

## REQUIREMENTS FOR SELLERS OF SPECIAL TOOLS

Sellers of special tools are responsible for the following:

1. Establish and Maintain Inspection System

Establish and maintain an inspection system ensuring the following:

- a. Latest models, drawings, and specifications are used
- b. All materials are acceptable.
- c. Metrology and test equipment is calibrated to standards traceable to the National Institute of Standards Technology (NIST).

Note: The Seller's inspection system is subject to periodic audit by the Buyer. Buyer reserves the right to conduct surveillance at the Seller's facility to determine whether the Seller's inspection system meets the requirements of this clause.

2. Pre-Plan the Inspection Process with Buyer's Quality Representative

Pre-plan the in-process and final inspection process with the Buyer's Quality representative, including the following:

- a. Determine which critical dimensions and requirements will not be accessible for verification-by Buyer's Quality representative during final inspection.
- b. Together with Buyer's Quality representative, jointly plan the in-process and final inspections.
- c. Ensure that tests, such as load, pressure, functional, and so forth, are planned to include verification and witness by Buyer's Quality representative.
- d. Provide a minimum of 72-hours advance notification of a pending inspection requiring Buyer's Quality representative witness.
- e. When practical, plan for Buyer's Quality representative inspections to be done during one visit.

3. Submit Computer-Aided Metrology Systems (CAMS) Inspection Plan

When CAMS data will be used for proof of configuration to specifications and requirements, submit a Computer-Aided Metrology System (CAMS) Inspection Plan (see D658-10024-1) to Tooling Quality Engineering (TQE) (by e-mail) for review and approval no less than two weeks before submittal for Buyer acceptance of the tool. Send e-mail requests for the inspection plan format and submittal process to:

[ISDS.TQA@BOEING.COM](mailto:ISDS.TQA@BOEING.COM).

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4. Provide Readiness Review (Concurrent Engineering and Fabrication Coordination)

When requested by the program, conduct a readiness review according to program requirements with Buyer's Quality representative.

5. Ensure Inspection Requirements are Met

Perform 100% inspection of tools, before Buyer's final verification/inspection, including the following:

- a. For non-designed tools, ensure that dimensions are according to the latest revision of the engineering (production) models, drawings, and specifications.
- b. For designed tools, inspect to the dimensions, process specifications, material, purchased items, and so forth of the latest revision of the tool model and/or drawing.
- c. Record, stamp, and date all "as-built" dimensions and/or processes on data sheets, inspection records, or a copy of the tool drawing (suitable for reproduction), or on computer printouts traceable to the tool, tool models, and/or drawing(s).
- d. Ensure that all tests such as load, pressure, functional, and so forth are verified by Buyer's Quality representative.
- e. Create a complete package of inspection records, including applicable certifications, all test results such as load test, pressure, functional, and so forth and the Seller's certificate of conformance for final inspection by Buyer's Quality representative.

6. Identify, Document, and Report Problems

Identify, document, and report all problems to Buyer's authorized procurement representative for resolution before final acceptance.

7. Ensure Tool Identification

Ensure that Buyer's Quality representative has verified that all primary and secondary property identification is properly marked according to D33181, *Boeing Tooling Procedure Standards*, and/or customer specifications and requirements, according to the contract, drawing, and statement of work.

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8. Provide Complete Data Package at Final Inspection

Provide a complete copy of the inspection records package, including applicable certifications, all test results such as load test, pressure, functional, and so forth and the Seller's certificate of conformance at final inspection by Buyer's Quality representative.

9. Ensure Evidence of Seller's Completion and Buyer's Final Acceptance

Ensure evidence of Seller's completion and Buyer's final acceptance of the tool as follows:

- a. Buyer Quality representative signature, inspection stamp, and date on Seller's shipper.
- b. Buyer Quality representative stamp and date on the tool.

10. Provide Shipping/Receiving Inspection

To ensure accountability for the condition of the tooling materials or tools before and after shipping, perform shipping/receiving inspection of Buyer-provided tooling materials or tools upon receiving them from Buyer, and before shipping them to Buyer.