



# Supplier Quality Requirements

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**QR1 Material Test Reports:** A legible copy of material test reports shall accompany each shipment. Test reports shall be identified with specification number and heat and/or cure lot number and cure date, as applicable. Chemical and physical test reports shall include actual numerical values for each property tested in accordance with the applicable specification. When more than one specimen is required, test results of each are required on the report. Specification and revision shall be shown on each test report furnished. Specification and revision shall be to the latest release.

**QR2 Certified Test Data:** A legible copy of certified test data shall accompany each shipment of material, parts, or assemblies. Tests shall be identified with specification number and heat and/or cure lot number. Chemical and physical test data shall include actual numerical values for each property tested in accordance with the applicable specification. Specification and revision shall be shown on each report furnished. Specification and revision shall be to the latest release.

**QR3 Certificate of Conformance:** Each shipment shall be accompanied by a legible copy of a Certificate of Conformance with the signature of responsible representative stating:

- TD Manufacturing (TD MFG) PO number, material (included heat/Lot number), process, or article being shipped meets requirements of applicable drawing or specification, work instruction cited in TD MFG Purchase Order.
- Specifications and revision shall be to the latest release unless otherwise noted.
- Supplier shall the signature of responsible representative and date of manufacture on the Certificate of Conformance.
- Raw material shall have Mill Certificate.

**QR4 First Article Inspection:** A First Article Inspection (FAI) in accordance with SAE AS9102 (lasted revision) , of one part, randomly selected from the first manufacturing lot of each part number, shall be conducted and documented by the Seller. The actual value of each drawing attribute shall be recorded, including drawing notes, specified processes, functional tests, and laboratory requirements, as applicable. Subsequent FAI's (Delta FAI's) shall be performed in accordance with SAE AS9102, section 5.3. Engineering drawing revisions shall require the generation of Delta FAI's to document the differences between the new and previous FAI. A new FAI shall be accomplished on a randomly selected part from the first lot produced if there is a lapse in the manufacturing cycle of two (2) years.

**QR4A Final Inspection Report:** If required, the seller shall furnish a final inspection report for each lot / batch of shipment. Final inspection report shall include but not limited to: TD MFG drawing notes, special processes, dimensional requirement, test report (if applicable). Unless otherwise specified, sampling plan inspection shall be approved by TD MFG Quality Manager.

**QR5 Report of Discrepancy:** Any departure from drawing specifications or other Purchase Order requirements shall be documented by the Seller and submitted to TD MFG, within 24 hours for consideration and approval of any non-conforming disposition. A copy of the dispositioned document shall accompany each affected shipment.

**QR6 Traceability/Lot and Batch Control:** Seller shall maintain lot and batch control of raw materials and details to purchased items through the use of lot, batch, serial number, or date of manufacture, as applicable, for all items in the shipment.

**QR7 Quality Assurance Records Retention:** Seller shall retain manufacturing planning, all certifications, and



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test reports required to assure that commodity conforms to the contractual and technical requirements of the Purchase Order for a minimum of 10 years after closure of the Purchase Order and shall be available for review by TD MFG, its customer or regulatory authority upon request. The supplier shall notify TD MFG in writing at least thirty (30) business days prior to destruction of records and must comply with any written response from TD MFG a request of such destruction.

**QR8 Identification:** Unless otherwise specified by Purchase Order, parts, assemblies and components shall be identified per the engineering drawing and marked with the date of manufacture. When identification is not specified on the engineering drawing, the product shall be identified with the part number, dash number and revision specified on the Purchase Order. When items are too small to be easily identified, parts may be bagged or tagged, with the proper identification indicated on the bag or tag. Raw material procured to Federal, Military, Aerospace or other specifications shall be marked per the identification specification, which is referenced in the controlling specification

**QR9 T D Manufacturing, Furnished Materials:** Parts or assemblies manufactured from T D Manufacturing, furnished material shall be accompanied by a Certificate of Conformance, stating that the parts and/or assemblies were produced from T D Manufacturing, furnished material(s). The Certificate of Conformance shall be identified with the part number and the Seller's lot number, material manufacturer's name and material certification number, if drop-shipped from the material manufacturer to the Seller. The Certificate of Conformance shall be identified with the T D Manufacturing, packing slip number if shipped from T D Manufacturing.

**QR10 Approved Processor Requirements:** A legible copy of all special process certifications shall accompany each shipment of material, parts, or assemblies. Special processes shall only be performed by customer-approved sources. Approved Source Identification number shall state on Certification.

