



## AS9100D Supplier Flow Down Requirements

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The Supplier requirements below apply to all Suppliers and sub-tier Suppliers to United CNC Machining providing raw materials, calibration services, manufactured components and products as well as performing material processing such as, but not limited to: heat treating; non-destruction and destructive testing; coatings; paintings; liquid penetrants; welding; and nonconventional machining processes. Acceptance of a Purchase Order from United CNC Machining binds the Supplier to the Terms and Conditions listed in the Purchase Order and the requirements listed in this document. The Supplier is not authorized to outsource any portion of the Purchase Order requirements unless specifically authorized by United CNC Machining and must flow down these requirements to any sub-tier Suppliers. Note that these requirements correspond with the requirements of United CNC Machining's customers and with the requirements of AS9100D, Clause 8.4.3.

**a. the processes, products, and services to be provided including the identification of relevant technical data (e.g., specifications, drawings, process requirements, work instructions)**

Refer to United CNC Machining's Purchase Order for this information.

**b. the approval of: products and services; methods, processes, and equipment; the release of products and services;**

Each shipment must be accompanied by one legible copy of a statement of conformance unless otherwise noted in the Purchase Order. A certificate of conformance (C of C) or certificate of analysis (C of A), supplied with the shipment must provide at a minimum: Supplier name, part number, purchase order number, quantity of parts, Planning-Engineering revision, serial numbers (if applicable), and title and signature of authorized Supplier representative.

- Material certifications shall show quantitative analysis of each element and physical testing as required by specifications referenced. Certifications must reference all related specifications required by a drawing and list full chemical/physical properties and source.
- Certification of heat treatment must show the type of treatment and specifications, hardness range, percentage of parts tested, tensile test results (as applicable by part), type of test performed, specifications and any other information required by the drawing/specifications. A laboratory performing a test shall be identified and any certifications signed by tester. Name of Heat Treat Supplier must be shown.
- Passivation Certificate of Conformance must reference the process specification used. Magnetic Particle Inspection/Penetrant Inspection Certificates shall reference specifications used, number of pieces tested, with results and signed by a certified tester and must indicate level to which it is certified.

**c. competence, including any required qualification of persons;**

Supplier will ensure that employees and people working on its behalf are competent and trained in accordance with the requirements of AS9100D, where applicable.



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**d. the Supplier's interactions with United CNC Machining;**

In addition to the other requirements recorded within this document, Suppliers shall hold all information received from United CNC Machining in confidence and no third-party request for information will be authorized unless approved, in writing, by United CNC Machining.

**e. control and monitoring of Supplier's performance to be applied by United CNC Machining;**

United CNC Machining will score Suppliers based on Quality and/or delivery. Suppliers will be issued corrective actions as needed. Supplier performance will be reviewed monthly by the Purchasing Manager and Plant Manager. Suppliers that fail to perform in these areas may be considered for evaluation and/or removal from United CNC Machining's approved supplier list.

**f. verification or validation activities that United CNC Machining, or its customer, intends to perform at Supplier's premises;**

United CNC Machining and its customers reserve the right to perform verification and/or validation activities at the Supplier's premises.

**g. design and development control;**

Design and development control does not apply to United CNC Machining Suppliers.

**h. special requirements, critical items, or key characteristics;**

As per the requirements of AS9100D, Supplier is responsible for the validation, and periodic revalidation, of the ability to achieve planned results of the processes for production and service provision, where the resulting output cannot be verified by subsequent monitoring or measurement.

**i. test, inspection, and verification (including production process verification);**

For calibration Purchase Orders, all gauges and instruments must be calibrated using standards whose accuracies are traceable to the National Institute of Standards and Technology. All provided calibration certifications must specifically state this traceability. Supplier will maintain a quality/inspection system that will ensure all goods and services conform to contract requirements whether manufactured or processed by Supplier or procured from Sub-Tier Suppliers and that fully complies with the requirements of AS9100D.



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**j. the use of statistical techniques for product acceptance and related instructions for acceptance by United CNC Machining;**

The Supplier will use a sampling plan, consistent with typical industry standards, unless otherwise specified or agreed upon in writing by United CNC Machining.

**k. the need to:**

- **implement a quality management system.**

When specifically requested by United CNC Machining in writing, Supplier will maintain a quality system in compliance to recognized Quality Management Systems and/or approved by United CNC Machining.

- **use customer-designated or approved external providers, including process sources (e.g., special processes);**

When required by United CNC Machining or by United CNC Machining's customers, Suppliers will use customer-specified sources.

