

Common Commodity Requirements
Purchase Order Processing Information Flow Down

Required Information (Always)

1. Purchase order number and date issued
2. Purchase order originator name and address
3. Purchase order originator contact person and method of contact
4. Processor name and address
5. Part number and part name, or product form description of each item
6. Quantity (of each item)
7. Boeing program or site
8. Model of craft
9. Processing specification, specific revision level, and all applicable engineering departures (such as PSDs & SPEOs)
10. Present material condition (Examples: as machined and deburred, as cast, as straightened, as machined and etched, stress relief status or need, etc.)
11. Processor must be, and/or use D1-4426 approved sources
(<http://www.boeingsuppliers.com/d14426/>)

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-Required Information (When Applicable, defer to spec/drawing)

1. Processor certificate of conformity/test data requirements (as required by contract and or specification)
2. Test methods and specimens
3. Test sampling
4. Test location
5. Pre and post processing (cleaning, stress relieve, etc.) to be performed by the processor
 - a. List processing specification, its revision level, and all applicable departures (e.g. PSDs)
 - b. Define the processing requirements detail
6. Frozen (Fixed) Process Document and Revision (for example D6-1276, SMPP, ...)
7. Approved exceptions to requirements
8. Part serial numbers
9. Shipping location (if other than originator address)
10. Special Conditions:
 - a. Handling (part protection, customer property or tooling)
 - b. Handling (personnel protection)
 - c. Surface Condition (Any special surface finish requirements)
 - d. Engineering instructions
 - e. Fixturing or Tooling required
 - f. Dimensional/tolerance requirements and measuring methods
 - g. Packaging
 - h. Documentation required with shipment
11. Due date

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Processes Not Required To Be Performed

1. Pre and post cleaning/processing (stress relieve, etc.)
2. Visual inspection and/or nondestructive testing
3. Other inspection or testing requirements

Unique Heat Treating Requirements
Purchase Order Processing Information Flow Down
Required Information (Always)

1. Material/Alloy designation, specification (if applicable), and present HT condition/Temper
2. Heat treat specification, revision, and applicable PSDs
3. Heat treat requirement

Required Information (When Applicable, defer to spec/drawing)

1. Special furnace atmospheres Surface condition
2. Special Racking instructions
3. Surface hardening
 - a. Requirements (e.g. case depth, etc.)
 - b. Testing methods
 - c. Stock removal
4. Hardness/conductivity test sampling (If other than as specified in the referencing Heat Treating specification)
5. Hardness test location
6. Other test sampling and test locations
7. Post heat treat processing (if to be performed by the heat treater)

Processes Not Required To Be Performed

1. The required clean and descale per BAC5651 or BAC5625 following heat treatment per BAC5619
2. Other post heat treat testing