

**Purchase Order Quality Requirements (POQR) Revision F**  
**Date 09/05/25**

**QA CLAUSES ARE MANDATORY AND APPLICABLE TO ALL PURCHASE ORDERS**

**QA1 – NOTIFICATION OF CHANGES BY THE SUPPLIER:** During performance of the contract, the Supplier is required to give written notice to the Triumph, Clemmons site of any changes of their BMS/QMS system, changes in certifications as required by Triumph, (e.g. Nadcap), address change, processes, processors, procedures previously approved by Triumph Actuation Systems, LLC and changes in management personnel that have responsibility for quality of product or service furnished to the Triumph Actuation Systems, LLC. This includes any Distributors that change a supplier for all procured parts, with the exception of COTS items.

Triumph Actuation Systems, LLC, at its option, may elect to conduct an on-site evaluation to determine the impact of such changes on previous approvals on product or service quality levels.

**QA2 – FOR GOVERNMENT/MILITARY RATED CONTRACTS SEE:**

[www.triumphsupplysource.com/SupplierProvisions](http://www.triumphsupplysource.com/SupplierProvisions): Triumph General Terms and Conditions and Triumph Company Terms and Conditions

**ITAR/EAR Requirements** - The technical data provided by Triumph-Clemmons to suppliers is governed by the United States International Traffic in Arms Regulations (ITAR). The supplier hereby represents and agrees that all technical data provided to supplier by Triumph-Clemmons, hereunder will be used in strict compliance with the ITAR/EAR and solely for the performance of the work hereunder. The supplier agrees to implement procedures for restricting access to said technical data to U.S. citizens only. If during the performance of the work, the supplier is required to provide such technical data or part thereof to a sub-tier supplier. Supplier may do so provided that such sub-tier supplier is located within the United States and further provided that supplier has imposed upon said sub-tier supplier the same ITAR obligations as contained herein. Disclosure and access to said technical data by a foreign national is subject to relevant approvals being obtained from the U.S. State Department. Supplier shall, upon completion of the work hereunder, including any warranty period, ensure that supplier shall destroy or return to Triumph-Clemmons all said technical data. This includes the supplier being registered with the Directorate of Defense Trade Controls (DDTC) and providing that registration to Triumph Clemmons on an annual basis.

**QA3 - SPECIAL PROCESSING SUPPLIER AND SUB-TIERS**

**“Use only special process suppliers listed on the Nadcap Approved Vendor List”**

For Build to Print product Nadcap and Customer approval is required

- a. If the drawing **is not** a Triumph Actuation Systems, LLC original or current design authority **1SR57** or **26437** found on the bottom right of the engineering drawing, **use** the customer (design authority) Approved Vendor List, i.e. Northrop Grumman, Gulfstream, Boeing etc.
- b. If the specification listed on the Triumph Actuation Systems, LLC drawing **is** a customer specification number **use** the customer Approved Suppliers List. i.e. BAC spec, use Boeing Approved Suppliers List.

Ensure the special process referenced specification is being performed within 90 days of the latest revision.

**QA4 - UNAUTHORIZED USE OF NONCONVENTIONAL MACHINING METHODS**

Unless specified on the engineering drawing, specification or purchase order, supplier or sub-tiers shall not use any non-conventional manufacturing or processing methods, such as electrical discharge machining (EDM), electro chemical machining (ECM), laser or abrasive water jet cutting, flame spray coatings, etc., without proper written authorization from Triumph Actuation Systems, LLC. To request approval, please contact your



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buyer for the correct request form to submit, or go to Quality Requirements, Site Quality Requirements, Clemmons in the Triumph Supplier Portal.

**QA5 – CURE DATES FOR ELASTOMERS/EXPIRABLES**

Elastomers - Cure date shall meet industry standard, AS5316 latest revision, unless, Northrop Grumman and/or Gulfstream Build to Print (BTP) items are called out on the Purchase Orders, in which case, cure date shall meet 2 years / 24 months or less.

Expirable (Paints, Primers, Adhesives, Epoxies, Sealants, etc.), 100% -75% of shelf life must be remaining upon date of receipt at Triumph Actuation Systems, LLC.

