

The following Quality Clauses apply to all purchase orders issued by Rolled Alloy-Canada, Inc (RAC). Suppliers are expected to familiarize themselves with the clauses herein and ensure full compliance with all aspects of their deliverables.

Any exceptions to/or conflicts with the requirements outlined in this document must be communicated in writing and approved by RAC prior to the fulfillment of the purchase order.

Failure to meet the requirements set forth in this document may result in order rejection, corrective action requests, or other measures deemed necessary to protect the integrity of our operations and customer commitments.

1. SUPPLIER RESPONSIBILITY

Suppliers shall satisfy all requirements of the purchase order including, PO notes, specification requirements, quality requirements, marking requirements, deliverable documentation requirements such as Material Test Reports (MTRs), Certificate of Conformances (C of Cs) and Packing Lists (PLs).

Suppliers shall review, inspect, and confirm compliance with all requirements of the PO prior to shipping.

2. CHANGES

As applicable, suppliers shall not make any changes in materials, components, manufacturing process, or methods used in production of the goods covered by this order without written consent of buyer.

Changes shall not adversely affect materials and/or services, requirements, or documents.

3. ETHICAL BEHAVIOR

Suppliers shall ensure personnel are aware of the importance of ethical behavior, their contribution to product conformity, and their contribution to product safety

4. ACCEPTANCE AUTHORITY MEDIA

Suppliers shall ensure the means are defined to document the status of outputs with respect but not limited to conformity, configuration, monitoring, measurement requirements and identification throughout processing, as necessary.

5. PREVENTION OF COUNTERFEIT PARTS

Material and documentation shall be controlled to prevent the delivery of counterfeit, suspect counterfeit, and unapproved parts use and their inclusions in product(s). Supplier shall provide written notification within 48 hours to RAC if the supplier becomes aware or suspects that it has furnished counterfeit or unapproved material to RAC.

6. COMPLIANCE

Suppliers shall comply with the latest revision of Regulatory Compliance requirements as applicable. Specifically, Conflict Minerals, REACH, RoHS, Proposition 65.

7. CALIBRATION

Gages or other measuring equipment used to ensure compliance shall be traceable to NIST or an alternate national standard. A program shall be implemented to ensure measuring equipment is calibrated on a regular basis and that documentation is maintained verifying the calibrations.

8. RAW MATERIAL SPECIFICATIONS

The current revision of any specifications, drawings, or other documents is applicable unless otherwise specified on the purchase order or allowed per specification.

9. RTX REQUIREMENTS – ASQR-01

Purchase orders involving material for RTX or Pratt & Whitney use will include the requirements of ASQR-01. Note AS6174 is flowed down within use of ASQR-01, and compliance must be met as well.

10. TESTING

All tests must be conducted in strict accordance with the specifications outlined in the Purchase Order. Test samples must represent the product in its final heat treat and delivered condition. Unless otherwise required by the specification, tests shall be conducted at a frequency of one test per heat lot and cross section.

11. SAMPLING

Dimensional sampling on products delivered to a location other than Rolled Alloys shall be compliant with ANSI Z1.4 or ANSI Z1.9. The following sampling plan may be used as a reference. Pratt & Whitney or RTX end-use order must be sampled in accordance with ASQR-20.1.

LOT SIZE	SAMPLE SIZE
1-3	100% INSPECT
4-25	3
26-50	5
Over 50 PCS	10% of Lot

12. Positive Material Identification (PMI)

When specified on the purchase order, PMI must be performed with XRF, LIBS, or equivalent at a frequency of one test per bundle/heat. Confirmation of PMI to be recorded and provided to Rolled Alloys. PMI data to be stored and remain retrievable for 5 years.

13. NON-CONFORMING MATERIAL

Authority to ship non-conforming material must be obtained in writing by RAC, 24 hours prior to shipment.

14. IDENTIFICATION /TRACEABILITY

Traceability to the original heat lot shall be maintained through the entire process. Unless otherwise specified, material shall be legibly marked or stamped with the alloy type and heat/lot number.

15. PRODUCT SAFETY

Material shall be controlled, handled & delivered to mitigate unacceptable risk of harm to persons or damage to property.

16. PRESERVATION, PACKAGING

All material shall be preserved and packaged to protect against moisture, rust, corrosion, and physical damage during shipment from the supply source to the destination noted on the purchase order. Actual weights of material and total weight shall be documented, except for plate product which may be theoretical weight.

