

Woven Electronics, LLC Procurement Quality Clauses BSP-8.4.3-02

Rev 3

Quality Manager



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1. PURPOSE

1.1. This procedure identifies quality clauses applicable suppliers as specified by quality requirement flow downs. This procedure meets the requirements of AS9100 and FAA 14 CFR §§ 21.137(c) and 45.15.

2. SCOPE

2.1. This procedure applies to customer or Woven Electronics, LLC, Simpsonville flow-down of quality clauses to Supplier purchase orders.

3. TERMS, DEFINITIONS, ABBREVIATIONS, ACRONYMS

- 3.1. FAA Federal Aviation Administration
- 3.2. PAH Production Approval Holder. The FAA-PMA authorized manufacturer (Woven).
- 3.3. PO Purchase order. Herein referred to as a PO between Woven and the Supplier.
- 3.4. QA Quality Assurance.
- 3.5. SO Sales Order between Woven and its customer.
- 3.6. Supplier The manufacturer of materials or service provider as named in the Supplier PO.
- 3.7. Woven Woven Electronics, LLC, Simpsonville, SC.

4. REFERENCES, RELATED DOCUMENTS

- 4.1. AS9100 Quality Management Systems Requirements for Aviation, Space, and Defense Organizations
- 4.2. COL-PRO-0022-01 Special Process Requirements for Internal Operations and Supplier Flow-Down
- 4.3. FAA 14 CFR Part 21, Section 21.137 Quality System
- 4.4. FAA 14 CFR Part 45, Section 45.15 Marking requirements for PMA articles, TSO articles, and Critical parts

5. RESPONSIBILITIES

5.1. The tasks contained in this procedure are performed by Woven Electronics, LLC, Simpsonville QA.

Note: Procurement is responsible for ensuring the Supplier is on the Woven ASL and the DPAS rating (if required) is correct. Product Engineering is responsible for ensuring the part configuration is correct.

6. PROCEDURE

6.1. Quality Engineer

- 6.1.1. Obtain open supplier PO.
- 6.1.2. Determine where used for Simpsonville part number being procured.
- 6.1.3. Review open sales orders for these part numbers.
- 6.1.4. Determine if part type is COTS, MILSPEC, Source Specific, standard catalog, company standard (e.g., Boeing standard parts such as BACC45xx, etc.), source controlled, etc.
- 6.1.5. Compare sales order quality clause requirements to Supplier purchase order quality clauses.
 - 6.1.5.1. Determine that specified clauses align to part type and customer requirements.
 - 6.1.5.2. If not, update supplier quality clauses to meet most stringent customer quality requirements.
- 6.1.6. Both the Quality Clause ID and Scope header (bold text) shall be listed in the PO.

7. FORMS AND DOCUMENTED INFORMATION

7.1. Not Applicable. Clauses for each part number are maintained in ERP system.



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8. REVISION HISTORY

0		Description of Changes	
	6/18/20	Initial Release – supersedes QAP-20027	
1	11/10/20	Added QA clause Q118	
applicable Q11B - Updated Reference to customer link Q11F - Added QA clause Q11F		Q11B - Updated Reference to customer link Q11F - Added QA clause Q11F Q109 - Rev items indicated as '***' must be manufactured to the latest	
3	6/1/2023	 Added Woven name to title page and headers. Added Collins Aerospace proprietary and doc control statement to footer. Updated Collins Aerospace logos. Updated formatting and table layouts throughout. Added FAA specific quality clauses (Q6, Q7, Q8, and Q9). Changed "Quality Codes" to "Quality Clauses" throughout. Added AS9100 and FAA references to Sections 1 and 4. Standardized Woven and Supplier naming throughout. Clarified part types in 6.1.4. Added process step to include clause description in the PO text. Quality Clause Table – Changed "must," "should" to "shall" and clarified wording where ambiguous usage was used. Q1 – Changed "section 3.0" to "QAP-007." Q10 – Added traceability requirement to CoC content. Q31 and Q31A – Clarified FAIR requirements. Q100 – Clarified language for document retention and to include FAA requirements. Added Q100J and Q100K to comply with FAA requirements. Updated Section 10 to include examples for suppliers of FAA parts. 	



