



SUPPLIER QUALITY ASSURANCE REQUIREMENTS
SQAR 840

QA-100 General Requirements

(QA-101) Form X31764 Quality Purchasing Data Requirements (BCA/BGS) – Applicable to Boeing Commercial and Boeing Global Services Programs, in support of Boeing PC700 Production Certificate, as noted in special instructions on face of purchase order. Form X31764 and the requirements therein are to be consumed by supplier and flowed down in its entirety in all supplier contracts. Form X31764 is available at the following location: <https://www.boeingsuppliers.com/X31764.pdf> This clause incorporates BCA PO note Q29 and D6-87282.

(QA-102) Right of Entry - King Machine, its customer or regulatory agencies shall be afforded the right to review and verify that subcontracted products, processes, and records conform to specified requirements. Verification by King Machine, its customer or regulatory agency does not absolve the supplier of the responsibility to provide acceptable product, nor does it preclude subsequent rejection by King Machine or its customer.

(QA-103) Non AS9100 Suppliers - Supplier shall provide and maintain an inspection system which will assure that all delivered products conform to Purchase Order requirements, whether manufactured or processed by the supplier or a sub-tier supplier. Supplier shall maintain controls and perform all inspections and tests required to substantiate product conformance requirements.

(QA-104) AS9100 Suppliers - The supplier will as a minimum maintain a documented quality system that meets the requirements of AS9100. The Supplier's Quality Assurance function shall be clearly designated within the Supplier's Organization. Personnel having the responsibility for the quality of product shall have sufficient authority to assure that quality is not compromised. The Supplier's Quality Assurance System shall be implemented by written procedures that adequately provide for compliance with the requirements of King Machine Purchase Order. The Supplier shall notify King Machine whenever there is a significant change to their Quality Assurance System, i.e., gaining or losing any NADCAP approvals, gaining or losing any FAA or governmental operating approvals, or gaining or losing any Quality System registration or certification.

(QA-105) Control of Quality Records by King Machine Suppliers - Supplier must maintain all quality records indefinitely. Records related to this order include, but are not limited to, proposal, procurement, specifications, production, test, inspection, quality, shipping, export and financial. Records related to King Machine shall not be destroyed without written approval from King Machine. King Machine will either approve of the destruction or request delivery of such records. In the event King Machine chooses delivery of the records, Seller shall promptly deliver such records to King Machine at no additional cost in a format agreed to by both parties.

(QA-106) Supplier Assistance - If Purchase Order requirements are not completely clear, or where special assistance is needed, King Machine will provide qualified personnel to consult with Supplier. Requests for assistance shall be made to King Machine Purchasing Department. If inquiries pertain to quality aspects of products or services, King Machine Quality Assurance Organization may be contacted directly.

(QA-107) Supplier Audits - King Machine may conduct periodic audits of the Supplier and/or their sub-tier Supplier's Quality system, to evaluate their ability to comply with King Machine requirements. As necessary, King Machine Customer may accompany King Machine Quality representative in such audits.

(QA-108) Government Inspections - Materials and/or components supplied under the terms of this Purchase Order may be utilized in equipment which has been or will be subject to Federal Government approval, including Federal Aviation Administration (FAA). The Suppliers Quality system, and the Quality system of any sub-tier Supplier, is therefore subject to surveillance by authorized representatives of the US Government and/or the FAA. The Supplier shall provide all reasonable facilities and assistance to the authorized representatives upon request.



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(QA-109) Nonconforming Product Produced by Supplier - The supplier must notify King Machine of nonconforming product or processes prior to delivery. All parts dispositioned by a supplier as scrap will be sorted 100% for the defect that is discrepant. Also, all parts that have been dispositioned as scrap must be identified with a discrepant part tag or other means of identification. The supplier must obtain approval from King Machine Quality / Purchasing for nonconforming part disposition.

