

Type : Quality	Procédure / Procedure No.: Q-023CLR
Titre / Title: Flow Down of Additional Requirements	Date de révision / Revised Date: Nov 7, 2019

The following apply for suppliers of Howmet Structure Systems, Laval Operations

CODE	REQUIREMENT
01	<p>General Quality Requirements for Supplier: When Code 01 is called out on PO, the following requirements apply:</p> <p>A. The supplier is responsible for meeting all requirements of specifications, drawings, and other purchase order instructions relating to the following:</p> <ul style="list-style-type: none"> • Requirements for approval of process / product. • Personnel qualifications. • When using sampling plan for inspection, the sampling plan shall meet all requirements of SAE AS 9138. However, sampling plan is not authorised for any critical characteristic defined per drawing. <p>B. Any chemical process supplier must be NADCAP certified for the appropriate scope of the process done.</p> <p>C. Supplier involved in manufacturing of:</p> <ul style="list-style-type: none"> • An aerospace component part shall perform a First Article Inspection (FAI) in accordance with the latest revision of AS 9102 and shall provide copy to RTI Claro (dba Howmet Aerospace) Quality Assurance for approval prior to certify (Certificate of Conformity required) and ship parts to RTI Claro. • A fixturing component named class 1 on PO shall provide an inspection report including 2D bubbled drawing for approval prior to certify product (C of C required) and ship parts to RTI Claro. • A fixturing component named class 2 on PO shall provide only a C of C with parts delivered to RTI Claro. <p>D. The supplier shall notify RTI Claro of change: In its organization that may affect the products supplied or the quality system processes. Such changes include but are not limited to: change of manufacturing process, change of address location, change in ownership, change of company name, change of quality manager, change in quality system registration, change of approved suppliers, etc. Written notification of changes shall be sent to RTI Claro procurement representative including the impact of applicable change. When required DFAI requirement will apply.</p> <p>E. In the event that during the PO review the supplier determines that the requirements of the PO cannot be met, the supplier must:</p> <ul style="list-style-type: none"> • Notify RTI of the situation, and • Prior to processing obtain, in writing, a revised PO or detail instructions. <p>F. The supplier shall allow right of access to RTI, its customers, and all appropriate regulatory or governmental authorities. They shall have the right to enter supplier's facility at reasonable times to inspect the facility, goods, materials, applicable records, and any property of Purchaser covered by this order.</p> <p>G. All requirements of a PO received by a supplier must be flowed down to any sub-tier supplier.</p>

See next page

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01	<p>H. The shipping documentation of any supplier shall contain the following:</p> <ul style="list-style-type: none"> • A signed or stamped and dated Certificate of Conformity (C of C) statement on the packing sheet certifying its Quality Assurance department has inspected the articles and they adhere to all contract requirements, applicable drawings, and/or specifications. • When applicable, refer to a non-conformance/rejection tag number on C of C. • When applicable, include the nonconforming tag with the articles shipped. <p>I. Unless otherwise specified, all documentation shall be maintained for a minimum of 30 (thirty) years by the supplier or sub-tier supplier. Supplier procedure shall include what production records, test records and test samples are kept, and where the records and test samples are stored for final retention.</p> <p>J. The supplier shall notify RTI of any nonconforming material. For any nonconforming product or process, supplier must obtain, in writing, approval to ship the nonconforming product to RTI Claro.</p> <p>K. If at any time the supplier detects a process violation, purchase order noncompliance, or part non-conformance, RTI Claro shall be informed as soon as practicable. Nonconforming material or parts shall be segregated and tagged as nonconforming. Tags shall indicate the nature of the non-conformance. Root cause and corrective action shall be determined and submitted within 10 working days of detection of the non-conformance unless otherwise agreed upon by RTI Quality Assurance. Non-conformance shall be submitted to RTI Quality Assurance on form: "Form_Q-108.1D-CLR" for disposition prior to release for shipment at ArconicLavalMachiningNCR@Arconic.com</p> <p>L. The supplier is required to establish and maintain a FOD prevention program in compliance with AS 9146.</p> <p>M. If DPD/MBD (Model Base Definition) is called out by purchase order or referring document, the supplier must be DPD/MBD approved by RTI Claro or have 2D drawing review and approved by RTI Claro.</p> <p>N. Supplier purchasing raw material, for Boeing D6-82479 or Bell Helicopter (SQRM-001) program shall periodically validate test reports for raw material accepted based on test reports. That validation test shall be accomplished by the supplier, the sub-tier supplier or an independent party through periodic, scheduled tests of raw material samples. Schedules for frequency of tests will be established by supplier based on historical performance of the raw material supplier.</p> <p>When supplier utilizes test reports to accept raw material purchased from sub-tier, the following requirements apply. The supplier shall:</p> <ul style="list-style-type: none"> • Review/verify test reports at 100% against applicable requirements of material specifications, • Perform validation test periodically, • Record results of test reports and of validation test results as quality record.
See next page	