For RAC supplied material, the supplier shall identify, protect, and safeguard the material for use or incorporation into the products or services. The supplier shall maintain the traceability, cleanliness, and usability of the material while under its control or being used by him. Losses, damages, or issues affecting suitability of material shall be reported and documented accordingly.

17. PAPERWORK / CERTIFICATIONS

In addition to the original MTR, suppliers shall provide a PL and C of C documenting the work performed. For raw material manufacturers, a MTR satisfies the C of C requirement. Inspection certificate must meet the requirements of the governing specification and EN 10204 3.1.

17.1. Documentation content:

Certifications must be legible, complete and detail all current specifications, chemistry and mechanical properties, tests, and method of manufacture. Additionally, MTRs must include the country of melt and manufacture, a statement asserting the product has not come into known contact with mercury or other low melting point elements, radioactive materials, nor have undergone any weld repairs

Packing List and C of C shall include the RAC purchase order, the heat/lot number, quantity, applicable specifications or drawings, a description of the material or services provided, and a statement of compliance to RAC PO instructions

All documentation shall be legible, signed and dated by a qualified and authorized representative.

18. RECORDS

All records showing compliance to the specifications, purchase order, and third-party testing records are to remain on file for a minimum of ten years. Advise RAC prior to the disposal of any records.

19. FRAUD AND FALSIFICATION

The recording of false, fictitious, or fraudulent statements or entries on this document may be punishable as a felony under Federal Statute.

20. FOREIGN OBJECT DAMAGE (FOD)

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

21. ACCESS

As applicable, suppliers shall provide access to relevant data within the Online Aerospace Supplier Information System (OASIS) and provide data from the Nadcap databases (e.g., registration documentation, certification, audit reports and findings, corrective actions).

22. AS13100 REQUIREMENTS

As applicable suppliers providing products and/or services for Aero Engine Manufacturers end use shall comply with AS13100 requirements, as determined by Table 1 (Organization Type) & Table 2 (QMS certification requirements) of the standard. Suppliers shall ensure that their respective sub-tiers are equally compliant.

Upon request, suppliers shall provide an Annual Audit Report demonstrating compliance to AS13100. Based on the results, an additional level of surveillance may be applied.

23. OUTSOURCING/SUBCONTRACTING

All outsourcing services must be completed by an RAC approved vendor and require confirmation of approval prior to outsourcing and/or subcontracting.

24. PERFORMANCE EVALUATION FOR SUPPLIERS

Suppliers undertake to achieve quality objectives determined by Rolled Alloys - Canada Inc, in particular:

- On Time delivery: Equal to or higher than 80%.
- Quality Rating: Equal to or higher than 95%.
- Provide adequate and timely response to non-conformances and/or corrective actions as defined within the documentation provided.

Regular measurements of these indicators are carried out and may be communicated to suppliers, as deemed applicable. These results will serve as the basis for the quality review of identified suppliers. When necessary, a continuous improvement plan will be requested.

APPENDIX A Revision History Documented Information:

REV	REV DATE	REVISED BY	REVIEWER	COMMENTS
A	06-02-2017	D. Haman	D. Haman	New Document
B	04-02-2018	D. Haman	D. Haman	Clause -1 – added “Certificate of Conformances”. Clause-10 – added “statement of compliance to Rolled Alloys PO instructions”. Clause-11 – new clause related to the prevention of counterfeit parts. Clause-12 – new clause related to product safety.
C	04-16-2018	D. Haman	D. Haman	Clause-13 – new clause related to awareness of ethical behavior.
D	06-10-2020	D. Haman	D. Haman	Clause-09 – modification to cover RA supplied material.
E	08-21-2023	D. Haman	E. Fernandes	Clause 1 – editing Clause 14 – new clause to communicate performance evaluation for suppliers.
F	06-09-2025	D. Haman	GMs, I.S.M., QA.	Renamed & restructured the document. Added new requirements: Clause 4 – acceptance authority media Clause 6 – compliance Clause 9 – RTX requirements – ASQR-01 Clause 10 – testing Clause 12 – positive material testing (PMI) Clause 19 – fraud and falsification Clause 20 – foreign object damage Clause 21 – access Clause 22 – AS1300 requirements Clause 23 – outsourcing/subcontracting Edited existing requirements: Clause 2 – changes Clause 17 – paperwork/certification