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9. QUALITY CLAUSES

ID	SCOPE
Q1	Quality / Inspection System Approved by Woven Electronics, LLC:
Qı	The supplier shall be evaluated per QAP-007 and added to Woven's Approved Supplier List.
Q2	Deleted
Q3	Deleted
04	Calibration System Compliance:
Q4	Calibration systems shall be compliant to ANSI/NCSL Z540.3 or ANSI/NCSL Z540.1
	Quality System Compliance:
Q5	Unless specified in the PO, a Supplier's Quality System not accredited to 3 rd party requirements shall be approved by Woven.
	Quality System Compliance To AS9100
Q5A	Supplier shall be certified to AS9100 and maintain the certification for the duration of the contract or PO.
	Quality System Compliance To: ISO9001 or AS9100
Q5B	Supplier shall be certified to ISO9001 or AS9100 and maintain the certification for the duration of the contract or PO. If the Supplier is a distributor, it is the responsibility of the Supplier to assure that the original manufacturer maintains a Quality System complying with the requirements of Woven's PO.
	FAA Form 8130-3 Required:
Q6	An FAA Authorized Release Document Form 8130-3 shall be provided with the part.
	FAA-PMA Part Marking Requirements:
	FAA-PMA part marking shall be applied to the requirements of 14 CFR § 45.15, which shall include, at minimum:
	The article Part Number for which the PAH holds PMA authorization.
Q7	• The letters "FAA-PMA"
	• The authorized PAH name, "Woven Electronics, LLC"
	The Serial Number for any parts identified in the FAA approved design as <i>Critical</i> .
	This Quality Clause shall be used only with approval from the PAH FAA Accountable Manager or delegate.



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ID	SCOPE
	FAA-PMA Direct Shipment Authorization:
	Supplier has been granted Direct Ship Authorization (DSA) by Woven.
Q8	DSA also grants an inspection delegation which shall be coordinated with the PAH and executed under the PAH's DSA Authorization Letter and DSA Procedure.
40	The Supplier shall ensure all PO and contract requirements are met, including all requirements found in the PAH's DSA Authorization Letter and DSA Procedure.
	This Quality Clause shall be used only with approval from the PAH FAA Accountable Manager or delegate.
	FAA-PMA Special Requirements:
	The Supplier:
	Shall not deviate from any contract, PO, design, or quality requirements and shall coordinate with the PAH and seek approval prior to making any deviations.
	2. Shall ensure manufactured parts conform to design, quality, and PAH requirements.
	3. Shall ensure manufactured parts meet all contract and PO requirements.
	4. <u>Shall</u> notify the PAH prior to any changes in quality system, manufacturing location, processes or inspection methods which may affect the conformity of parts under the PO.
	5. Shall use approved procedures to ensure control of design data, documentation, manufacturing process, material traceability, inspection & testing, inspection equipment, handling and storage, quality records, and external suppliers.
Q9	6. <u>Shall</u> conduct internal audits to ensure compliance of processes to approved procedures.
	7. <u>Shall</u> use approved procedures to control nonconforming parts and implement corrective and preventive actions to prevent recurrences
	8. Shall notify the PAH within 24 hours of any quality escape or noncompliance.
	9. <u>Shall</u> ensure flow-down of Woven's requirements to all tiers of the supplier chain. No FAA-PMA part marking, inspections, or DSA granted to the Supplier by Woven can be delegated to the Supplier's external suppliers.
	10. Shall ensure document control & retain documented information for review by the PAH or FAA.
	11. Shall allow access to the FAA of all the Supplier's and sub-tier suppliers facilities.
	12. <u>Shall not</u> direct ship FAA-PMA parts to Woven's customer unless authorized by the PAH.
	13. Shall not apply "FAA-PMA" part marking under 14 CFR § 45.15 unless authorized by the PAH.