(QA-110) Production or Process Changes - The supplier must notify King Machine of any changes in the product or process used in the manufacture of product for King Machine. King Machine reserves the right for approval of the product, the parts used, the materials used, and equipment used by the supplier in fulfilling King Machine Purchase Order requirements. This includes changes of suppliers, manufacturing and / or processing facility locations or additional facilities. These changes may require King Machine approval depending upon the change.

(QA-111) Nonconformance Disposition of Supplied Discrepant Parts - If nonconforming parts or processes are found during inspection at King Machine the supplier will be contacted and will have 14 days to respond to the discrepancy by coming to King Machine to re-inspect, or King Machine may, at their discretion, return the parts to the supplier for inspection.

(QA-112) Notice of Escapement / Disclosures - King Machine suppliers shall provide a written notification of nonconformities that may have affected parts or services delivered to King Machine within 48 hours of the realization of the escapement. Safety or Critical designated items require immediate notification. The King Machine purchasing agent will be notified and the discrepancy documentation must include a clear and concise description of the discrepancy which includes as a minimum; part number, purchase order number, quantity and the date the parts were delivered to King Machine. Also, immediate corrective action / containment as well as the root cause and corrective action must accompany the discrepancy documentation submitted to King Machine.

(QA-113) Quality System Documentation - The supplier shall assure that the latest revisions status of applicable drawings, specifications, technical requirements, as specified on King Machine Purchase Order, are available at the Supplier's facility.

(QA-114) Subcontracting without Written Approval - Subcontracting all or substantially all the order without written consent of King Machine Quality or Purchasing is prohibited.

(QA-115) Subcontractor Flow Down and Work Transfer - If any portion of the order is subcontracted, it is the responsibility of the supplier to flow down to the supply chain the applicable requirements, including customer requirements. Seller shall ensure its supply chain shall not, initiate a movement or transfer of the location for the work to be performed under this Contract to another facility without Buyer's prior written approval.

(QA-116) Supplier Awareness - King Machine suppliers shall ensure that their workforce is aware of their contribution to product conformity, product safety, and the importance of ethical behavior.

(QA-117) Supplier Performance - King Machine suppliers are expected to continuously perform at a high level and will be periodically monitored in the areas of product quality and on-time delivery performance. King Machine's acceptable ratings for quality and delivery are Quality 99% and Delivery 96%.

(QA-118) Foreign Object Damage (FOD) - Seller shall maintain a FOD Prevention Program in accordance with Aerospace Standard AS9146, Foreign Object Damage (FOD) Prevention Program - Requirements for Aviation, Space, and Defense Organizations. Whenever or wherever Foreign Object Debris (FOD) can be entrapped or Foreign Objects (FO) can migrate, Seller shall ensure the requirements of this clause are flowed down to Seller's subcontractors at every tier.



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(QA-119) Calibration Services - Sellers of calibration services shall meet the requirements of ANSI/NCSL Z540.1, ISO/IEC 17025 or equivalent standard. Calibrations performed shall be traceable to NIST or other recognized international standards.

(QA-120) Protection of Parts against Contamination or Damage - The parts must be boxed, banded, or shipped in a manner that will ensure that no damage will occur.

(QA-121) Acceptance Authority Media - a) Seller shall comply with the AS/EN/JISQ 9100 requirements and 14CFR Part 21.2 regarding the application of the Acceptance Authority Media (AAM) requirements. b) Seller shall, within its organization and its supply chain, ensure that the use of AAM is clearly defined within its Quality Management System (QMS). c) Seller shall, upon request, be able to demonstrate evidence of communication to its employee and to its supply chain; use of AAM must be considered as a personal warranty of compliance and conformity. d) Seller shall maintain compliance to the AAM requirements by assessing its process and supply chain as part of its internal audit activities.

