
	Quality Assurance Procedures				
	Quality Assurance Requirements from Subcontractors/Suppliers				
Page 1	Date:	02/06/2024	Rev:	02	Doc: 10741-5E

This specification is an integral part of the order and all the requirements listed hereby are obligatory unless it is required otherwise in writing by "Tirosh David Quality Castings Ltd." In any case of discrepancy between this document and the requirements derived from the drawing/customer specification - the drawing/customer specification guidelines will prevail.

1. General



This document specifies and defines the quality requirements of Tirosh David Castings Quality Ltd. (hereinafter "Tirosh Company") for manufacturers and subcontractors (hereinafter "the Company") that manufacture products, parts, materials, and services in accordance with the requirements and specifications of Tirosh Castings Quality Ltd

2. Applicable Documents

AS9100	Quality Management System for Requirements for Aviation, Space, and Defence Organizations
ISO9001	Quality Management System
AS6174	Counterfeit Materiel; Assuring Acquisition of Authentic and Conforming Materiel
AS5553	Counterfeit Electronic Parts; Avoidance, Detection, Mitigation, and Disposition
ISO17025	Requirements for the Competence of Testing and Calibration Laboratories
93.00.63	Customer requirement Raphel
OP301-D030-ESX	Customer requirement Elbit
OP301-D098-AERO	
NA	Eaton Supplier Code of Conduct

3. Quality System

3.1. The S/C will declare by the Vendor Certification that he is certified in accordance with the ISO 9001 or AS9100 latest version.

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 2	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

3.2. The S/C quality assurance system, quality assurance procedures, work instructions, testing equipment calibration and inspection reports will be available for Tirosh Company or for Tirosh Company customer inspection.

3.3. The supplier undertakes to comply with the requirements detailed in this document.

3.4. The supplier will ensure that its employees related to the order are aware of their contribution to product quality, product safety and the importance of ethical behavior.

3.5. The supplier will ensure that its employees do not receive gifts / bribes that may impair the employee's discretion, or that may result in an advantage in receiving orders / over a competing supplier.

3.6. The supplier will ensure that its employees related to the order will be suitable to perform the work and will be certified accordingly.

3.7. The supplier undertakes, if required in the order, to provide sample(s) for verification tests (such as coating quality, color stamp, etc.) by Tirosh David Castings Ltd.

4. Awareness

4.1. The S/C shall ensure that the employees who the work are aware of the following:

4.1.1. Employees' contribution to meeting product and service requirements.

4.1.2. Employees' contribution to product safety.



4.1.3. The Ethic Code.

5. Performance Monitoring

The S/C will ensure annual monitoring of the quality and scheduled delivery of the products supplied to Tirosh company.

6. Conflict Minerals

The S/C will report the use of conflict minerals, such as: tin, tantalum, tungsten, and gold in products supplied to Tirosh Company, and indicate whether they originate in the Democratic Republic of Congo or the surrounding countries (Angola, Burundi, the Central African

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 3	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

Republic, Rwanda, South Sudan, Uganda, and Zambia) in accordance with the CMRT report format.

7. Environmental Protection and Safety

- 7.1. The S/C will fulfill every legislation and regulation of the state and local authorities concerning environment protection and safety.
- 7.2. If the S/C has certifications in accordance with ISO 14001/ ISO 45001, the S/C will provide Tirosh Company with a valid copy of certification according to the latest version.



8. Confidentiality/ Working for third Party

- 8.1. The S/C hereby declares it will not provide any information, drawings, specifications, magnetic media, or any other data to an entity unapproved by Tirosh Company
- 8.2. In case work can be delegated (by approval) from the S/C that has received the order to the S/C of his choice, the S/C that has received the order is hereby obliged to convey Tirosh Company. company requirements, including requirements as listed in the order, alongside the current document.
- 8.3. In any case, the responsibility for quality and due performance lies with the S/C that has received the order from Tirosh company.
- 8.4. The S/C will refrain from engaging in any communication/ receiving instructions, requirements, specifications, or drawings regarding the work from any source, other than written orders from Tirosh Company.

9. Process Control

9.1. Audits and Source Inspection

Tirosh company / ordering customer's representative/ regulators are entitled to visit the S/C site, by prior arrangement, to perform quality system audits, including measuring equipment, relevant quality records, processes and manpower related to cooperation with Tirosh Company.

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 4	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

9.2. Source inspection/ inspection by Tirosh Company representative/ customer: reception Tirosh Company reserves the right to performed, by prior arrangement, Source inspection at the S/C site before the manufactured parts are supplied.

9.3. Source inspection will include but will not be limited to visual inspection, measurements with conventional and digital tools and gauges, such as CMM or similar.