**QA6 – SUPPLIER SAMPLING PLAN**

Located on the Supplier Portal under the following location:

[www.triumphsuppliesource.com/suppliers/Quality Requirements/Site Quality Requirements/Triumph Actuation Systems - Clemmons, NC](http://www.triumphsuppliesource.com/suppliers/Quality%20Requirements/Site%20Quality%20Requirements/Triumph%20Actuation%20Systems%20-%20Clemmons,%20NC)

**QA7 – PACKAGING, PACKING, AND MARKING REQUIREMENTS**

Located on the Supplier Portal under the following location:

[www.triumphsuppliesource.com/suppliers/Quality Requirements/Site Quality Requirements/Triumph Actuation Systems - Clemmons, NC](http://www.triumphsuppliesource.com/suppliers/Quality%20Requirements/Site%20Quality%20Requirements/Triumph%20Actuation%20Systems%20-%20Clemmons,%20NC)

**QA8 – SOURCE CONTROLLED DRAWINGS:** Typically used for components that are qualified to application-specific requirements that have been reviewed and approved by Triumph Actuation Systems, LLC Engineering Department.

- a) **Any changes** to these Source Controlled Drawings after the initial approved design must be submitted to Triumph Actuations Systems, LLC Engineering for review and documented approval.

**QA9 – DIGITALLY SCANNED CERT PACKAGES:** Triumph requires that when a part is ready to ship to TAS-Clemmons, your site will scan the complete cert package and email it to: [TASNC-CERTPKGS@triumphgroup.com](mailto:TASNC-CERTPKGS@triumphgroup.com). The cert package should be named using the following naming convention: Part Number, Purchase Order, Packing Slip, Date:

Part Number.Purchase Order.Packing Slip.Date  
Example: (1FA123456.123456.12345.02132015)

**Delegated Suppliers will use:** [TASNC-SIDAPKGS@triumphgroup.com](mailto:TASNC-SIDAPKGS@triumphgroup.com) for eligible Supplier Inspection Delegated Authority (SIDA) part numbers and the same naming convention as listed above.

The shipment of delegated parts would only need to have a Packing Slip, Triumph's Delegated Product Release Verification Form, (QF-0150) in color and a Certificate of Conformance upon receipt at Triumph.

**QA10 - CERTIFICATE OF CONFORMANCE**

Every shipment shall be accompanied by a legible and reproducible copy of a Certificate of Conformance. The Certificate must include, at a minimum, the following:

1. Suppliers name and address.
2. Triumph Actuation Systems, LLC purchase order number.
3. Quantity shipped.
4. Country of Origin
5. Triumph's part number and vendor part number (if applicable) and revision number.
6. Serial Numbers, Batch Numbers, Cert Numbers, Heat Numbers or Cure Dates as applicable.
7. Signature and Title of Authorized Representative.
8. The Certificate of Conformance must contain a statement that processing and tests have been performed as required and meet the drawing requirements and/or purchase order.



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9. Products controlled by heat numbers, cert. numbers, batch numbers or cure dates must be linked to the certificate of conformance by the controlling number.
10. Each shipment must also be accompanied by **legible and reproducible** copies of all raw material, processing, test and hardware certifications needed to produce the part in accordance with the engineering drawing and/or purchase order requirements.
11. The Suppliers Certificate of Conformance with the title of the Authorized Representative must be submitted with each shipment.

#### **QA11 – SQAM001 TRIUMPH'S SUPPLIER QUALITY ASSURANCE MANUAL APPLIES**

Located on Triumph's Supplier Portal [www.triumphsupplysource.com](http://www.triumphsupplysource.com)

#### **QA12 - DIMENSIONAL FIRST ARTICLE INSPECTION**

Triumph Actuation Systems, LLC requires full compliance to **SAE AS9102 using the latest revision, Aerospace First Article Inspection Requirement**, when there is a first production run or if there has been a lapse of 2 or more years in production. The supplier shall mark all open or unused fields on the FAI report, "N/A" to ensure each field has been reviewed. *The supplier **shall** provide a copy of the Ballooned Drawing with each characteristic and/or requirement clearly marked with unique identifier number, along with the identified first article part. The number may be circled or boxed for easy visual identification.*

**NOTE:** In the event of a sub-assembly, each detail part shall be sent to Triumph Clemmons for inspection prior to the sub-assembly with the individual FAIs. Once assembled the sub-assembly FAI shall also be sent with the completed part.