**QR11 Boeing Approved Vendors:** All special processes for details and assemblies built per Boeing drawings shall be processed utilizing D1-4426 approved vendors. All material and hardware used in details and assemblies built per Boeing drawings shall be obtained from Boeing-approved sources.

**QR12 Material Safety Data Sheets (MSDS):** Materials noted on this Purchase Order must be supplied in accordance with OSHA's hazard communication standard 29CFR1910-1200, OSHA instruction CPL2-2.38 dated August 5 1985, and Washington State codes 296-62-05413, "Material Safety Data Sheets". Materials not received in compliance with the aforementioned OSHA requirements and Washington State codes will be subject to immediate rejection and return at supplier's expense. In addition, if Seller is aware of any additional precautions and/or handling techniques instituted with regard to other customers, the Seller is required to submit those safeguards with the MSDS. If specifically noted in body of purchase order, seller is required to forward a Toxic Substances Control Act (TSCA) certification letter to T D Manufacturing, Buyer for product(s) purchased on this Purchase Order, with the statement that every chemical component of the product(s) is listed by the Toxic Substances Control Act Inventory (P.L.94-94-969).

**QR13 Supplier Corrective Action:** Seller shall, on request, provide statements of corrective actions on failures of Seller's product or Quality System. Corrective action statements may require approval of T D Manufacturing, Quality Assurance. Continues to failure responding the Corrective Action on time and / or failure implementing of corrective action/ preventive action, the Seller approval status will be derated or removed from TD Manufacturing Approved Supplier List.

**QR14 Control of Changes:** Seller agrees not to make any change in materials or design details that would affect the part or any component part thereof without prior written approval from T D Manufacturing. Supplier shall



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notify TD MFG within 72 hours of changing in Quality Management system, Management Representative, facility location and loss of or suspension of Certification or eligibility for ISO 9001/AS 9100, ITAR.

**QR15 Calibration System Requirements:** Seller shall have a calibration system that assures compliance with ISO 10012, "Measurement management systems – Requirements for measurement processes and measuring equipment". Any deviation or waiver to this requirement shall be approved in advance by T D Manufacturing, Quality Assurance.

**QR16 ITAR Warning:** International Traffic in Arms Regulation (ITAR) Warning. Equipment and/or technical data generated or delivered in performance of this contract may be controlled by the Code of Federal Regulations, International Traffic in Arms Regulation (ITAR), 22CFR, Chapter 1, Part 120, Sections 120-130, and may require an export license before assigning any foreign person or foreign national to perform work under this contract or before granting access to foreign persons or foreign nationals to any equipment/technical data generated or delivered in performance of this contract (See 22CFR, Ch. 1, Section 123). A foreign person is any natural person who is not a lawful permanent resident of the U.S. or who is not a protected individual. It also means any foreign corporation, business association, partnership, trust, society or any other entity or group that is not incorporated or organized to do business in the U.S., as well as international organizations, foreign governments and any agency or subdivision of foreign governments (e.g., diplomatic missions). It also includes any foreign interest and any U.S. person effectively owned or controlled by a foreign interest. A foreign national is any person who is not a citizen or national of the U.S. If you have any questions about the proper application of ITAR restrictions, immediately contact your T D Manufacturing, Procurement Representative for resolution.

**QR17 Quality Management System - Suppliers:** The Supplier shall maintain a quality system that complies with Aerospace Standard AS9100, "Quality Management Systems – Requirements for Aviation, Space and defense Organizations." Supplier QMS document are readily accessible whenever requested by TD MFG, its customers and regulatory agency to ensure they are capable to perform the contract processes and have adequate resources necessary to meet TD MFG purchase order requirements.

**QR17B Quality Management System – Distributors:** The Distributor shall maintain a Quality Management Systems that complies with either Aerospace Standard AS9100, "Quality Management Systems – Requirements for Aviation, Space and defense Organizations and/or AS9120 – "Quality Management Systems - Aerospace Requirements for Stock list Distributors.

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**QR18 Right of Entry:** TD MFG and its customer reserves the right to enter, observe, record and or report on any activities at the Supplier and their sub-tiers during the manufacturing of the TD MFG and/ or customers products. This right extends to include any pertinent federal, state or local government agency, including the DOD.

**QR19 Digital Product Data (DPD) Requirements:** Supplier shall be certified per TD-F741-8 DPD MBD Questionnaire. Suppliers shall be DPD approved by T D Manufacturing, prior to delivery of a procured product or service. Supplier is responsible to maintain being in compliance with requirements set forth in D6-51991. Supplier shall have on file a copy of D6-51991. Supplier must notify customer within 30 days of any changes or at a minimum annually if no changes occur. TD MFG has the right to audit supplier's DPD process if needed.