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ID	SCOPE
	Certificate of Compliance (CoC) Required – The Supplier shall provide a CoC for each shipment that includes the following, as a minimum:
	1. Identification of:
	a) Company submitting Certification.
	b) Woven PO Number.
	c) Woven Part Number (Specification and Revision Level, as applicable).
	d) Customer Part Number (Specification and Revision Level, as applicable).
	e) Traceability (Lot or Serial Number, as applicable)
	f) Shipped Quantity.
Q10	g) Certification Date.
	h) RMA # and the phrase 'rework parts or replacement parts' as applicable
	2. Statement that the shipment items comply with all purchase order requirements.
	3. Signature or initials and title of a duly authorized company representative.
	4. The Manufacturer's CoC with traceability to the sub-tier supplier's CoC.
	(Note: Traceability may be in the form of the Manufacturer's Date Code; Heat, Cast, Lot, Batch, Manufacturing or Assembly Order Number; or as specified by Material Specification.)
	5. All documents provided with the CoC shall be legible.
	6. All other requirements as specified by the Purchase Order.
	Special Process Certification – NADCAP:
Q11	The Supplier and/or sub-tier suppliers shall have a NADCAP Approved procedure for the performance of special processes, i.e. soldering ,welding, brazing, plating, anodizing, coating, painting, etc. Procedures are subject to review and / or approval by Woven Electronics or our Customer.
	Special Process Certification – BOEING:
Q11A	The Supplier and/or sub-tier suppliers shall have a BOEING approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc.
	Approved Boeing suppliers can be found at the following URL:
	http://www.boeingsuppliers.com/d14426/index.html



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ID	SCOPE
	Special Process Certification – NADCAP and NORTHROP:
Q11B	The Supplier and/or sub-tier suppliers shall have a NADCAP and NORTHROP approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc.
	Approved Northrop suppliers can be found at:
	https://oasis-aspl.myngc.com/
	Special Process Certification – NADCAP and LOCKHEED MARTIN:
Q11C	The Supplier and/or sub-tier suppliers shall have a NADCAP and LOCKHEED MARTIN approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc. Procedures are subject to review and / or approval by Woven Electronics or LOCKHEED MARTIN.
	Approved special processors can be found through Exostar / LMC P2P.
	Special Process Certification – NADCAP and RAYTHEON:
Q11D	The Supplier and/or sub-tier suppliers shall have a NADCAP and RAYTHEON approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc. Procedures are subject to review and / or approval by Woven Electronics or RAYTHEON.
	Approved special processors can be found through Raytheon.
	Special Process Certification – NADCAP and BELL HELICOPTER:
Q11E	The Supplier and/or sub-tier suppliers shall have a NADCAP and BELL HELICOPTER approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc. Procedures are subject to review and / or approval by Woven Electronics or BELL HELICOPTER.
	Approved special processors can be found through Bell Helicopter Sell2Bell site.
	Special Process Certification – NADCAP and HAMILTON SUNDSTRAND:
Q11F	The Supplier and/or sub-tier suppliers shall have a NADCAP and HAMILTON SUNDSTRAND approved procedure for the performance of special processes, i.e. soldering, welding, brazing, plating, anodizing, coating, painting, etc. Procedures are subject to review and / or approval by Woven Electronics or HAMILTON SUNDSTRAND.
	Approved special processors can be found on the 80 Report and 85 Report found at:
	https://suppliers.utc.com/Pages/Home
013	Soldering Requirements:
Q12	Soldering shall be performed to ANSI/J-STD-001 or other specification as indicated.



