

**VULCAN STEAM FORGING COMPANY, INC.**  
**REQUIREMENTS**

247 RANO STREET, BUFFALO, NY 14207

P: 716-875-3680; F: 716-875-3226; E: [SALES@VULCANSF.COM](mailto:SALES@VULCANSF.COM)

**SUPPLIER QUALITY MANAGEMENT SYSTEM**

Whereas Vulcan Steam Forging Co. is third-party certified to AS 9100:2016 Rev D QMS requirements, to be in compliance with these QMS Standards, we require your organization's compliance to the following with immediate effect:

- 1.) Your organization shall develop and maintain a quality management system that is, at the least, compliant with the requirements of ISO 9001:2015 Quality Management System requirements;
- 2.) All Vulcan purchase orders will be accompanied by, where applicable, product drawings, shop orders and vendor work instructions, hereinafter collectively called "product documents". These product documents will include, where applicable, revision levels of our customer drawings. You will be required to ensure that all this revision level is identified on all documents and records used by your organization to process the order.
- 3.) When required, Vulcan will identify certain product characteristics as critical by denoting the ♦ symbol on one or more product document. Such characteristics are considered Key Product Characteristics (KPC) and indicate an elevated level of importance for Vulcan and Vulcan's customer. When KPCs are identified, you will be required to identify them in all applicable documents and records used by your organization to process the order. Additionally, you will also use proper Statistical Process Control (SPC) techniques to monitor and control these KPCs. At a minimum, the following SPC requirements apply to KPCs:
  - a. X-Bar and R Charts to control variable data
  - b. np Charts to control attribute data
  - c. A minimum Process Capability Index Ppk of 1.33 for all KPCs for new product launches
- 4.) Nonconforming product:
  - a. When non-conforming product is manufactured, your organization will notify Vulcan of the nature of nonconformity. Vulcan will advise your organization of the disposition of the nonconforming product. Nonconforming product can be disposed of as any of the following:
    - i. Accept as-is for intended or alternate application with deviations approved by Vulcan
    - ii. Rework, re-inspect
    - iii. Scrap
  - b. All nonconforming product shall be properly identified so as to prevent its unintended use until disposition is finalized.
  - c. All nonconforming products that are disposed off as scrap shall be permanently marked physically (ex. notched, etc.) so as to make it unusable.

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5.) Your organization will notify Vulcan prior to executing any of the following changes to your product and/or process:

- a. manufacturing process changes
- b. changes in suppliers
- c. changes in manufacturing location

Not all changes will require approval from Vulcan to implement the change. However, based on the potential severity of the proposed change on the end product, your organization may require an approval from Vulcan prior to executing the proposed change.

- 6.) 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.
- 7.) Vulcan, Vulcan's customer, and any applicable regulatory body will have right of access to applicable areas of your organization, at any level of the supply chain, involved in the order and to all applicable records.
- 8.) Supplier shall comply with Executive Order 13496 (January 30, 2009), pertaining to employee rights under the National Labor Relations Act.
- 9.) Records shall be made available to the purchaser within 30 hours of request.
- 10.) Seller shall comply with all applicable provisions of Executive Agreement 11246 of September 24, 1965, as amended, the terms of which are incorporated herein by this reference and made a part thereof. It is the policy of Vulcan Steam Forging Co. to provide equal employment opportunity and to adhere to federal, state and local laws pertaining thereto. Appropriate action
- 11.) shall be taken by Seller, with respect to itself and any of its subcontractors, vendors, and suppliers to ensure compliance with such laws. All federal, state and local equal opportunity and affirmative action requirements with regard to race, gender, creed, color, age, religion, national origin, disability or veteran status, are incorporated herein by reference.
- 12.) Test reports/C of C's required. Certifications must include name, signature, and title of QC Manager or other authorized personnel.
- 13.) The recording of false, fictitious or fraudulent entries on documents may be punished as a felony under Federal Statute.
- 14.) To the extent there is a conflict between the within system requirements and the requirements set forth on the face of or in the attachments to this document, the requirements on the face of or in the attachments shall prevail.

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- 15.) At times, Vulcan customers designate specific requirements for special process sources. Vulcan will communicate this to you and you are then responsible to flow down these requirements to your suppliers.
- 16.) Personnel performing work affecting quality shall be competent and qualified based on established criteria regarding education, experience, skills, training. The Supplier is responsible for determining acceptable standards and for monitoring that they are being met.

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**Appendix A: Revision record**

	Revision date	Author	Approve	Reason for revision
A.	5/26/2011	Sri Vilayanoor	Mike Duggan	New Document
B.	7/9/2012	MA Attea	Mike Duggan	Added #6
C.	12/21/2014	MA Attea	Mike Duggan	Added #9 and #12
D.	3/21/2015	MA Attea	Mike Duggan	Moved #8 to #2; Added "and/or process" to #5; Added #15
E.	3/14/2025	Thomas Gilray	Mike Duggan	Updated AS/ISO referencing to reflect current 3 <sup>rd</sup> party certification