



**Flat Rolled Products**

ALSP Spec No.:	<b>ALSP.GEN.1</b>	<b>General Quality Requirements</b>		
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**I. SCOPE**

This specification applies to suppliers of semi-finished and raw material to ATI Flat Rolled Products (ATI FRP), and subcontractors providing ATI FRP any of the following services: conversion on semi-finished material, final inspection, material testing, furnace pyrometry testing, thermocouple manufacturing and calibration, calibration of monitoring and measuring equipment, material storage, or shipment of material to customers.

**II. RESPONSIBILITY**

Suppliers have the responsibility to complete work in accordance to applicable ATI FRP procedures and ATI FRP purchase orders. In the event of a conflict between the requirements of an ATI FRP Purchase Order and ATI FRP procedures, the requirements of the ATI FRP Purchase Order shall take precedence.

Outside subcontractors have the responsibility to complete work in accordance to ATI FRP procedures and Vendor Processing Instructions (VPI). In the event of a conflict between the requirements of ATI FRP procedures and the requirements of the VPI, the requirements of the VPI shall take precedence.

ATI FRP has the responsibility to flow down customer and internal ATI requirements to the subcontractor/supplier via procedures, purchase orders and/or VPI's.

**III. REQUIREMENTS**

1. Requirements Applicable to All Purchase Orders and Vendor Processing Instructions

ATI FRP Subcontractors / Suppliers shall:

- 1.1. Ensure applicable ATI FRP flow-down requirements are imposed on all levels of the supply chain, as well as sub-tier suppliers, including customer requirements, key characteristics and corrective actions as required.
- 1.2. Maintain a quality management system using continuous improvement strategies.
- 1.3. Notify ATI FRP for review and approval prior to subcontracting work related to an ATI FRP Purchase Order when that work has not been pre-approved by ATI FRP. Sub-tier suppliers must be approved prior to use.
- 1.4. Permit right of access at any level of the supply chain by ATI FRP, our customer, and regulatory authorities to involved facilities/operations and applicable records to perform audits, surveillance, or verification to assure Quality Assurance requirements and/or the requirements of the purchasing documents are being met.
- 1.5. Immediately notify ATI FRP of any deviations/defects found to exist in products or services provided to ATI FRP. The subcontractor/supplier's obligation is to immediately notify ATI FRP in the event a deviation is found to exist in any product or service delivered to ATI FRP. ATI FRP shall disposition the deviation in accordance with customer requirements and Federal Regulations (10CFR21).

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- 1.6. Ensure products and services requisitioned as safety related functions (i.e. nuclear grade materials and services) shall be held to the requirements of Title 10, Chapter 1, Code of Federal Regulations, Part 21 (10CFR21).
  - 1.7. Notify ATI FRP for review and approval of any significant changes to your Quality System Program, services and/or processing procedures that may affect the quality of ATI FRP material prior to implementation. E.g., changes to manufacturing facility location, new equipment, scope of quality accreditation, etc.
  - 1.8. Certify (as applicable) that the materials or services were produced or performed in accordance with the quality program audited and approved by ATI FRP.
  - 1.9. Prevent the use of unapproved, suspected unapproved, and counterfeit parts.
  - 1.10. Notify ATI FRP in the event the subcontractor/supplier and/or any principals of the subcontractor/supplier is debarred, suspended, proposed for debarment, or declared ineligible for the award of contracts by any Federal agency.
  - 1.11. Ensure applicable quality records pertaining to the performance of requested services or manufacture of material must be retained for a minimum of ten (10) years, unless otherwise specified on the applicable ATI FRP Purchase Order.
  - 1.12. Ensure personnel are appropriately qualified for the jobs they perform. The employees must be aware of the importance of:
    - 1.12.a.1. Their contribution to product or service conformity
    - 1.12.a.2. Their contribution to product safety
    - 1.12.a.3. The importance of ethical behavior
  - 1.13. Notify ATI FRP of any condition that adversely impacts the laboratory's ability to maintain the scope of accreditation.
2. Requirements Applicable to Calibration Services Providers:
- 2.1. When calibration services are performed at an ATI FRP location, a calibration certificate shall be provided to ATI FRP. If the calibration services are performed at the subcontractor's facility, a calibration certificate shall be provided along with the calibrated equipment when it is returned.
  - 2.2. Calibration services are to be provided in accordance with the accredited program. The calibration certificate must certify compliance to:
    - a. ISO/IEC 17025:2005, ISO 10012 or ANSI/NCSL Z540, latest revisions;
    - b. All specifications listed on the P.O.
    - c. ATI FRP purchase order number
  - 2.3. The calibration certificate must also include the following information:
    - a. calibration date
    - b. serial number, make and model of the standard(s) used to perform the calibration
    - c. serial number, make and model of the device being tested
    - d. standard (nominal) test value(s)
    - e. actual (as-found) test result(s)
    - f. as-left test result(s)