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ID	SCOPE
Q13	Test Data Requirements: Test data as identified in the specification, drawing, or PO shall be included with the item.
Q14	Time or Temperature Sensitive Material Requirements: The material and / or container shall be identified with the applicable expiration date or shelf life, special storage conditions (i.e. temperature for storage) etc. All shelf life controlled materials shall have a minimum of 60 days or ½ their shelf life (whichever is less) remaining upon receipt.
Q15	Electrostatic Sensitive Device Requirements: Supplier shall assure that devices are manufactured, identified, and packaged to provide protection against electrostatic damage.
Q16	Solderability Requirements: Soldering to MIL-STD-202, method 208. Supplier shall provide a certificate stating the solderability requirements have been met and any expiration time period.
Q16A	No steam aging
Q16B	1 hr. steam aging
Q16C	4 hr. steam aging
Q16D	8 hr. steam aging
Q16E	Special requirement:
Q21	Wire Spool Requirements: Spooled and labeled per NEMA WC27500.
Q31	First Article Inspection Report: Supplier shall provide with the first shipment a FAIR validating all drawing notes, dimensions, and verification of materials used per the BOM. Supplier shall seek Woven approval prior to use of any FAIR formats not meeting AS9102 requirements. Full FAIR's shall account for all design characteristics and requirements for first production runs, when production has lapsed for more than 2 years, or at Woven's request. Partial (delta) FAIR's shall be included in the first shipment subsequent to a change for the affected characteristics.
Q31A	AS9102 First Article Inspection Report: First Article Inspection Reports shall be compliant to AS9102, latest revision.



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	Woven Electronics Source Inspection Required:
Q32	Woven QA to be notified 5 days prior to shipment to receive source inspection instructions.
Q33	Government and / or Woven Customer Source Inspection Required:
Q33	Notify Woven QA 10 days prior to shipment to receive source inspection instructions.
Q34	Special Quality Provisions:
Ψ.	As noted on PO text flow down.
Q35	UL or CSA Listing / Recognition Requirements:
400	Items shall be identified per UL / CSA requirements.
Q35A	UL Listing or Recognition
Q35B	UL and CSA Listing or Recognition
Q36	UL 94V-0 Requirements:
Q36	Material supplied shall meet the requirements UL 94V-0.
Q36A	UL 94V-1 Requirements:
Q36A	Material supplied shall meet the requirements UL 94V-1.
Q36B	UL 94V-2 Requirements:
Q30B	Material supplied shall meet the requirements UL 94V-2.
Q41	Standard Level Packaging
Q42	Special Packaging Requirements:
Q42	As noted on the Purchase Order.
	Mercury Non-Contamination Certification Requirements:
Q43	Material furnished under this purchase order shall not contain metallic mercury, or mercury compounds, and shall be free from mercury contamination. Mercury contamination of the material will be cause for rejection. The Supplier is required to furnish a certificate stating that the material furnished under this PO contains no metallic mercury or mercury compounds.
Q50	Delegation of Verification:
Q30	Inspection or tests are delegated to the supplier per the attached detail.



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ID				sc	ОРЕ	
Q60	The Supp	Right of Entry: The Supplier shall allow Woven representatives, Woven's customer, and regulatory agencies the right of entry to facilities as necessary to determine and verify the quality of contracted work.				
Q61	Woven E Drawing	Notification of Transfer of Work: Woven Electronics shall be notified when manufacture / assembly of Source Controlled Drawing parts are re-located or other substantial changes to the production line occur. 30 day prior notification is requested.				
Q70		quirements: e required to	be RoHS co	ompliant.		
Q75	Items pro	Requirements for Soldered / Plated Electrical / Electronic Components: Items provided on this purchase order SHALL NOT HAVE PURE TIN finishes. Additionally, any tin-lead plating or solder process/processing shall result in a finish of not less than 3% lead composition.				
Q100	Document Retention Requirements: Supplier shall retain build, test, inspection, first article inspection, sampling records, material and chemical certificates, and any other physical traceability records used in the manufacture of the purchased part for the required retention period and are subject to review and audit by the purchaser, the purchaser's customer, or regulatory and governmental agencies. All FAIR's shall be retained for the duration of the PO or contract, and after expiration of the contract of PO for the duration specified in the last approved PO.					
	Q100A	3 Years	Q100E	15 Years	Q100J	FAA-PMA Parts – 5 Years
	Q100B	5 Years	Q100F	20 Years	Q100K	FAA-PMA Critical Parts – 10 Years
	Q100C	7 Years	Q100G	30 Years		
	Q100D	10 Years	Q100H	40 Years		
Q105	Engineering Design Change Requirements: No changes to the items purchased are allowed without written approval of Woven Electronics. Contact Woven for more information on change requests.					