9.4. Deviations / nonconformity if any will be performed during the Source inspection will oblige the S/C to perform 100% inspection and rework in accordance with all production batch.

9.5. The source inspection by Tirosh Company representative/ customer does not relieve the S/C from full responsibility for the quality performance of the entire shipment.

9.6. Measurement Tools Calibration



9.6.1. Calibration of the measuring tools used for testing and supplying of Tirosh company products shall be performed only in laboratories certified according to the ISO17025 standard.

9.6.2. Design and manufacture of specific gauges (non-conventional ones, such as thread gauges, Johnson levels, etc.) by the S/C will be accompanied by the gauge validation report and will be available for Tirosh Company examination on demand.

9.7. Foreign Object Damage (FOD) Prevention

9.7.1. The supplier will define and implement a prevention plan that will include a review of the development and production processes to identify and prevent the inclusion of foreign bodies and particles in the product. The supplier will ensure that the production is carried out in a way that prevents the entry of foreign bodies/particles into the supplied product. Upon delivery of the product, the supplier declares that the product is free of foreign bodies that may cause damage.

10. Quality Assurance Records

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 5	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

10.1. The S/C shall maintain all quality records storage for a period of at least 10 years, unless otherwise required by the order or end customer.

10.2. After the end of the period, written approval must be obtained from Tirosh David Castings Ltd before destroying the records.

10.3. FAI reports will be retained for 10 years after the last shipment of the relevant product. Quality records of serial products or critical items or SSI parts will be kept for 15 years, parts tracking information will be kept indefinitely.

11. Configuration Management

The S/C is hereby responsible for holding, managing, and auditing all applicable documents required for its work, whether sent by Tirosh Company or required by the drawings/ specifications such as standards, provided their version is the last revision.

12. Employee Certification

Manufacturing and QC personnel shall be performed by authorized and qualified personnel in accordance with applicable requirements and standards.

13. Frozen Process

13.1. The S/C will establish and manage the Frozen Process for every item manufactured for Tirosh Company. The S/C will notify in advance of any change in any of the processes that may influence the FFF (Form, Fit and Function). The process will be carried out only by Tirosh Company written approval.



13.2. In any case of FFF (Form, Fit and Function) alteration the S/C will perform the FA (First Article) test at his own expense. The required documentation will be submitted to Tirosh Company for approval.

14. Raw Materials used by the S/C which are not supplied Tirosh Company

14.1. Counterfeit materials

14.1.1. The S/C must comply with the applicable requirements of the AS6174 standard for the prevention of counterfeit components.

14.1.2. The S/C will only purchase items from the original manufacturer or an authorized distributor.

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 6	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

14.1.3. In case there is no option of purchasing from a licensed S/C or the original manufacturer, the S/C will contact Tirosh Company for written approval.

14.2. Raw Materials Control

14.2.1. The S/C must maintain a method that will ensure the traceability of the components and items supplied by the manufacturer.

14.2.2. The shipment must be accompanied by the Certificate of Compliance with the original order (COC/COT/COA) issued by the component manufacturer or authorized distributor.

14.2.3. For MS / NAS items the S/C must attach the original Certificate of Compliance (COC/COT/COA) issued by the manufacturer, to each shipment.

14.3. Aerospace Raw Materials

14.3.1. In case there is no requirement for valid material, the S/C will purchase raw materials from western sources only.

14.3.2. Materials received without validation (C.O.C) require approval by Tirosh Company and/or the customer.

14.3.3. It is recommended to make sure that no more than 5 years have passed since the date of production of the raw material.



14.4. Critical Materials

14.4.1. For materials defined as critical, the raw materials validation will be performed in a certified laboratory under the S/C responsibility.

14.5. Inserts (metallic & non-metallic)

14.5.1. Insert will be provided with a Certificate of Compliance (C.O.C) that meets the order requirements. The report will include the manufacturers and distributor details, production paperwork and the rigids batch number.

14.5.2. The Insert will be supplied from a single production batch and one manufacturer.

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 7	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

14.5.3. Insert must be purchased only from suppliers approved by the end customer
- for a list of approved suppliers, please contact Tirosh David Castings Ltd company.

14.6. Adhesives / Paints / Chemicals

14.6.1. The manufacture date, the recommended shelf life, and the required storage conditions (humidity temperature, etc.) of all items/ materials with a limited lifespan provided according to this order must be indicated on each individual package.

14.7. Expired Materials

14.7.1. Materials with a limited shelf life will be supplied to Tirosh Company provided their minimum shelf life will be 75% of the original.

15. Deviations/ Nonconformance

15.1. Nonconformance Product

15.1.1. The subcontractor will notify Tirosh Company within 48 hours of any nonconformance found in the products which may cause delivery delays.