Additional Requirements

- **QA-200 King Supplier – Manufacturing (Page 3-4)**
- **QA-300 King Supplier – Processing (Page 4-5)**
- **QA-400 King Supplier – Raw Material, Hardware, Components, Sealants (Page 5)**

QA-200 King Supplier – Manufacturing

(QA-201) Certifications - Suppliers must submit with each shipment a certificate of conformance stating that all manufacturing and inspections comply with the applicable engineering and purchase order requirements. The seller must provide a statement on the packing sheet certifying its quality assurance department has inspected the parts and they adhere to all requirements, applicable drawings/specifications. Material and processing certifications must be supplied to King Machine if parts were purchased by King Machine complete. QA-400 codes also apply to manufacturers supplying Raw Material, Hardware, Components, Sealants, etc.

(QA-202) First Article (Reference BCA PO note Q48) - AS9102 (latest revision) first article inspection is required. The first article shall consist of 100% verification and documentation showing compliance with the King Machine supplied engineering, including dimensional and functional data of each item manufactured and supplied to King Machine. FAIs required as a result of a change or lapse in production will be conducted as FULL FAIs unless otherwise agreed upon with King Machine QA. Unless otherwise approved by King Machine, First Article Inspection Reports (FAIRs), including delta/partial FAIs, are to be documented and submitted to the customer "KING MACHINE INC - MUKILTEO" via web based Net-Inspect software (<http://www.net-inspect.com/>) prior to shipment of all first article parts. Supplier shall attach FULL/partial FAI supporting documentation (material/processing certs, work orders, bubbled drawings/parts lists/specifications, CMM or other inspection data, etc.) as applicable. Do NOT submit FAIRs directly to the end item customer in Net-Inspect. Contact King Machine Quality for alternate submittal methods and approval.

(QA-203) Statistical Process Control - Statistical process control may be required and shall be implemented as defined by the King Machine Purchase Order. The supplier shall contact King Machine Buyer prior to manufacturing to arrange a meeting to define the required key or special characteristics affected.



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(QA-204) In-Process Inspection - In-Process inspection may be required by King Machine. When this is required, the specific inspection point in the process will be specified on the purchase order. The supplier will contact King Machine and hold the material for in-process inspection by King Machine Quality.

(QA-205) Product Sampling - Sampling plans and procedures written to AS9138 may be used upon submission to and approval by Buyer's Quality Assurance. With the exception noted herein. Seller's statistical sampling procedure/plan conformance to AS9138 with minimum protection levels meeting SAE AS9138 Table A1 and C=0 will constitute Boeing Quality approval subject to restrictions noted in AS9138, Section 4.3 Safety/Critical Characteristics, and part/product Design Data sampling requirements and/or prohibitions. Purchase Order specific requirements for 100% inspection override the use of an approved sampling inspection.

(QA-206A) Digital Data Sets - When digital data is provided to the supplier as a manufacturing aid, Supplier's Quality system shall assure that the configuration management and media security are handled in accordance with Boeing Document D6-51991 or equivalent. All datasets provided for the purposes of bidding, and marked "Preliminary," shall be discarded upon bid completion.

(QA-206B) DPD/MBD - When digital data is provided to the supplier the supplier will provide SQAR 840-2 Supplier Quality Questionnaire Form, section 16 along with documented DPD processes, CATIA synchronization (D6-51991 or equivalent), CAD, CAM, CAI, CMMS/PAS Software (software/equipment list) and CMMS equipment, provide OEM approval evidence and inform King Machine of revisions or changes.

(QA-207) King Machine Supplied Drawings and PCM's - All drawings / PCM's or other Engineering media provided to a supplier must be returned with the order upon completion.

(QA-208) King Machine Furnished Material - Heat lot traceability must be maintained by the supplier when the material is supplied by King Machine. No heat lot substitution or co-mingling of heat lots is allowed unless written permission is granted by King Machine.

(QA-209) Operator Self-Verification programs: - If seller uses an operator self-verification program, seller shall comply with the requirements set forth in SAE industry standard AS9162. "Aerospace Operator Self Verification Programs," as may be amended from time to time. Buyer reserves the right to conduct surveillance at Seller's facility to determine that the Seller is compliant to the requirements of AS9162.

QA-300 King Supplier – Processing

(QA-301) Nadcap Approval - Suppliers must be Nadcap approved for all chemical processing, heat treating, welding, non-destructive testing and all other processes required by King Machine customers.

