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	SPECIFICATION NO.	Q-107.4SQR
TITLE: GENERAL QUALITY REQUIREMENTS FOR SUPPLIERS OF CRITICAL TO QUALITY PRODUCTS AND SERVICES.	DATE ISSUED:	4/22/2008
	DATE REVISED:	01/06/2010

1.0. Scope:

This document establishes the General Quality Requirements for suppliers of critical to quality products or services to any RTI International Metals Company. It is Supplier's responsibility to ensure implementation of these requirements within its organization and flow-down to their sub tier suppliers.

2.0. Order of Precedence

The requirements specified in this specification are intended to be complementary to all RTI International Metals, end user, and industry specifications, as well as all other requirements which may be applicable, including any Legal, regulatory or administrative requirements.

In the case where requirements of this specification are in conflict with the requirements of end user specifications, industry specifications, or engineering drawing / models, the latter requirements will take precedence.

In the event of conflict in the definition of requirements, the order of precedence is:

- 1) Procuring document (purchase order),
- 2) Applicable engineering documents (condition of supply)
- 3) Associated process specifications, and
- 4) Other referenced specifications.

Contact your RTI procurement representative for further information and to advise him or her that such a conflict exists.

By issuing this document, RTI in no way represents, warrants or guarantees that the supplier, by complying with all the requirements herein contained, complies with all requirements.

3.0. Second & Third Party Approvals

3.1. Where required the supplier shall obtain and maintain certifications as directed by RTI International Metals.

- * 3.1.1. Required third party certifications may include but are not limited to the following:
- 3.1.1.1. ISO 9001:2008
 - 3.1.1.2. AS 9100B
 - 3.1.1.3. NADCAP Approval for special processes
- 3.1.2. At the sole discretion of RTI International Metals, suppliers who do not have the required third party certifications may be audited by RTI International Metals to the applicable requirements and approved upon recommendation of an RTI Corporate Approved Lead Auditor.
- 3.1.3. OEM / End user approvals (second party approval).

* Denotes change and/or addition

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4.0. RTI Supplier Approvals

- 4.1. All suppliers of critical to quality products and services must be first approved by RTI International Metals. This approval can only be granted by the RTI Quality Assurance Department.
 - 4.1.1. Under no circumstances can a supplier sub contract any work without the express approval of the RTI Quality Assurance Department.
- 4.2. All suppliers after initial approval are subject to periodic evaluation based on the following:
 - 4.2.1. Supplier performance will be graded based on the following minimum requirements:
 - 4.2.1.1. On time delivery performance: Target \geq 90%
 - 4.2.1.2. Product quality performance: Target \geq 90% non defective
 - 4.2.1.3. Accuracy of required documentation: Target 100% deliveries with complete and accurate documentation.
 - 4.2.1.4. Each RTI Location may impose stricter requirements based on specific supplier requirements.
 - 4.2.2. Performance to corrective and/or preventative actions issued to the supplier.
 - 4.2.3. Changes to suppliers manufacturing or processing capability.
 - 4.2.4. Periodic audit.
- 4.3. Unsatisfactory performance to any item in section 4.2 could be cause for approval to be revoked, suspended, or limited, at the sole discretion of RTI Quality Assurance.
 - 4.3.1. Limits placed on a supplier may include but are not limited to the following:
 - 4.3.1.1. Suppliers may be placed on probation. Probation status requires the supplier to submit a Corrective Action Plan within 14 days.
 - 4.3.1.2. Obtaining source inspection from RTI Quality Assurance at the suppliers expense
 - 4.3.1.3. Reimbursing RTI for reasonable RTI costs incurred at the point of manufacture (i.e. Supplier site) to verify product conformance
 - 4.3.1.4. Reimburse RTI for reasonable costs incurred by RTI at the point of receipt to verify product conformance.

5.0. RTI Source Inspection

- 5.1. Source Inspection can be imposed on a Supplier as decided by RTI Quality Assurance for various reasons and is not to be construed as punitive. Source Inspection criteria include but are not limited to:
 - 5.1.1. First Article Inspection or Delta First Article Inspection
 - 5.1.2. Part of new supplier qualification
 - 5.1.3. Customer Critical or serialized part
 - 5.1.4. Poor quality or delivery performance
- 5.2. Source inspection can include required observation of processing, verification of finished material, or additional inspection requirements.
- 5.3. Specific requirements will be communicated to suppliers via the purchase order, condition of supply documents, or additional specification requirements.

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6.0. Digital Product Definition Requirements

- 6.1. RTI suppliers are required to obtain RTI approval as a DPD capable supplier if the supplier receives, downloads, and/or uses Computer Aided Design (CAD) geometry in any format from RTI.
- 6.2. To become approved, a Supplier must demonstrate the ability to comply with “Digital Product Definition Supplier Qualification Checklist” (form Q-107.4SQR attached). Questions contained in this document are intended to evaluate a supplier’s deployment of DPD process controls.

7.0. Foreign Object Damage (FOD) Prevention

- 7.1. All suppliers are required to prevent foreign objects from contaminating material(s).
- 7.2. Where required specific FOD requirements will be communicated to suppliers via the purchase order, condition of supply documents, or additional specification requirements.