- **notify United CNC Machining of nonconforming processes, products, or services and obtain approval for their disposition;**

United CNC Machining will not accept Supplier product that does not meet Planning - Engineering drawing and/or Purchase Order requirements. Supplier product discovered after shipment by the Supplier to be nonconforming to any Planning-Engineering drawing and/or Purchase Order requirement shall be immediately disclosed to United CNC Machining upon discovery, including but not limited to quantity shipped, date shipped, and the extent of the nonconformance. Suppliers that receive notification of Nonconforming product shall take appropriate action to contain the nonconforming condition and prevent it from occurring again. The Supplier will be notified if formal Corrective Action is required to be submitted to United CNC Machining. The response shall be submitted within 1 week of issue or a time frame agreed upon between United CNC Machining and the Supplier. Errors with paperwork shall be resolved within 24 hours.

- **prevent the use of counterfeit parts (see 8.1.4);**

To prevent the purchase of counterfeit or suspect / unapproved products and to ensure product identification and traceability (and for other reasons), Supplier will institute controls that include the requirement of Material Certificates, Certificates of Conformity, and/or other supporting documentation as is appropriate. Material and part substitutions are not allowed.



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- **notify United CNC Machining of changes to processes, products, or services, including changes of their external providers or location of manufacture, and obtain United CNC Machining's approval;**

Supplier will notify United CNC Machining of any change in ownership, management, or location and are subject to re-survey and approval. Supplier will notify United CNC Machining of any product or process changes or changes in approval status that affect United CNC Machining's product and are subject to re-survey and approval.

- **flow down to external providers applicable requirements including customer requirements;**

Suppliers shall flow-down to Sub-Tier Suppliers the applicable requirements as required by the purchase order either specifically or by reference.

- **provide test specimens for design approval, inspection/verification, investigation or auditing;**

When requested by United CNC Machining or its customers, Supplier will provide test specimens for inspection/verification, investigation and/or auditing purposes.

- **retain documented information, including retention periods and disposition requirements;**

Unless otherwise specified on the Purchase Order, the latest specification revision in effect at the time the lot of raw material/parts was originally manufactured or processed shall apply. In the event a document has been superseded, the latest revision of the superseding document shall apply. All certifications, test reports, and inspection reports, as well as receiving inspection, in-process inspection, final inspection, and calibration records shall be retained for a minimum of five years, unless otherwise specified by United CNC Machining. These records will be made available to United CNC Machining, United CNC Machining's customers, or regulatory agency upon request.

- I. **the right of access by United CNC Machining, United CNC Machining's customer, and regulatory authorities to the applicable areas of facilities and to applicable documented information, at any level of the supply chain;**

United CNC Machining and United CNC Machining's customers reserve the right to perform an on-site inspection of the Supplier's facility or visit the facility. United CNC Machining will give reasonable notification to the Supplier prior to the on-site inspection. The on-site inspection may include surveillance of the Supplier's facilities, procedures, production methods, processes, and the Supplier's Quality System. The Supplier shall furnish, at no cost, the necessary data as required by



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applicable drawings, Purchase Order, specifications, and inspection instructions to facilitate the on-site inspection.

**m. ensuring that persons are aware of: their contribution to product or service conformity; their contribution to product safety; the importance of ethical behavior.**

Supplier must be committed to the highest standards of ethics and business conduct. Supplier must comply with the law, honor commitments, act in good faith, and be accountable. Supplier must strive to maintain full compliance with all laws and regulations applicable to the operation of the business and customer relationships. Supplier must not offer, promise, authorize, or provide, directly or indirectly, anything of value (including business gifts or courtesies) with the intent or effect of inducing anyone to engage in unfair business practices. Supplier will avoid involvement in activities that may be perceived as a conflict-of-interest. Supplier will respect the legitimate proprietary rights and intellectual property rights of customers and Suppliers and take proper care to protect sensitive information, including confidential, proprietary, and personal information. Supplier will support product safety by ensuring robust management of special requirements, critical items and key characteristics. If there are concerns with respect to product safety, Supplier will communicate them to United CNC Machining. If there is a concern at the Supplier's premises with respect to safety during the manufacture of the product, Supplier will notify its own employees of the concern and whenever possible, mitigate the concern.

Supplier will ensure that employees and people working on its behalf are aware of:

- Their contribution to product or service conformity
- Their contribution to product safety
- The importance of ethical behavior

**n. export control requirements for Digital Product Definition**

Suppliers shall comply with ITAR, MLA, MA, TAA, and EAR requirements when they are identified in the purchase order and/or the Engineering. Suppliers shall flow-down this requirement to their sub-tier suppliers.



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### Revision History Supplier Flow Down Requirements (QP-489)

Revision Date	Revision
01.06.2022	- Implemented QP system instead of QF Forms
06.01.2022	- Double checked all information to ensure it's current.
06.02.2023	- Added bullet points and numbers. - Simplified the whole AS9100D Supplier Flow Down Requirements Process
07.28.2023	- Process Engineering and Engineering changed to Planning
03.27.2025	- Added section n to comply with Boeing spec D6-51991.
04.01.2025	- Revising section n per auditor feedback.