#### **QA13 – SUPPLIER - RESPONSIBLE NONCONFORMANCE COST RECOVERY**

At the discretion of TAS-Clemmons, suppliers may be subject to charges for recovery of costs associated with any/all supplier-responsible non-conforming parts/material or documentation. Such charges may include:

Minimum of \$300 (USD) administrative charge for each non-conforming document, each request for error correction required for documentation and/or each request for missing documentation.

#### **QA14 – ACCEPTANCE AUTHORITY MEDIA (AAM)**

Triumph Actuation Systems, LLC suppliers **shall** have as part of their QMS, a policy for their employees and suppliers of the use of Acceptance Authority Media (AAM). Suppliers AAM policy shall comply with the AS/EN/9100 Requirements and FAA 14 CFR Part 21 (Section 21.2). The Seller shall make every effort to prevent the likelihood of fraudulent activity and shall have in place a policy that addresses and controls fraudulent activity and the potential consequences of fraudulent activity.

Triumph Actuation Systems, LLC suppliers shall upon request, be able to demonstrate evidence of this communication to its employees and to its supply chain; use of AAM must be considered as a personal warranty of compliance and conformity per AS/EN/9100 Requirements and FAA14 CFR Part 21 (Section 21.2)

The areas of focus of this assessment shall include but are not limited to:

- Authority Media Application Errors (i.e. Omission, Typos, Legibility, etc.)
- Authority Media Application Untimely Use (i.e. Documentation is not completed as planned, "Stamp/Sign as you go", etc.)
- Authority Media Application Misrepresentation (i.e. Uncertified personnel, Fraudulent Activity-Falsification of documentation, Work not performed as planned, etc.)
- Authority Media Application Training Deficiencies (i.e. Ethics, Culture awareness, Proper use of authority media, etc.)

**QA15 – Part Identification**

All parts shall be marked to have proper traceability back to the supplier, per supplier Identification, and/or serial numbers, as applicable. This requires at a minimum; the packaging of the parts shall be tagged with the Supplier's name and the Triumph part number. Should the supplier choose to physically mark the actual part(s) themselves, the methods and the location of the part marking shall be submitted for approval through the buyer. **Any supplier identifier shall not be an extension of the part number.**

**QA16 – FAA/PMA (Federal Aviation Administration/Parts Manufacturer Approval)**

If a supplier has PMA for a part, that part shall not be delivered to Triumph, Clemmons having any markings on the *parts themselves* indicating the supplier's part number or markings stating FAA/PMA for that part. The supplier's part packaging may have the supplier's part number on the package, in addition to the Triumph part number, but no PMA markings on the packaging as well.

**QA17 – Obsolescence**

Suppliers are responsible for notifying Triumph, Clemmons 6 months in advance of a site closure or commodity obsolescence, to include parts and consumables.

**QA18 – Electrostatic Discharge (ESD)**

Product deemed to be susceptible to damage from ESD, which may include, but not be limited to, circuits, resistors, transistors, and other semiconductor devices, shall be clearly labeled on the packaging of the product with an ESD Symbol and identified as such on the packing slip accompanying the product.

**QA19 – Involute Splines and Inspection**

All procured Splined Interfaces shall meet the inspection requirements of FES0137 Procurement Specification for Splined Interfaces Used for Hydraulic Pumps and Motors.

**QA20 – Honeywell Specification Prefixes Called out on Drawings with Cage Code 1SR57**

When any drawing, print, parts lists, etc. references any Honeywell spec prefixes, as noted in the table below, the Supplier is to contact the Buyer for the Triumph owned version (revision) or Triumph's superseding or replacement specification.