(QA-302) King Machine Customer's Approved Processors - All Heat Treat, NDT, Welding and Coatings subcontracted by King Machine must be performed by a King Machine Customer Approved Processor. The supplier is responsible for verifying their approval status prior to any processing being performed.

(QA-303) ITAR Requirements - "In entering into any agreement with King Machine, relating to the manufacture of defense articles or the provision of defense services, the Subcontractor (or Supplier) warrants to King Machine that it has registered as a defense manufacturer with the Department of State, Directorate of Defense Trade Controls, as required by ITAR 122.1."

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(QA-304) Certifications - Processing certifications must reference all relevant processes performed, specifications and revisions of the processes completed. The seller must provide a statement on the packing sheet certifying its quality assurance department has inspected the parts and they adhere to all requirements, applicable drawings/specifications.

(QA-305) Specifications - The Supplier must meet the requirements of all specifications referenced on drawings or on the purchase order. Current revision level, and all applicable specification departures will be included with the purchase order as attachment QF 840-1 Special Process Specs and PSD's.

QA-400 King Supplier – Raw Material, Hardware, Components, Sealants

(QA-401) Certifications - A Supplier Certificate of Conformance is required with each shipment to King Machine including the applicable heat lots and chemical and physical analysis / test reports. The C of C must state the material type, the material temper, and that the material meets the applicable specifications and revisions of the material specification procured by King Machine. The seller must provide a statement on the packing sheet certifying its quality assurance department has inspected the parts and they adhere to all requirements, applicable drawings/specifications.

(QA-402) Preference for Domestic Specialty Metals - When a line item on a King Machine purchase order has the part number identified as XXX-DFARS the supplier agrees to comply with Defense Federal Acquisition Regulation Supplement DFAR 252.225-7014 (Alt. I), Preference for Domestic Specialty metals when this clause is specified in the purchase order. Use of foreign specialty metals may only be made with the written authorization from King Machine. Note: Country of melt must be identified on certification.

(QA-403) King Machine Customers Approved Manufacturers - All Suppliers of materials, hardware, components, sealants / adhesives, etc., where applicable, must be on the current approval listings of King Machine Customers. The supplier is responsible for verifying their approval status prior to the manufacture of these goods. Examples include but are not limited to QPLs and D1-4426.

(QA-403) Shelf Life - The date of manufacture must be noted on each individual container and / or certification. Sealants / adhesives and adhesive tapes must have at least 80% of shelf life available upon receipt at King Machine or it will be returned to the supplier.

(QA-404) Counterfeit Parts/Materials Prevention - All Suppliers of materials, hardware, components, sealants / adhesives, etc., procured for the purpose of incorporation into deliverable fly-away parts by King Machine, shall establish and maintain a counterfeit parts/materials control plan to ensure counterfeit parts/materials are not delivered to King Machine.

(QA-405) MATERIAL SUBSTITUTION PROHIBITION - BDS T&C D607 ([Section D - Material](#)) Substitution of materials is prohibited for all suppliers OM (Outside Manufacturing) of raw materials. King Machine will review requests on a case-by-case basis when required.



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REVISION SUMMARY			
REV	DATE	REVISED BY	COMMENT
N	6/14/2024	TMO	Added QA-119. CAR 20240531-01. QA-202 added FULL FAI clarification for production change or lapse in production. Added Revision Summary. Moved QA-205 to QA-120 (General). QA-101 added "BCA PO note Q29 and D6-87282". QA-403 added "QPLs and D1-4426.". Added QA-205 Sampling, QA-209 OSV and QA-121 AAM.
P	3/17/2025	TMO	Added 206B, 206A was 206. Clarified DPD/MBD Approval and supplier responsibility to communicate equipment (CMMS and Software) and procedural revisions to King Machine. QA112 added "immediate" notification for safety or critical designated items. Added QA-405 MATERIAL SUBSTITUTION PROHIBITION for OM and material suppliers. QA-201 added reference to QA-400 codes.