicable.
 - The supplier shall plan, implement and control processes, appropriate to the organization and the product or service, for the prevention of counterfeit part use and their inclusion in products or services supplied to Vulcan. As such, the recording of false, fictitious or fraudulent statements or entries may be punished as a felony under federal statutes, including federal law.
 - Notification shall be made to Vulcan prior to executing any changes to the supplier's manufacturing processes, external providers and location of manufacture which may affect the ability of the product or service to meet purchase order requirements. Not all changes will require written approval from a representative of Vulcan, however, based on potential impact and/or risk of the proposed change the supplier organization may require approval from Vulcan prior to its execution.
 - All applicable supplier documentation/records must flow down product or service requirements (customer, statutory and regulatory), including key characteristics, internally and to external providers to maintain compliance with Vulcan's purchase order.
 - Test specimens shall be provided, when required, to Vulcan for customer-design approval, inspection/verification, investigation and disposition requirements.
 - Objective evidence pertaining to processes, products and services is required to be maintained on file for no less than 15 years, destroyed in such a way that prevents disclosure of contents or reconstruction of the document, unless otherwise specified in writing by a representative of Vulcan. These documents will be made available to Vulcan, its customer, and/or any regulatory agency associated with a given purchase order upon request.
- L.) Suppliers shall allow Vulcan, its customer, as well as any applicable regulatory authority the right of access to any applicable area and documentation, at any level of the supply chain, to determine and verify the quality of records, products, intellectual property and the confidentiality of unclassified information.
- M.) All suppliers shall ensure that personnel are aware of their contribution to the product and/or service conformity, product safety (including prevention of counterfeit parts), importance of ethical behavior, protection of information and cybersecurity.

SPECIAL ATTENTION

- Certificates of Conformance must specify the purchase order number, serial/part number (if applicable), represented quantity, conforming standard/specification and revision, as well as the signature from a responsible company official.
- Mercury-Free statement is required on all certificates and must state that products and services furnished in fulfillment of any given purchase order have not been in contact or exposed to mercury containing materials/devices in any form.
- Counterfeit Part/Malpractice statement is required on all certificates. Any falsification, concealment, or alteration of any material fact, or any false, fraudulent, or fictitious statement or representation in conjunction with the work under any purchase order is not only prohibited but may also be punishable as a felony under federal statutes, and federal law.
- When required, supplier organizations must follow U.S. Federal Acquisition Regulation's requirement that specialty metal must be melted in a qualifying country, per DFARS clauses 252.225-7008, 252.225-7009 and Alternate 1.
- Material designated as "Level 1" on a purchase order requires all associated documentation to be clearly identified as Level 1 and handled by the external provider as per Electric Boat specification EB2678 (revision on purchase order).
- External providers will adhere to the directions provided in the following Presidential Executive Orders:
 - EO 11246 (September 25, 1965), pertaining to equal employment opportunity and to adhere to federal, state and local labor laws.
 - EO 13224 (September 24, 2001), pertaining to terrorist financing, blocking property and prohibiting transactions with persons who commit, threaten to commit, or support terrorism.
 - EO 13496 (January 30, 2009), pertaining to employee rights under the National Labor Relations Act.
- To the extent there is a conflict between the within system requirements and any requirements set forth on the face of or in the attachments to a Vulcan purchase order, the requirements on the face of or in the attachments shall prevail.

Appendix A: Revision Record

REV. #	REV. EFF. DATE	PREPARED BY	APPROVED BY	REASON
A	5/26/2011	Sri Vilayanoor	Michael Duggan Sr.	<ul style="list-style-type: none"> ● New document
B	7/9/2012	Mary-Alice Attea	Michael Duggan Sr.	<ul style="list-style-type: none"> ● Added "All records related to Vulcan's contract will be retained by your organization for a minimum of 15 years, unless otherwise specified by Vulcan explicitly in a specific purchase order."
C	12/21/2014	Mary-Alice Attea	Michael Duggan Sr.	<ul style="list-style-type: none"> ● Added "Records shall be made available to purchaser within 30 hours of request." ● Added "Test reports/C of C's required. Certifications must include name, signature, and title of QC Manager or other authorized personnel."
D	3/21/2015	Mary-Alice Attea	Michael Duggan Sr.	<ul style="list-style-type: none"> ● Moved documentation/record requirements to #2. ● Added verbiage "and/or process" to #5. ● Added requirements for customer designated special process sources to #15.
E	3/14/2025	Thomas Gilray	Michael Duggan Sr.	<ul style="list-style-type: none"> ● Updated AS/ISO referencing to reflect current 3rd party certification.
F	8/28/2025	Thomas Gilray	Michael Duggan Sr.	<ul style="list-style-type: none"> ● Complete update to all sections/pages for AS9100, ISO9001, and PED compliance. ● Removed redundant or obsolete information.