Honeywell Prefixes that require Updated Triumph Actuation Systems, LLC. Cage Code 1SR57 Specifications Prior to work completion			
AF	EMS	MC	S8
C5	ES	MCS	S9
CP	FI	PS	SC
DC	FP	PPS	TR
DRM	GPS	RR	WB
EI	HT	S3	WI

**END OF QA CLAUSES**

**ADDITIONAL QUALITY ASSURANCE REQUIREMENTS ARE APPLICABLE ONLY WHEN NOTED ON THE PURCHASE ORDER:**

**SPECIFIC CUSTOMER REQUIREMENTS ARE LOCATED ON THE TRIUMPH SUPPLY SOURCE PORTAL**

**NOTE:**



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**QARs 20 through 31 and 35 through 43 do not apply to those COTS items with a prefix of MS, NAS, and AS items.**

**QAR16 - SOURCE INSPECTION/TEST** Triumph Actuation Systems, LLC source inspection is mandatory on this purchase order. Reference SQAM001 for this requirement. It is not necessary for suppliers to contact Triumph to schedule source inspection activities. Triumph utilizes the Verify e-launch system to manage and deploy Verify personnel to support Triumph's source inspection program. Access the supplier portal and enter Approved Sources-Authorized Providers for scheduling an e-Launch Source Inspection request to Verify.

**QAR17 - GOVERNMENT SOURCE INSPECTION**

Government inspection is required prior to shipment from your plant. Upon receipt of this order, promptly notify the Government Representative who normally services your plant so that appropriate planning for government source inspection can be accomplished.

**QAR18 - SUPPLIER INSPECTION DELEGATION AUTHORITY (SIDA)**

Suppliers that have been evaluated, approved, and listed on Triumph Actuation Systems, LLC Approved Suppliers List for this program, must conform to all requirements of QP-0020 when this QAR is noted on the purchase order. Applicable to all qualifying delegated products. Non-qualifying products as defined in QP-0020 and non-delegated product must conform to the requirements of QAR32. The Supplier Quality Management System requires registration to AS9100. All SIDA suppliers are required to submit with each shipment the Form QF-0150 – Delegated Product Release Form

**QAR19 – FAR/DFARS** - Reference [www.triumphsupplysource.com](http://www.triumphsupplysource.com): Supplier Provisions: Triumph Company Terms and Conditions: Clemmons: FAR/DFARS Flow-down Addendum. When this QAR is called out on the Purchase Order, certifications identifying the country of the Specialty Metal.

**QAR20 – SPECIAL CUSTOMER REQUIREMENT AIRBUS**

Ref Airbus Supplier Requirements (ASR) A1501, A1502, A1504, A1505, as applicable

**QAR21 – SPECIAL CUSTOMER REQUIREMENT – RAYTHEON (Includes: Goodrich, UTC/UTAS, Pratt & Whitney, Collins and Hamilton Sundstrand)** Refer to Aerospace Supplier Quality Requirements (ASQR-01) for Quality System Requirements

**QAR22 - SPECIAL CUSTOMER REQUIREMENT – EATON AEROSPACE GROUP**

Quality Requirements for Subcontractors QC 06.1

**QAR23 - SPECIAL CUSTOMER REQUIREMENT – HONEYWELL**

Honeywell Supplemental Purchase Order Condition (SPOC) Manual requirements

The following is the only exception to Honeywell SPOC requirements: Triumph shall be the sole source for obtaining current part and process specifications. The supplier shall contact their Triumph assigned buyer for specification requests.

