



Tyee Aircraft
Supplier Quality Assurance Requirements
(SQAR-001)

(QC-1) *Inspection Systems* - The supplier will as a minimum maintain and implement a documented inspection system that meets the requirements of AS9003. This system is subject to review by Tyee Aircraft Quality.

(QC-1A) *Quality System*- The supplier will as a minimum maintain a documented quality system that meets the requirements of ISO9001:2008

(QC-1B) *Quality System*- The supplier will as a minimum maintain a documented quality system that meets the requirements of AS9100.

(QC-1C) *Special Processor Requirements* – Nadcap approval is required for any special processes specified in the www.eaudit.net QML / Commodities website.

(QC-2) *Certifications* - A certificate of conformance shall accompany each shipment.

(QC-3) *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 its shelf life available upon receipt at Tyee or it will be returned to the supplier.

(QC-4) *First Article* - First article inspection is required. First article shall consist of 100% verification of compliance to the Tyee drawing, including dimensional and functional data. This FAI must be verified by Tyee Quality prior to the manufacture of the balance of the purchase order.

(QC-5) *Source Inspection* - Source inspection is required by Tyee Quality. Supplier must contact the Tyee Quality Manager prior to all shipments to Tyee.

(QC-6) *Inspection* - 100% visual inspection is required with documented evidence presented with each shipment. This evidence will be shown through an inspection check or equivalent with the method stated as “visual”.

(QC-7) *Statistical Process Control* - Statistical process control is required and shall be implemented on this order as defined by the Tyee Process Improvement Coordinator. The supplier shall contact the process improvement coordinator prior to manufacturing to arrange a meeting to define the required key or special characteristics affected.

(QC-8) *In-Process Inspection* - In process inspection is required by Tyee. When this is required, the specific inspection point in the process will be specified on the purchase order. The supplier will contact Tyee and hold the material for in-process inspection by Tyee Quality.



Tyee Aircraft
Supplier Quality Assurance Requirements
(SQAR-001)

(QC-9) *Frozen Planning* - Upon acceptance of the first article, the supplier shall make no changes to the method of manufacture, equipment used, materials, or processes which may affect interchangeability, function, dimensions, performance, or finishes. All changes must be approved by Tyee Quality or Engineering.

(QC-10) *Production Parts Approval* - Prior to production start-up, the supplier shall produce limited quantity (as specified on the purchase order) of pieces to confirm consistency of quality and performance. This information will be flowed to the supplier either through a drawing or will be noted on the purchase order. No revision to the tooling, programming or inspection can be done without Tyee consent.

(QC-11) *Procedure and Approval* - The supplier must submit for review and approval, detailed test and inspection method, which will be used to ensure that the requirements of this order have been satisfied. This information shall include the procedures and identification of the description of the equipment to be used.

(QC-12) *Parts identification* - All parts must be identified with the drawing number and vendor number. The manner and location of this identification shall be agreed upon by Tyee Engineering and or Tyee Quality.

(QC-13) *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. External threads must have special protection against damage.

(QC-14) *Right of Entry* – Tyee, its customer or regulatory agencies shall be afforded the right to verify that subcontracted product conforms to specified requirements. Verification by Tyee, its customer or regulatory agency does not absolve the supplier of the responsibility to provide acceptable product, nor does it preclude subsequent rejection by Tyee or its customer.

(QC-15) *Subcontracting without Written Approval* - Subcontracting all or substantially all of the order without written consent of Tyee Quality or Engineering is prohibited.

(QC-16) *Nonconformance Disposition and Review* – All parts dispositioned by a Tyee 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.



Tyee Aircraft
Supplier Quality Assurance Requirements
(SQAR-001)

(QC-16A) *Tyee Nonconformance Disposition of Supplied Discrepant Parts* – If nonconforming parts or processes are found during inspection at Tyee the supplier will be contacted and will have 48 hrs to respond to the discrepancy by coming to Tyee to re-inspect and or if Tyee decides to return the parts to the supplier for inspection. Tyee also has the option to not return the parts to the supplier and debit the supplier for the costs associated with the discrepancy.

(QC-16B) *Notice of Escapement / Disclosures* – Tyee’s supplier shall provide a written notification of nonconformities that may have affected parts or services delivered to Tyee within 48 hours of the realization of the escapement. The Tyee buyer / 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 Tyee. Also, immediate corrective action / containment as well as the root cause and corrective action must accompany the discrepancy documentation submitted to Tyee.

(QC-16C) *Tyee Customer’s Approved Processors* – All Heat Treat, NDT and Coatings subcontracted by Tyee must be performed by a Tyee Customer Approved Processor. Tyee’s supplier is responsible for verifying their approval status prior to any processing being performed. Tyee’s customers name and PO number is referenced on all Tyee processing purchase orders for this approved process verification.

(QC-17) *Delegated Source Program* – All suppliers that have been selected by Tyee quality to be a part of the Tyee Delegated Source Program must follow the requirements stated in Tyee procedure WI-6.4. No deviation to this procedure is allowed unless agreed upon by Tyee quality.

(QC-18) *Suppliers of Electronic Components*– Suppliers of electronic components to Tyee must submit a certificate of conformance showing configuration with actual values obtained during testing referenced by serial number with each shipment.

(QC-19) *Independent Testing* – Suppliers of independent inspection and validation testing are required to perform the process or service per the documentation provided by Tyee Aircraft. This documentation may include but is not limited to, specifications, engineering drawings and qualification test procedures (QTP).

(QC-20) *Control of Quality Records by Tyee Suppliers* – Tyee suppliers used for processing and machining or any service procured that affects product conformity must maintain on file all quality records showing conformance to Tyee purchase order requirements for a minimum of 7 years.



Tyee Aircraft
Supplier Quality Assurance Requirements
(SQAR-001)

(QC-21) Preference for Domestic Specialty Metals – When a line item on a Tyee 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 Tyee Aircraft.
Note: Country of melt must be identified on certification.

(QC-22) Approved Raw Material Suppliers per 299-100-837 – Raw materials supplied per this quality code must be approved by Bell Helicopter specification 299-100-837 for use in Tyee manufactured parts. (See attached file for approved sources [Bell Approved Raw Material Suppliers](#)).

Revision History

<i>Revision</i>	<i>Date</i>	<i>Description</i>
A	12/01/00	Original Issue
B	6/13/02	Added (QC-18)
C	7/17/03	Revised (QC-14) to include regulatory agencies.
D	12/16/03	Added (QC-19) Independent testing requirement and revised (QC-10)
E	1/8/04	Added (QC-20) Control of Quality Records by Tyee Suppliers
F	9/16/06	Added (QC-21) Preference for Domestic Specialty Metals Clause.
G	11/15/06	Revised (QC-1) and added (QC-1C) Special Processor Requirements.
H	12/1/07	Revised (QC-21) to identify DFAR part number requirements.
I	1/13/09	Revised (QC-3) shelf life requirement of 80% upon receipt.
J	1/6/2010	Added (QC-16A) Disposition of Suppliers processed parts, (QC-16B) Notice of Escapements / Disclosures and (QC-16C) Tyee customer approved processors.
K	12/17/10	Added (QC-22) Requiring raw material to be procured from sources approved by Bell Helicopter per 299-100-837.