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Q106	Waiver or Deviation Requirements: A written request for deviation or waiver from contracted drawing or specification is required prior to shipment of product to Woven Electronics. Contact Woven for more information on submission of requests.
Q107	Acceptance Test Plan Approval: An ATP identifying the instrumentation, test conditions, test methods, data sheets shall be submitted for approval prior to start of work.
Q108	Tooling / Process Control: Supplier shall notify Woven if any of the following have occurred; production tooling out of service for 1 year or more; rework, refurbishment or replacement of any tooling used to produce the item; any change in the manufacturing process that alters the configuration, composition, or physical properties of the item.
Q109	Requirements Flow Down: Supplier's system shall assure that applicable quality and technical requirements within this purchase order are flowed down to subcontracted suppliers and services. Rev items indicated as '*** shall be manufactured to the latest documented revision.
Q110	Foreign Object Damage (FOD) Prevention: The Supplier's program shall utilize effective FOD prevention practices. NAS412 shall be used as a guideline for development of prevention practices.
Q111	Supplier Qualification: Supplier agrees to maintain controls to assure that after successful qualification, neither any design, material, part, process, procedure, tooling, or test equipment shall be changed in any way without written approval of Woven.
Q112	Notification of Non-Conformances: The Supplier shall notify Woven Electronics of any non-conformance subsequently identified in materials, products shipped. Notification shall be within 24 hours of discovery.
Q113	Silver Coated Copper Wire – Corrosion Control – Raytheon # P8658300: Silver coating material thickness shall be measured and certified in accordance with ASTM B298. Wire and cable materials shall be certified in accordance with specifications which require use of ASTM B298 certified conductor strands.



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	Printed Wir	Printed Wiring Board Requirements:						
Q114	hour steam no activated	Printed wiring boards shall meet solderability of J-STD-003, Class 3, Category #3 after an 8-hour steam age preconditioning, followed by Edge Dip Method (IPC-TM-650, 2.4.12), using no activated flux Type ROLO; solderability conformance shall include BGA pads on boards when applicable.						
Q115	Rigid PC boa	Rigid PC Board Requirements: Rigid PC boards shall be certified to conform and comply with IPC-6012C-2010, Class 3 for manufacturing, inspection, test and acceptance. The purchased lot shall be inspected to IPC-6012C-2010, Class 3, AQL 4.0; sampling plan.						
Q116	Boeing Qua	lity Clauses listed below can be f	found at:					
QIIO	http://www	v.boeingsuppliers.com/idscommo	on/clauses/claus	e index.htm				
	Q116A	Boeing clause Q011S	Q116B	Boeing clause Q011P				
	Q116C	Boeing clause Q029						
	Q116E	Boeing clause Q073 & Q074	Q116F	Boeing clause Q132				
	Q116G	Boeing clause Q224P	Q116H	Boeing clause Q224S				
	Q116J	Boeing clause Q831	Q116K	Boeing clause GP7				
	Q116L Boeing clause D607 Q116M Boeing clause H101							
	Q116N	Boeing clause H900	Q116P	Boeing clause H927				
	Q116R	Boeing clause GP1	Q116S	Boeing clause Q219P				
	Q116T	Boeing clause Q320	Q116U	Boeing clause H106				
	Q116V	Boeing clause H108	Q116W	Boeing clause H217				
	Q116X	Boeing clause H202	Q116Z	Boeing clause H202S				
	Q116AA	Boeing clause Q227	Q116BB	Boeing clause Q091				
	Q116CC	Boeing clause Q186	Q116DD	Boeing clause H200				
	Q116EE Boeing clause Q143 Q116FF Boeing clause Q1							
	Q116GG	Q116GG Boeing clause Q40 Q116HH Boeing clause Q019						
	Q116JJ	Boeing clause Q053	Q116KK	Boeing clause Q041				
	Q116LL	DFARS 252.204-7012		•				