**QAR24 - SPECIAL CUSTOMER REQUIREMENT – SAFRAN LANDING SYSTEMS AND SAFRAN NACELLES**

Reference GRP-0087 Safran Requirements to External Providers

**QAR25 – SPECIAL CUSTOMER REQUIREMENT – NORTHROP GRUMMAN**

SQAR Manual - Supplier Quality Assurance Manual

**NGC APPROVED SOURCES REQUIRED FOR SPECIAL PROCESSES**

Note: Where Northrop Grumman Standard Specifications (GSS) are available, they are mandatory for drawing callout. Unless otherwise specified, the latest revision and/or amendment of GSS's shall apply. Ref. GP20A

**QAR27 – SPECIAL CUSTOMER REQUIREMENT – MOOG**

**Moog Supplier Quality Requirements (SQR-1) If goods or services are related to a Government Contract, Form 116-32 applies**



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**QAR28 – Was Deleted and requirements moved to QAR 21 – HAMILTON SUNDSTRAND/UTAS/PRATT & WHITNEY**

**QAR 29 – SPECIAL CUSTOMER REQUIREMENT–GULFSTREAM – APPROVED SOURCES REQUIRED FOR SPECIAL PROCESSES**

**QAR 30 – SPECIAL CUSTOMER REQUIREMENT – BELL HELICOPTER**

Supplier Quality Requirements Manual SQRM-001

**QAR 31 – SPECIAL CUSTOMER REQUIREMENT – BOEING COMMERCIAL / MILITARY**

D1-4426 flow down requirements applies on special process purchase orders.

Boeing Quality Purchasing Data Requirements (BCA/BGS) D6-87282 applies

Boeing Advanced Product Quality Planning (APQP) & Production Part Approval Process (PPAP) X38656, applies when listed on the PO.

In addition to, any Q-clause(s) flowed down from Customer PO, as applicable

**QAR 32 – SUPPLIER FINAL INSPECTION VERIFICATION CHECKLIST FORM QF-0112**

Located on the Supplier Portal under the following location: Quality Requirements, Quality Requirements – Clemmons QF-0112 is required for all non-qualifying delegated product as defined in QP-0020 and all non-delegated product.

The supplier **must** complete this form and attach it to the cert package.

**QAR 33 – DROP SHIP AUTHORIZATION**

Drop Ship authorizes approved and delegated suppliers to drop ship articles to Triumph Customers.

**QAR 34 – APQP ELEMENTS REQUIRED** – If there is a requirement externally from the Customer or Internally from Triumph this QAR shall be added to the Purchase Order with the designated items listed that apply. Items noted below shall be submitted to Triumph for review and approval when noted on the Purchase Order. Once the required element is approved, submissions are not required with each shipment. QAR elements shall be re-submitted for approval when a change has been made from the originally submitted approval.

(Example: QAR34 Items 1, 2, 5, 6 & 9 apply)

1. Design Records
2. Design Risk Analysis (e.g. DFMEA); only applicable to design organization
3. Process Flow Diagram
4. Process Failure Mode and Effects Analysis (PFMEA)
5. Control Plan
6. Measurement System Analysis (MSA)
7. Initial Process Capability Studies
8. Packaging, Preservation and labeling Approvals
9. First Article Inspection Report (FAIR)
10. Customer PPAP Requirements for Elements Listed on PO
11. PPAP Approval Form (or equivalent)

**QAR 35 – SPECIAL CUSTOMER REQUIREMENT - CURTISS WRIGHT**

Supplier Quality Requirements SQR-100 Applies

**QAR 36 - SPECIAL CUSTOMER REQUIREMENT – HEROUX DEVTEK, INC.**

HPS-011 Quality Requirements for Suppliers with Design Responsibility

**QAR 37 - SPECIAL CUSTOMER REQUIREMENT - SAAB**

REQ-05842 Supplier Quality Management Requirements for Suppliers providing products to be used on Boeing Programs

**QAR 38 - SPECIAL CUSTOMER REQUIREMENT - PIPER**

Quality Procedure 6.2 Supplier Quality Assurance Requirements



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**QAR 39 - SPECIAL CUSTOMER REQUIREMENT – CESSNA/TEXTRON AVIATION**  
Supplier Quality Requirements P1