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01	<p>O. Metallic wrought materials such as Plate, Bar, & Tubing that are (procured under Industry, Military, or Federal specifications) used in the manufacture of BELL Helicopter designed Primary, Critical, Flight Safety, or Critical Safety Items (CSI) parts shall be procured from sources approved Bell helicopter per document # 299-100-837.</p> <p>Metallic material (Aluminum, Titanium, etc.) bought for a BELL Helicopter parts shall be melted in the United States or in Country qualified per DFAR clause '225.872-1'. Refer to clause 39 of Bell Helicopter contract and the following link.</p> <p>Note: The supplier shall insert the substance of this clause in all applicable subcontracts. Refer to: http://www.acq.osd.mil/dpap/dars/dfars/html/current/225_8.htm#BM225_8.</p> <p>P. SOURCE OF SUPPLY FOR BOMBARDIER PROGRAM:</p> <p>Bombardier Quality requirements for Suppliers as per QD 4.6-40 apply for all parts manufactured, and Raw materials shall be purchased only from manufacturers listed in the Bombardier Approved Supplier Listing on the Internet and must comply with the requirements of the BAEMM-001. Raw material manufacturers are subject to further control under BAEMM-001 or other engineering documentation.</p> <p>Q. SUPPLIER APPROVED TO PROCESS BOEING PARTS:</p> <p>Refer to Boeing web site and D1-4426 Approved Sources requirements. In accordance with Federal Regulations and other customer requirements, D1-4426 approval is required for those processes and raw materials listed.</p> <p>R. SHOT PEENING</p> <p>When shot peening operation is required on purchase order parts shall be cleaned after shot peening by supplier unless otherwise noted on RTI Claro purchase order / condition of supply. The cleaning operations must be performed per shot peening specification specified on purchase order / drawing. If cleaning operation cannot be performed, supplier shall advise RTI Claro purchasing agent.</p> <p>S. PREVENTION OF COUNTERFEIT PARTS</p> <p>Supplier shall mitigate the risks associated with any counterfeit material. The supplier shall plan, implement and control the product for prevention of counterfeit or suspect counterfeit part used and any possible inclusion in product(s) to be delivered and certified to RTI Claro per AS9100 requirements.</p> <p>T. Supplier shall comply with AS/EN/JISQ 9100 requirements and with X31764 document for Boeing product regarding the using of the Acceptance Authority media (Stamp Control Process). The supplier's Quality system shall establish and document the controls for the stamps or electronic passwords (if used).</p> <p>U. For Boeing product, supplier shall ensure compliance with X38656 document and to AS 9145 requirements for <i>Advance Product Quality Planning (APQP)</i> and <i>Production Part Approval Process (PPAP)</i>. Seller shall flow-</p>
See next page	

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See next page	

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	<p>Y. IDENTIFICATION</p> <p>Unless otherwise specified (MEPS, COS, etc.) the identification of a finished (turnkey) part should be done using the following method:</p> <ul style="list-style-type: none"> • Parts must be identified, by supplier, using drawing referenced in RTI Claro purchase order. • The batch number identification will consist of <u>maximum 10 digits</u>. • The batch number identification must be unique to each batch of a particular part number. • The first 5 digits of the batch number are the last 5 digits of the Vendor No. This number is located on the purchase order (See in red below). • The last 5 digits of the batch number identification are an alpha or numeric combination of supplier choice. <p>Should you need information regarding the batch number please contact the purchasing agent issuing the order.</p> <p>See below 2 examples of acceptable batch number identification:</p> <p>Ex. 1: 17881AB251 or ex. 2: 1788140251 Vendor No. Supplier choice Vendor No. Supplier choice</p> <div style="border: 1px solid black; padding: 10px; margin-top: 20px;"> <p>A subsidiary of Arconic Arconic Titanium & Engineered Products Laval, Machining & Integrated Structures Operations 5515 Ernest Cormier Laval, QC H7C 2S9 Page 1 of 4</p> <p>STROCO MANUFACTURING INC. 628 LAMBERT POINTE DRIVE HAZELWOOD MO 63042 USA</p> <div style="border: 1px solid gray; padding: 5px; margin: 10px 0;"> <p style="text-align: center;">Purchase Order</p> <p>PO Number: 9000016054 Date 26.01.2017</p> <p>Contact Person: Alberto Stagnaro</p> <p>Telephone: 450-786-2001 Fax: 450-661-6844</p> <p>Email: Alberto.Stagnaro@Arconic.com</p> <p>Our VAT Registration No. GST/TPS: 100992783</p> </div> <p>Your Vendor No. with us: 117881 </p> <p>Your Person Responsible Jenna Dailey</p> <p>Please deliver to: RTI Claro 5515 Ernest Cormier LAVAL QC H7C 2S9</p> <p>Please bill to: 5515 Ernest Cormier Laval, QC H7C2S9 Attn: Accounts Payable</p> </div>

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02	<u>100% Dimensional Inspection</u> : When Code 02 is called out on PO, a 100% dimensional inspection is required. => No sampling plan allowed.
03	<u>Source Inspection</u> : When Code 03 is called out on PO, the following requirements apply: RTI Claro source inspection is required on this purchase order. Contact RTI Claro five (5) working days prior to performing services as required by the purchase order to arrange the source inspection/witness.