15.1.2. The subcontractor may not repair or approve as is any products in which nonconformance has been discovered.



15.1.3. The subcontractor is required to obtain Tirosh Company written approval for any nonconformance found in product or process.

15.1.4. The request will be discussed by Tirosh company and approved if necessary.

15.2. Corrective and Preventive Actions

15.2.1. The subcontractor will initiate due investigation and take effective corrective and preventive measures, including root cause analysis for any case of inconsistency regarding the faults found in Tirosh Company products, whether the nonconformance was discovered by the subcontractor, Tirosh Company representative, or the customer.

15.2.2. The subcontractor will take the immediate action required to prevent nonconformance, including reporting to the client or other involved parties.

	Quality Assurance Procedures				
	Quality Assurance Requirements from Subcontractors/Suppliers				
Page 8	Date:	02/06/2024	Rev:	02	Doc: 10741-5E

15.2.3. The corrective action plan will be submitted for approval of the Tirosh company quality assurance within 10 business days.

16. Testing Reports, Verification and Documentation

16.1. FAI (First Article Inspection)

16.1.1. FAI (First Article Inspection) will be conducted for parts manufactured for the first time, or have passed 24 months since the last production, or if changes were made in design (Form Fit and Function).

16.1.2. The FAI process will be performed in accordance with AS9102 Rev. C (Aerospace First Article Inspection Requirement) standard.

16.1.3. The S/C is required to provide Tirosh Company with all FAI reports.

16.2. Serial Manufacturing

16.2.1. The S/C will provide a final COC report including the drawing dimensions, related to its parts.

16.2.2. Documents for delivery as required - COT/ COC/ COA.

16.2.3. The actual measurements obtained in the report must be recorded for each part tested. Range of results / result marked as OK measurement should are not acceptable, unless otherwise agreed.



16.2.4. The S/C will provide a complete list of part numbers indicated on the parts (S/N) with each delivery order, if required.

16.3. The S/C will apply the reports, and other applicable documents for the production batch to Tirosh Company before the Tirosh Company representative's arrival for source inspection or packaging.

17. Special Processes

17.1. Special processes such as coating and paint will provide a declaration of compliance with the RoHS requirements for each shipment.

17.2. The S/C will provide test coupons by requirement of the Tirosh Company.

	Quality Assurance Procedures				
	Quality Assurance Requirements from Subcontractors/Suppliers				
Page 9	Date:	02/06/2024	Rev:	02	Doc: 10741-5E

17.3. The test reports for special processes shall include the drawing requirements, specifications and applicable international standards, revision, as well as the test results and the type of measuring instruments used for the testing.

17.4. Special processes shall be validated in accordance with the applicable standards requirements. Validation confirmation will be stored by the subcontractor and presented to Tirosh Company on demand.

17.5. Test reports should be in English only.

18. Control Sampling Plan

18.1. Unless otherwise required by the order, drawing or relevant customer specification, the serial manufacture sampling plan be executed according to SQUGELIA, AQL 2.5% C = 0.

18.2. The S/C will perform a visual inspection of 100% of the parts supplied and report the results in a final report.

18.3. key characteristics, critical Items, or special requirements - the subcontractor will act in accordance with the drawing requirements/ specifications.

19. Human Rights



19.1. The supplier will employ workers of the permitted age according to the requirements of the law and will not employ workers under the age of 16.

19.2. The supplier undertakes to employ workers and give them full rights as required by law.

20. Parts Packaging and Transportation

20.1. It is the S/C responsibility to design, manufacture and carry out all the necessary means to prevent damage to the product at all stages of production, storage, and transportation.

20.2. Each part is required in separate packaging. The size of the carton / bag must be adjusted to the size of the part being packed; each item must be packed separately in bubble wrap + cardboard paper when there is a buffer with single/double

	Quality Assurance Procedures					
	Quality Assurance Requirements from Subcontractors/Suppliers					
Page 10	Date:	02/06/2024	Rev:	02	Doc:	10741-5E

- corrugated cardboard between the items to prevent blows during the transportation process - it is absolutely forbidden for parts to touch each other.
- 20.3. In painted items, the edges and the areas with sharp corners must be protected with cardboard / hard packing material that prevents contact between the parts. (wrapping in bubble wrap + using corrugated cardboard to separate the units)
 - 20.4. The parts will be packed in a way enabling quick and reliable part count verification.
 - 20.5. A sticker will be affixed to each package indicating the product details, company name and the exact quantity of parts in the package.
 - 20.6. Testing and quality assurance reports and delivery certificates shall be attached to every shipment.
 - 20.7. Before packaging the products or performing a process, the products will be inspected for the detection and prevention of foreign objects (FOD).
 - 20.8. In case packaging specifications have been defined by the final customer, the parts will be packed in accordance with the customer's specifications.