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Q117	Raw Material & Certified Material Test Report (CMTR) Submittal Requirements:			
	The supplier shall:			
	 Provide two raw material specimens from the mill heat or lot of raw material used to manufacture the items supplied and of sufficient size to create two material test coupons in accordance with ASTM-E8. 			
	Tag or mark each specimen with the mill heat or lot number traceable to the original mill CMTR.			
	3. Include a copy of the original mill CMTR.			
	 Package the specimens and CMTR in an envelope or separate package marked for QA Receiving Inspection. 			



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10. QUALITY CLAUSE EXAMPLES

The following examples demonstrate typical Quality Clause usage. Note: Customer and regulatory requirements shall take precedence.

For Supplier parts used in Woven's FAA-PMA	Commercial:		
manufacturing:	Q1 Standard WE approved Quality		
 Q9 FAA-PMA Special Requirements 	System		
 Q100 Document Retention Requirements 	 Q10 Certificate of Compliance 		
 Q100J FAA-PMA Parts – 5 Years 	 Q41 Standard Packaging 		
 Q100K FAA-PMA Critical Parts – 10 Years 	Q60 Right of Entry		
 Other standard and specific clauses, as required. 	 Q61 Notification of Transfer of Work 		
	 Q112 Notification of Non-Conformance 		
For Supplier with "FAA-PMA" part marking authorization	Military:		
of parts used in Woven's FAA-PMA manufacturing:	 Q5A, Q5B Quality System to ISO/QS-9000 		
 Q7 FAA-PMA Part Marking Requirements 	series, AS9100, or equivalent		
(Used only with approval from the PAH FAA	 Q10 Certificate of Compliance 		
Accountable Manager or delegate.)	 Q41 Standard Packaging 		
 Q9 FAA-PMA Special Requirements 	 Q60 Right of Entry 		
 Q100 Document Retention Requirements 	 Q61 Notification of Transfer of Work 		
 Q100J FAA-PMA Parts – 5 Years 	 Q106 Waiver or Deviation 		
 Q100K FAA-PMA Critical Parts – 10 Years 	 Q109 Requirements Flow down 		
 Other standard and specific clauses, as required. 	 Q110 FOD Prevention 		
	Q112 Notification of Non-Conformance		
For Suppliers with Direct Ship Authorization (DSA) for	Chemicals, potting materials, epoxies, etc.:		
FAA-PMA completed assemblies and kits:	 Q14 Expiration date identification 		
 Q7 FAA-PMA Part Marking Requirements 			
(Used only with approval from the PAH FAA			
Accountable Manager or delegate.)			
 Q8 FAA-PMA Direct Shipment Authorization 			
(Used only with approval from the PAH FAA			
Accountable Manager or delegate.)			
 Q9 FAA-PMA Special Requirements 			
Q100 Document Retention Requirements			
• Q100J FAA-PMA Parts – 5 Years			
Q100K FAA-PMA Critical Parts – 10 Years			
Other standard and specific clauses, as required.			
For FAA approved Suppliers of distribution parts where	Wire:		
Woven's customer requires an 8130-3:	 Q16 Solderability 		
 Q6 FAA Form 8130-3 Required 	 Q21 Wire spooling, Identification 		
 Other standard and specific clauses, as required. 			