8.0. Change to Supplier’s Organization

Supplier shall notify RTI of any changes in its organization affecting manufacturing site location, manufacturing processes, certification status, approved Sub-tier suppliers and subcontractors or other pertinent changes that could affect the product. Written notification of changes shall be sent to RTI procurement representative prior to implementation. Supplier will describe the nature of the change, including justification, scheduled date and point of incorporation and impact on manufacturing and logistics concerns.

9.0. Right of Access

The Supplier shall grant access to RTI, RTI’s customers, or any applicable government or regulatory agency to any areas and/or records that are part of work performed under an RTI purchase order.

10.0. RTI Contracts and Purchase Orders

- 10.1. It is the Supplier’s responsibility to understand and comply with all clauses, terms and conditions specified within a contract, a purchase order, and with all other applicable requirements. Failure to do so may result in product rejection and may affect the Supplier’s status and expose them to monetary penalties.
 - 10.1.1. A supplier may be charged back for all costs incurred by RTI due to Supplier non compliance to any applicable requirement.
- 10.2. Suppliers shall not guess or interpret requirements including but not limited to drawing / model, specification, or condition of supply if conflict or confusion exists. Contact the assigned SQA representative to initiate the process of clarification.
- 10.3. The RTI procurement representative is the only authorized person to issue or revise purchase orders.

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11.0. No Change Clause

Supplier shall make no change in manufacturing or assembly processes or source of supply without express consent of the RTI Quality Assurance Department. This requirement is also to be flowed down through Supplier Supply Chain.

12.0. Control of Records

12.1. Quality records shall be kept for a minimum of ten years after delivery of the last item on a purchase order and shall not be destroyed unless written approval is obtained from RTI procurement.

12.1.1. Additional RTI purchase specifications may impose stricter record retention requirements.

12.2. Records/data stored by electronic means shall have a secure backup system.

13.0. Identification and Traceability

All material shall be identified in accordance with applicable purchase order requirements, specification requirements, drawing requirements, and contractual requirements.

14.0. RTI Property

14.1. RTI may provide to Supplier parts, raw material, tools, etc. These supplied goods shall be subject to receiving inspection in accordance with Supplier's procedures.

14.2. Supplier shall report in writing, via rejection report any non-conformance related to received goods.

14.3. RTI supplied goods shall be stored in a segregated area to prevent unauthorized used and adequately protected against damage and degradation.

15.0. Preservation of Product

15.1. Packaging shall be done in accordance with the engineering drawings, specifications, condition of supply, and / or as specified on the purchase order. In all circumstances, the guidelines of ASTM-D3951 apply in order to prevent physical, contamination and corrosion damage in transit.

15.2. Supplier shall pack the products to prevent damage and deterioration taking into account method of shipment, location of shipment and destination of receipt, as well as time associated with shipment.

15.3. Product received from the Supplier in a damaged condition due to improper packaging or showing evidence of rust or surface corrosion will be rejected.

15.4. Product with shelf life shall not have more than 25% of the life elapsed at time of receipt at RTI.

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16.0. First Article Inspection Report

- 16.1. When required, suppliers shall follow the requirements of AS9102.
- 16.2. The First Article shall be clearly identified "FAI" or "Delta FAI" when presented to RTI for inspection and / or shipped to RTI.

17.0. Control of Nonconforming Product

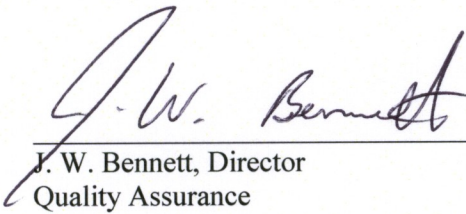
- 17.1. For nonconformities detected at the supplier facility, the supplier shall:
- Complete a rejection report / deviation request
 - Forward the rejection report / deviation request to the RTI procurement representative for disposition.
- 17.2. For nonconformity detected by the Supplier on a product already delivered, the Supplier shall promptly notify RTI via a disclosure letter to the RTI procurement representative. The Disclosure letter shall include as a minimum:
- Affected material identification including part number(s) along with traceability number, quantity delivered and date delivered
 - A clear description of the nonconformity
 - Potential impact, if known
 - Inspection procedure along with acceptance criteria, as required
 - Instructions for the disposal of retrieved nonconforming items.

18.0. Additional RTI Requirements

Individual RTI locations may have additional requirements or more stringent requirements than those expressed in this specification. In that case the local Quality Assurance Department shall communicate these to suppliers in an additional specification Q-107.4SQR-XXX (where XXX denotes the specific location).

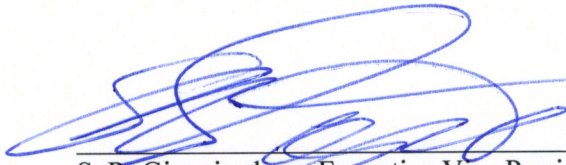
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Approved by:




 J. W. Bennett, Director
 Quality Assurance

1-7-2010
 Date ^{MS} 1-7-10



 S. R. Giangiordano, Executive Vice President
 Technology & Innovation

1-07-10
 Date



 Richard Dean, Vice President
 Fabrication Operations

1/12/2010
 Date

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CHANGE HISTORY:

This is a newly issued specification dated April 22, 2008, created by Luc Charbonneau & Jeffrey W. Bennett to address issues in section 7.4 of the AS-9100B standard.

Revision dated 01/06/2010 originated by J.W. Bennett
Updated references to ISO 9001:2008 in section 3.1.1.1.
Updated signature page per Q-104A dated 10-23-09.