



Woven Electronics, LLC

Procurement Quality Clauses

BSP-8.4.3-02

Rev 5

Quality Manager

Woven Electronics, LLC

Procurement Quality Clauses

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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 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

Revision	Date	Description of Changes
0	6/18/20	Initial Release – supersedes QAP-20027
1	11/10/20	Added QA clause Q118
2	11/1/22	Q10 added g) – RMA # and the phrase ‘rework parts or replacement parts’ as applicable Q11B - Updated Reference to customer link Q11F - Added QA clause Q11F Q109 - Rev items indicated as ‘***’ must be manufactured to the latest documented revision.
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.
4	10/27/2023	Updated document branding and bringing QPulse up to ITAR compliance
5	10/17/2024	- Q9 – Added Item 5 for supplier sub-tier country of origin requirement. - Q10 – Revised to align to Collins Aerospace COL-ASQR-PRO-0003. - Q115 – Clarified IPC 6012 requirement by removing “C-2010”. - Q115A – Added QA clause with Class 2 requirements. - Q116 – Added 5 new Boeing QA clauses (Q116OO – Q116VV). - Q118 – Added QA clause requirements for solder.

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9. QUALITY CLAUSES

ID	SCOPE
Q1	Quality / Inspection System Approved by Woven Electronics, LLC: The supplier shall be evaluated per QAP-007 and added to Woven's Approved Supplier List.
Q2	Deleted
Q3	Deleted
Q4	Calibration System Compliance: Calibration systems shall be compliant to ANSI/NCSL Z540.3 or ANSI/NCSL Z540.1
Q5	Quality System Compliance: Unless specified in the PO, a Supplier's Quality System not accredited to 3 rd party requirements shall be approved by Woven.
Q5A	Quality System Compliance To AS9100 Supplier shall be certified to AS9100 and maintain the certification for the duration of the contract or PO.
Q5B	Quality System Compliance To: ISO9001 or AS9100 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.
Q6	FAA Form 8130-3 Required: An FAA Authorized Release Document Form 8130-3 shall be provided with the part.
Q7	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. • The letters "FAA-PMA" • The authorized PAH name, "Woven Electronics, LLC" The Serial Number for any parts identified in the FAA approved design as Critical . This Quality Clause shall be used only with approval from the PAH FAA Accountable Manager or delegate.

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ID	SCOPE
Q8	FAA-PMA Direct Shipment Authorization: Supplier has been granted Direct Ship Authorization (DSA) by Woven. 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. 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.

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Q9	FAA-PMA Special Requirements: The Supplier: 1. <u>Shall not</u> deviate from any contract, PO, design, or quality requirements and shall coordinate with the PAH and seek approval prior to making any deviations. 2. <u>Shall</u> ensure manufactured parts conform to design, quality, and PAH requirements. 3. <u>Shall</u> 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. <u>Shall</u> only use sub-tier suppliers / manufacturers located within the USA. Use of sub-tier suppliers / manufacturers located outside the USA requires approval by the PAH. 6. <u>Shall</u> 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. 7. <u>Shall</u> conduct internal audits to ensure compliance of processes to approved procedures. 8. <u>Shall</u> use approved procedures to control nonconforming parts and implement corrective and preventive actions to prevent recurrences 9. <u>Shall</u> notify the PAH within 24 hours of any quality escape or noncompliance. 10. <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. 11. <u>Shall</u> ensure document control & retain documented information for review by the PAH or FAA. 12. <u>Shall</u> allow access to the FAA of all the Supplier's and sub-tier suppliers facilities. 13. <u>Shall not</u> direct ship FAA-PMA parts to Woven's customer unless authorized by the PAH. 14. <u>Shall not</u> apply "FAA-PMA" part marking under 14 CFR § 45.15 unless authorized by the PAH.

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ID	SCOPE
Q10	Certificate of Compliance (CoC) Required – The Supplier shall provide a CoC for each shipment that includes the following, as a minimum: 1. Name and address of the organization/ supplier/manufacturer providing product to Woven Electronics, LLC / Collins Aerospace. 2. Name and address of Woven Electronics, LLC / Collins Aerospace facility product is delivered to. 3. Commercial and Government Entity (CAGE) Code / Unique Entity Identifier (UEI) Code (as applicable). 4. Country of Manufacture and/or Country of Origin. 5. PO #, Revision, and Line Item. 6. Full drawing or specification number with revision per PO (Configuration Requirements). 7. Part number as listed on the PO. 8. Part nomenclature or description per PO line item. 9. Quantity of parts delivered. 10. Serial number(s) of parts delivered for serialized parts. If serialization is not required, Work Order or Batch/Lot number shall be provided. 11. As applicable, non-conformance report number (e.g., QN, MRB #, etc.) or RMA # and the phrase 'rework parts or replacement parts'. 12. As applicable, original manufacturer's CoC with traceability to the sub-tier supplier's CoC. 13. (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.) 14. Statement of conformity (e.g., "I hereby certify the material / service supplied was produced in accordance with the PO, and all applicable drawings and specifications.") 15. