

COMPARISON BETWEEN ISO/TS 16949:2002 AND QS-9000 EDITION 3

ISO/TS 16949:2002		QS-9000:1998		Type of change	ACTION
Clause	Heading	Clause	Heading	Clause	
N/A	Requirement not included	4.1.4	Business plan		
		4.15.4.1	Customer packaging standards		
		4.15.4.2	Labelling		
		4.15.6.4	Shipment notification system		
4.1	General requirements	4.2.1	Quality system - General	CNR	
4.1.1	General requirements - supplemental	N/A		CNR	
4.2.1	Documentation requirements	4.1.1	Quality policy	NCI	
		4.2.2	Quality system procedures	CNR	
		4.3.1	Contract review - General	CNR	
		4.4.1	Design control - General	CNR	
		4.6.1.	Purchasing - General	CNR	
		4.9	Process control - General	CNR	
		4.10.1.	Inspection and testing - General	CNR	
		4.13.1.	Control of nonconforming product - General	CNR	
		4.14.1.	Corrective and preventive action - General	CNR	
		4.15.1	Handling, storage, packaging, preservation and delivery - General	CNR	
		4.16.1	Control of quality records	CNR	
		4.18	Training	CNR	
		4.19	Servicing	CNR	
4.20.1	Statistical techniques-Identification of need	CNR			

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Clause	Heading	Clause	Heading	Clause	
		4.20.2	Statistical techniques - Procedures	CNR	
4.2.2	Quality manual	4.2.1	General quality system requirements	CNR	
4.2.3	Control of documents	4.5.1	Document and data control - General	NCI	
		4.5.2.1	Document and data approval and issue	NCI	
		4.5.3	Document and data changes	NCI	
4.2.3.1	Engineering specifications	4.5.2.1	Engineering specifications	CNR	
4.2.4	Control of records	4.16	Control of quality records	NCI	
4.2.4.1	Record retention	4.16.1	Record retention	NCI	
5.1	Management commitment	4.1.1	Quality policy	CNR	
5.1.1	Process efficiency	N/A		CNR	
5.2	Customer focus	N/A		CNR	
5.3	Quality policy	4.1.1	Quality policy	CNR	
5.4.1	Quality objectives	4.1.1	Quality policy	CNR	
5.4.1.1	Quality objectives - supplemental	N/A		CNR	
5.4.2	Quality management system planning	4.2.3	Quality planning	CNR	
5.5.1	Responsibility and authority	4.1.2	Responsibility and authority	NCI	
5.5.1.1	Responsibility for quality	4.1.2a) Note	Responsibility and authority	NC	
		4.1.2.5	Information to Management	NC	
5.5.2	Management representative	4.1.2.3	Management representative	NC	
5.5.2.1	Customer representative	4.1.2f)	Customer representative	CNR	

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Clause	Heading	Clause	Heading	Clause	
5.5.3	Internal communication	N/A		CNR	
5.6.1	Management review - General	4.1.3	Management review	CNR	
5.6.1.1	Quality management system performance	4.1.3.1	Management review - supplemental	NCI	
		4.2.8	Quality system performance	CNR	
5.6.2	Review input	N/A		CNR	
5.6.2.1	Review input-supplemental	N/A		CNR	
5.6.3	Review output	N/A		CNR	
6.1	Provision of resources	4.1.2.2	Resources	CNR	
6.2.1	Human resources-general	4.18	Training	CNR	
6.2.2	Competence, awareness and training	4.18	Training	CNR	
		4.18.1	Training effectiveness	NCI	
6.2.2.1	Product design skills	4.2.4.1	Tools and techniques	NCI	
		4.4.2.1	Required design skills	NCI	
6.2.2.2	Training	4.18.1	Training	NCI	
6.2.2.3	Training on the job	N/A		CNR	
6.2.2.4	Employee motivation and empowerment	4.1.4 Note	Business plan	CNR	
6.3	Infrastructure	N/A		CNR	
6.3.1	Plant, facility and equipment planning	4.2.6	Plant, facility and equipment planning	NCI	
6.3.2	Contingency plans	4.9.b.2	Contingency plans	LR	
6.4	Work environment	4.9b	Process control - General	CNR	

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Clause	Heading	Clause	Heading	Clause	
6.4.1	Personnel safety to achieve product quality	4.2.3.4	Product safety	NCI	
6.4.2	Cleanliness of premises	4.9.b.1	Cleanliness of premises	NC	
7.1	Planning of product realization	4.2.3	Quality planning	CNR	
		4.1.2.4	Organizational interfaces	NCI	
		4.2.3.1	Advanced Product Quality Planning	NCI	
		4.10.1	Inspection and testing - General	NCI	
7.1.1	Planning of product realization-supplemental	N/A		CNR	
7.1.2	Acceptance criteria	4.10.1.1	Acceptance criteria	NC	
7.1.3	Confidentiality	N/A		CNR	
7.1.4	Change control	N/A		CNR	
7.2.1	Determination of requirements related to the product	4.4.4	Design input	CNR	
7.2.1.1	Customer designated special characteristics	4.9.d.1	Designation of special characteristics	NCI	
7.2.2	Review of requirements related to the product	4.3.2	Review	NCI	
		4.3.3	Amendment to contract	NCI	
		4.3.4	Records	CNR	
7.2.2.1	Review of requirements related to the product - supplemental	N/A	-	CNR	
7.2.2.2	Organization manufacturing feasibility	4.2.3.3	Feasibility reviews	CNR	
7.2.3	Customer communication	N/A		CNR	
7.2.3.1	Customer communication - supplemental	4.4.4.1	Computer aided design	LR	
		4.15.6.3	Electronic communication	LR	

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Clause	Heading	Clause	Heading	Clause	
7.3 Note	Design and development	N/A		CNR	
7.3.1	Design and development planning	4.4.2	Design and development planning	NCI	
		4.4.3	Organizational and technical interfaces	NCI	
7.3.1.1	Multidisciplinary approach	4.2.3.1	Multidisciplinary approach	NC	
7.3.2	Design and development inputs	4.4.4	Design input	NC	
7.3.2.1	Product design input	4.4.1.1	Use of information	CNR	
7.3.2.2	Manufacturing process design input	N/A		CNR	
7.3.2.3	Special characteristics	4.9.d.1	Designation of special characteristics	NC	
		4.2.3.2	Special characteristics	NC	
7.3.3	Design and development outputs	4.4.5.	Design output	LR	
7.3.3.1	Product design outputs – supplemental	4.2.3.1	Tools and techniques	NCI	
		4.4.5.1	Design optimization	NCI	
7.3.3.2	Manufacturing process design output	4.2.3.5	Process FMEAs	NCI	
		4.2.3.6	Mistake proofing	NCI	
7.3.4	Design and development review	4.4.6	Design review	NCI	
7.3.4.1	Monitoring	N/A		CNR	
7.3.5	Design and development verification	4.4.7	Design verification	CNR	
7.3.6	Design and development validation	4.4.8	Design validation	CNR	
7.3.6.1	Design and development validation - supplemental	4.4.8.1	Design validation - supplemental	NCI	

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7.3.6.2	Prototype programme	4.4.10	Prototype programme	NC	
7.3.6.3	Product approval process	4.2.4	Product approval process	NCI	
7.3.7	Control of design and development changes	4.4.9.1	Design changes	NCI	
		4.4.9.2	Evaluation of design change	NCI	
7.4.1	Purchasing process	4.6.2	Evaluation of subcontractors	NCI	
7.4.1.1	Regulatory compliance	4.6.1.2	Regulatory compliance	NC	
7.4.1.2	Supplier quality management system development	4.6.2.1	Subcontractor development	CNR	
7.4.1.3	Customer-approved sources	4.6.1.1	Customer approved subcontractors	NC	
7.4.2	Purchasing information	4.6.3	Purchasing data	NCI	
7.4.3	Verification of purchased product	4.6.4.1	Supplier verification at subcontractors premises	NCI	
		4.6.4.2	Customer verification of subcontractors product	NCI	
		4.10.2	Receiving inspection and testing	NCI	
7.4.3.1	Incoming product quality	4.10.2.4	Incoming product quality	NCI	
7.4.3.2	Supplier monitoring	4.6.2.2	Scheduling of subcontractors	LR	
7.5.1	Control of production and service provision	4.9	Process control - General	NCI	
		4.15.1	Handling, storage, packaging, preservation and delivery - General	NCI	
		4.19	Servicing	NCI	
7.5.1.1	Control plan	4.2.3.7	Control plan	CNR	
7.5.1.2	Work instructions	4.9.1	Job instructions	NCI	
7.5.1.3	Verification of job set-ups	4.9.4	Verification of job set-ups	NC	

