

CONTROLLED DOCUMENT-QPR-DM- DIRECT MILL QUALITY CLAUSES



PURCHASE ORDER QUALITY CLAUSES – DIRECT SHIPMENTS

The following Quality Clauses apply to all orders shipping to a location other than Rolled Alloys.

1: SUPPLIER RESPONSIBILITY

It is the responsibility of the supplier to satisfy all requirements of the purchase order, including specification requirements, Quality requirements, marking requirements, deliverable documentation requirements such as MTR's, C of C, and Packing lists.

2: CHANGES

Supplier 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.

3. RAW MATERIAL SPECIFICATIONS

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

4. SAMPLING

The sample plans used shall be compliant with ANSI Z1.4 or ANSI Z1.9. The following sampling plan may be used as a reference. Pratt & Whitney or UTC 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

5. 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.

6. IDENTIFICATION /TRACEABILITY

Traceability 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.

7. NON-CONFORMING MATERIAL

Authority to ship non-conforming material must be obtained in writing by the buyer prior to shipment.

8. 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.

9. 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.

10. **PAPERWORK / CERTIFICATIONS.** Supplier shall provide a packing slip and/or Certificate of Conformance documenting the work performed. At a minimum, this documentation shall include the Rolled Alloys purchase order, the heat/lot number, quantity, applicable specifications or drawings, and description of the material or services provided.

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