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- g. deviation from the standard or correction factors with the cert clearly stating which.
  - h. required accuracy
  - i. statement of acceptance or rejection. The acceptance criteria for the monitoring and measuring equipment (e.g. gauge blocks) can be either the former Federal Standard (GGG-G-15C) or ASME B.89.1.9-2002. The acceptance criterial must be stated on the certificate.
  - j. test environmental conditions (when applicable)
  - k. sensitivity, pass/fail (when applicable)
  - l. traceability to national standards
  - m. ***precision of the instrument or measurement uncertainty of the measurement result presented in the same unit as that of the measurand or in a term relative to the measurand*** (when ISO/IEC 17025 accredited calibration is requested)
  - n. calibration procedure and revision or method used to perform the calibration
  - o. name of the person who performed the calibration
  - p. signature of Quality Organization or designated company representative with title
  - q. calibration company's name and address
  - r. due date of the next calibration.
- 2.4. The calibration certificate for production scales (non-laboratory) and test weights (non-laboratory) must include the following information:
- a. calibration date
  - b. serial number standard(s) used to perform the calibration
  - c. serial number, make and model of the device being tested
  - d. standard (nominal) test value(s)
  - e. actual (as-found) test result(s)
  - f. as-left test result(s)
  - g. deviation from the standard or correction factors with the cert clearly stating which.
  - h. statement of acceptance or rejection
  - i. standards traceable to NIST and/or other internationally recognized standard
  - j. name of the person who performed the calibration
  - k. signature of company representative
  - l. calibration company's name and address
  - m. due date of the next calibration.
- 2.5. Calibration of Furnace Controllers, Recorders and Thermocouples
- a. Furnace controllers, recorders and thermocouples must be tested at those temperatures specified by the purchase order and in accordance with AMS 2750, latest revision.
  - b. Thermocouples made from rolls calibrated in accordance AMS2750 may be supplied in lieu of individually calibrated thermocouples IF they comply with requirements in AMS2750 latest revision for such thermocouples.

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The calibration standard used must be traceable to NIST or other equivalent national certification agency.

- d. For instruments, a sticker shall be affixed to the instrument and include:
  - i. the date of calibration
  - ii. the due date of the next calibration
  - iii. technician who performed the calibration.
  - iv. Any limitations or restrictions of the calibration
- e. If ATI FRP calibration procedures are used, training on the ATI FRP procedures must occur with a minimum frequency of five years and as needed for revisions. Training records must be maintained.

#### 2.6. Calibration of Secondary Pyrometry Standards

- a. Secondary standards shall be calibrated per the manufacturer's instructions and in accordance with AMS 2750, latest revision.

#### 3. Requirements Applicable to Laboratory Testing Services Providers:

- 3.1. Testing services are to be provided in accordance with the accredited program. A Certification containing the test results must be forwarded to the requestor of the testing services.
- 3.2. The Certification must certify compliance to:
  - a. ISO/IEC 17025 and/or Nadcap;
  - b. The applicable ATI FRP Purchase Order; and
  - c. 10CFR21 as applicable.

#### 4. Requirements applicable to NDE service providers:

- 4.1. NDE services shall be performed by qualified personnel using qualified procedures in accordance with specific requirements. Written practices shall meet ASNT SNT-TC-1A latest code accepted revision requirements.

#### 5. Requirements applicable to subcontractors performing conversion services on semi-finished material:

- 5.1. The outside processor shall notify ATI FRP of planned outages at least three months before the outage.
- 5.2. The outside processor shall notify ATI FRP immediately of unplanned process outages, changes in process capabilities, and delivery and shipping availability.
- 5.3. Upon arrival and before unloading, the outside processor shall inspect the received material for transit damage and wetness. The subcontractor shall document incidents of transit damage and wetness with photos, and, submit a description and photos to ATI FRP within 24 hours of delivery.
- 5.4. Prior to unloading, the outside processor shall verify what is physically being delivered against the bill of lading.
- 5.5. The outside processor shall review the VPI within 24 hours of delivery of the **material**.

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- a. The outside processor shall notify ATI FRP immediately if **material** arrives for which a VPI has not been received.
  - b. The outside processor shall notify ATI FRP immediately if processing cannot be completed per the VPI.
- 5.6. The outside processor shall provide records of production via email or Tandem production recording to ATI FRP within 24 hours of completing processing of the material.
- 5.7. All titanium coils shipping back to ATI FRP from the outside processor shall ship on the skids they were delivered on, or, on skids similar to those sent with the coil.
- 5.8. The outside processor shall verify that all flatbed loads leaving their facility are loaded per VPI shipping instructions, are properly tarped and secured.
- 5.9. Prior to releasing an outbound shipment, the outside processor shall verify what is physically being shipped against the bill of lading.

Revised by: J.C. Valko, Sr Process Leader, Quality

Approved by:

**Approval on File in Quality Assurance**

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