**QR20 Supplier-Sub tier Control:** Seller shall notify Buyer prior to outsourcing any requirements pertaining to Buyer's purchase order. After approval for outsourcing, in writing by Buyer, Seller must flow down all requirements outlined on Buyer's purchase order, including TD MFG TD-F741-3 lasted revision, any key characteristics, to their supplier. Seller is responsible to monitor, control its sub tier supplier to ensure delivered product meet quality and On-time schedule by TD MFG and its customer requirement.



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**QR21 AS9100 Certification:** Seller shall maintain certification, obtained from an accredited certification body, to AS/EN/JISQ 9100, Quality Management Systems Aerospace Requirements, as may be revised from time to time. Boeing (Buyer) reserves the right to make final determination regarding seller compliance to quality management system requirements. Seller shall comply with the requirements of Form X31764 (Revised 07/01/2013), Boeing Quality Purchasing Data Requirements available at the following URL address. When entering URL - (Please do so in lower case letters only): <http://www.boeingsuppliers.com/>

Seller shall also perform First Article Inspections (FAIs) in accordance with AS/EN/SJC 9102.

Boeing requires that the provisions/requirements set forth in FORM X31764 be included in Seller's direct supply contracts as well as the obligation that they be flowed to the Seller's sub-tier supply chain. Boeing requires that the provisions/requirements set forth in AS/EN/JISQ 9100, as determined by the Seller to be applicable, be flowed to the sub-tier supply chain as specified in AS/EN/JISQ 9100.

**QR22 Revision Status – Technical Data:** Seller shall assure that specifications, drawings, parts list, process requirements, inspection and verification instructions and other relevant technical data is the current controlled and released revision unless otherwise specified in the purchase order.

**QR23 Prohibited substances in supplied materials and parts:** Product and / or material does not contain the following substances. Asbestos (all forms) –global regulations (e.g., [EU REACH Annex XVII](#)) prohibit the use of asbestos. Boeing has existing contractual requirements that prohibit suppliers from delivering products that contain any asbestos mineral fibers. Penta-bromodiphenyl ether and octa-bromodiphenyl ether – global regulations (e.g., [EU 76/769/EEC](#), [RoHS](#), [US EPA](#)) restrict their marketing and use. BCA previously sent out communication requiring suppliers to identify the presence of these flame retardants in supplied materials and parts. Polychlorinated biphenyls (PCBs) – global regulations (e.g., [Stockholm Convention](#), [US Environmental Protection Agency](#)) prohibit the use of PCBs.

**QR24 Prevention of Counterfeit of Suspect Product:** Supplier shall establish a process to eliminate the risk of introducing both counterfeit product including electrical and non- electrical part into TD MFG and its customer products. Parts and assembly must have certificate from Original Component Manufacturing (OCM) and Original Equipment Manufacturing (OEM) and that certificate shall be delivered with each lot/ batch shipment. Supplier must have program to avoid counterfeit product re-enter back to supply source.

**QR25 Employee awareness and training:** Supplier shall have their employee are aware of:

- Their contribution to product or service conformity.
- Their contribution to product safety.
- Importance of their ethical behavior.

**QR26 FOD Prevention:** The supplier shall have established and maintain effective Foreign Objective Debris/ Damaged (FOD) prevention program to eliminate FOD in items to delivered to TD MFG. the written procedure/policy developed by supplier may be subject to TD MFG review and audit.

**QR27 TD MFG Audit, Monitoring, Control supplier Performance:** TD MFG and its customer reserves the right to conduct a survey/ audit the supplier's facility and their sub-tiers to determine their capability to comply with the requirement of the purchase order. The supplier will be notified 72 hours in advance of the date of survey/ audit will occur. Performance of sellers is monitoring and evaluating in quarterly interval per TD MFG SOP 7.4. Sellers will be notified as soon as their performance including On-time delivery and product quality failed below TD MFG expectation level. If needed, Corrective action is required per TD-F741-3, QR -13.



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## Revision Record:

Rev.	Description	Date	Author
NC	Initial Release	05/20/13	John M. Brennan
A	Added QR23, Prohibited substances in supplied materials and parts.	04/22/16	John M. Brennan
B	Revised QR 3,14 add QR 4, QR 24, QR 25, QR26, QR 27	5-13-2018	Thang Le
C	Revised QR 13, Monitor and control of responding Corrective Action from suppliers	7-10-2018	Thang Le