

# What's New with IR 0451 (2025 Revision)?

The 2025 revision of IR 0451 "Instructions for Submittal and Handling of External Nonconformance Documents" has been posted on the BoeingSuppliers.com website.

Revision bars were not used but technical changes were made to the following sections:

1. Para. 1.1.3 – added to remind suppliers to follow the correct process for returned product.
  - a. This continues to be a source of error with suppliers not following the provided disposition or the NOR process (Para 11).
  - b. Suppliers who do not follow the provided disposition or the NOR process will receive Correct Actions and additional surveillance audits
2. Para. 2.3.3 – added to clarify requirements on incorporating nonconforming product into other parts / assy.
3. Para. 2.6 – added to provide instructions for build to Boeing print suppliers to request Pre-Production Variance (PPV).
4. Para. 2.31 – new section to provide instructions on submitting a Pre-Production Variance (PPV).
5. Para. 4.1 – added flow chart for Notice of Revision (NOR)
6. Para. 5.1.1 – added Supplier Tip Sheet (already posted on the website) with an updated NCR Discrepancy Submission Checklist.
7. Para. 11.4 – added to provide clarification on expectations for supplier shipment of returned parts.
8. Para. 13.20 – added Definition for Pre-Production Variance (PPV).
9. Helpful Websites to bookmark:
  - a. IR0451 and attachments - [https://www.boeingsuppliers.com/supplier\\_portal/bdsSiteReqs.html](https://www.boeingsuppliers.com/supplier_portal/bdsSiteReqs.html)
  - b. BDS Common Purchase Contract Clause Text - [https://www.boeingsuppliers.com/idscommon/cclauses/clause\\_index.htm](https://www.boeingsuppliers.com/idscommon/cclauses/clause_index.htm)
10. Helpful Hints:
  - a. SQIS web browsers are Firefox (preferred) and Edge.
  - b. MAC861MRB – this is a XFA form and Edge will not open directly but will allow you to right click and "Save Link As" and save the file to a folder / desktop.
  - c. When submitting files thru Message Courier, you will receive a notification regarding the email addresses not found in the directory. This is not an error. Select "Done" to submit the message.