**QAR 40 – SPECIAL CUSTOMER REQUIREMENT – TRIUMPH YAKIMA**  
QWI 06.01.02 Purchase Order Quality Clauses and SQAM001

**QAR 41 – SPECIAL CUSTOMER REQUIREMENT - CESA**  
EC033 General Quality Requirements for Suppliers

**QAR 42 – SPECIAL CUSTOMER REQUIREMENT - EPIC**  
QPM-007 Quality Procedures Manual: Supplier Quality Requirements

**QAR 43 – SPECIAL CUSTOMER REQUIREMENT – HANWHA COPORATION**  
SQARs Q1000 through Q8000

**END OF ADDITIONAL QUALITY (QAR) REQUIREMENTS**

**Signatures of Approval**

<b>Director of Quality</b>
<b>Procurement Manager</b>
<b>Director of Program Management</b>
<b>Director of Engineering</b>
<b>Controller</b>
<b>Director of Aftermarket</b>
<b>Director Contracts &amp; Commercial</b>

**REVISION RECORD CHANGES**

Reason for change:

Date/Rev: 1/26/18 Rev NC

Date/Rev: 1/30/20 Rev. A Update cure date for elastomers to meet industry standard with the exception of those for Northrop Grumman or Gulfstream

Date/Rev: 2/3/22 Rev. B: Added NOTE Page 3 NOTE: QARs 20 through 31 do not apply to those COTS items with a prefix of MS, NAS, and AS items.

Griff Parrish

Date/Rev: 7/26/23 Rev C: Complete rewrite

Carole Sagraves, Sean Wood

Date/Rev: 6/11/24 Rev D:

Carole Sagraves/Sean Wood Added to QA4 "or go to Quality Requirements, Site Quality Requirements for Clemmons."  
Section QA5 changed 8 qtrs or less to 2 years of 24 months  
QA14 Acceptance Authority Media, added: The Seller shall make every effort to prevent the likelihood of fraudulent activity and shall have in place a policy that addresses and controls fraudulent activity and the potential consequences of fraudulent activity.  
Rewrite of QA16 FAA/PMA was: Parts shall not be delivered to Triumph, Clemmons having any markings on the *parts themselves* indicating the supplier's part number or FAA/PMA. The supplier's part packaging may have the supplier's part number on the package, in addition to the Triumph part number, but no PMA markings on the packaging as well  
Added QA18 Electrostatic Discharge  
Added QA19 Involute Splines and Inspection  
Added "QARs 20 through 31 and 35 through 43" to Note on page 4.  
Rewrite of QAR 34 was: Items noted below shall be submitted to Triumph for review and approval when noted on the Purchase Order.  
(Example: QAR34 Items 1, 2, 5, 6 & 9 apply)

Date:/Rev: 5/15/25 Rev E.

Carole Sagraves

Added to QA1 During performance of the contract, the Supplier is required to give written notice to the Triumph, Clemmons site of any changes of their BMS/QMS system.....  
Added to QA2 the ITAR and EAR requirements to include DDTC  
QA4 added or go to Quality Requirements, Site Quality Requirements, Clemmons in the Triumph Supplier Portal.  
QA5 Added Build to Print (BTP) items  
Updated path on the portal for QA6 and QA7  
QA12 Added NOTE: In the event of a sub-assembly, each detail part shall be sent to Triumph Clemmons for inspection prior to the sub-assembly with the individual FAIs. Once assembled the sub-assembly FAI shall also be sent with the completed part.  
QAR18 was The Supplier Quality Management System requires being registered or compliant to AS9100.



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QAR19 Added When this QAR is called out on the Purchase Order, certifications shall be made available identifying the country of the Specialty Metal.  
Added QA20 concerning Honeywell Spec Prefixes  
QAR 23 added The following is the only exception to Honeywell SPOC requirements:  
Triumph shall be the sole source for obtaining current part and process specifications.  
The supplier shall contact their Triumph assigned buyer for specification requests.  
QAR25 was Note: For any NGC (Build to Print - Cage code 26512) Grumman Standard Specification (GSS) takes precedence over any MIL- Spec/Military standard or Industry Standard. Refer to GP20A Northrop Grumman Specification para. 4.6  
QAR26 Qarbon Aerospace-Vought Aero Structures was deleted  
Added Director of Aftermarket and Director of Contracts to signature list

Date:/Rev. 09/05/25 Rev. F.  
Sherri Oliver

QA12 added "along with the first article part"  
QAR31 replaced X31764 with D6-87282