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7.5.1.4	Preventive and predictive maintenance	4.9.g.1	Preventive maintenance	CNR	
7.5.1.5	Management of production tooling	4.2.6.2	Tooling management	NC	
7.5.1.6	Production scheduling	4.15.6.2	Production scheduling	NC	
7.5.1.7	Feedback of information from service	4.19.1	Feedback of information from service	CNR	
7.5.1.8	Servicing agreement with customer	N/A		CNR	
7.5.2	Validation of processes for production and service provision	4.9	Process control - General	CNR	
7.5.2.1	Validation of processes for production and service provision – supplemental	N/A		CNR	
7.5.3	Identification and traceability	4.8	Product identification and traceability	NCI	
		4.12	Inspection and test status	NC	
7.5.3.1	Identification and traceability – supplemental	4.8	Product identification and traceability	NC	
7.5.4	Customer property	4.7	Control of customer supplied product	CNR	
7.5.4.1	Customer-owned production tooling	4.7.1	Customer owned tooling	NCI	
7.5.5	Preservation of product	4.15.1	Handling, storage, packaging, preservation and delivery - General	NCI	
		4.15.2	Handling	NCI	
		4.15.3	Storage	NCI	
		4.15.4	Packaging	NCI	
		4.15.5	Preservation	NCI	
		4.15.6	Delivery	NCI	
7.5.5.1	Storage and inventory	4.15.3.1	Inventory	NCI	

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7.6	Control of monitoring and measurement devices	4.11.1	Control of inspection, measuring and test equipment - General	CNR	
		4.11.2	Control procedure	CNR	
7.6.1	Measurement system analysis	4.11.4	Measurement system analysis	NC	
7.6.2	Calibration/verification records	4.11.3	Records	NC	
7.6.3	Laboratory requirements	4.10.7	Laboratory requirements	CNR	
8.1	Measurement, analysis and improvement- general	4.20.1	Statistical techniques-Identification of need	NCI	
		4.10.1	Inspection and testing - General	NCI	
8.1.1	Identification of statistical tools	4.20.3	Identification of statistical tools	NCI	
8.1.2	Knowledge of basic statistical concepts.	4.20.4	Knowledge of basic statistical concepts.	NC	
8.2.1	Customer satisfaction	4.1.6	Customer satisfaction	CNR	
8.2.1.1	Customer satisfaction – supplemental	4.15.6.1	Performance monitoring of supplier delivery	CNR	
8.2.2	Internal audit	4.17	Internal quality audits	CNR	
8.2.2.1	Quality management system audit	N/A		CNR	
8.2.2.2	Manufacturing process audit	N/A		CNR	
8.2.2.3	Product audit	4.10.4.2	Product audit	CNR	
8.2.2.4	Internal audit plans	4.17.1	Internal quality audits –supplemental - General	CNR	
8.2.2.5	Internal audit qualification	N/A		CNR	
8.2.3	Monitoring and measurement of processes	4.9d	Process control - General	CNR	
8.2.3.1	Monitoring and measurement of manufacturing processes	4.9.2	Maintaining process control	CNR	

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8.2.4	Monitoring and measurement of product	4.10.3	In-process inspection and testing	NCI	
		4.10.2	Receiving inspection and testing	NCI	
		4.10.4	Final inspection and testing	NCI	
		4.10.5	Inspection and test records	NCI	
8.2.4.1	Layout inspection and functional testing	4.10.4.1	Layout inspection and functional testing	NC	
8.2.4.2	Appearance items	4.9.6	Appearance items	NC	
8.3	Control of nonconforming product	4.13.1	Control of nonconforming product - General	NC	
		4.13.2	Review and disposition of nonconforming product	CNR	
8.3.1	Control of nonconforming product - supplemental	4.13.1.1	Suspect material or product	NCI	
		4.13.1.2	Visual identification	NCI	
8.3.2	Control of reworked product	4.13.3	Control of reworked product	NCI	
8.3.3	Customer information	4.13.2.1	Corrective action plan	NC	
8.3.4	Customer waiver	4.13.4	Engineering approved authorization	NC	
8.4	Analysis of data	4.1.5	Analysis and use of company level data	CNR	
8.4.1	Analysis and use of data	4.1.5	Analysis and use of company level data	LR	
8.5.1	Continual improvement	4.2.5	Continuous improvement	CNR	
8.5.1.1	Continual improvement of the organization	N/A		CNR	
8.5.1.2	Manufacturing process improvement	4.2.5.1	Process improvement	NCI	
8.5.2	Corrective action	4.14.1	Corrective and preventive action - General	NCI	

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Clause	Heading	Clause	Heading	Clause	
		4.14.2	Corrective action	NCI	
8.5.2.1	Problem solving	4.14.1.1	Problem solving	NCI	
8.5.2.2	Error-proofing	4.14.1.2	Mistake proofing	NCI	
8.5.2.3	Corrective action impact	4.14.2.2	Corrective action impact	NC	
8.5.2.4	Rejected product test/analysis	4.14.2.1	Returned product test/analysis	NC	
8.5.3	Preventive action	4.14.1	Corrective and preventive action - General	NC	
		4.14.3	Preventive action	NC	

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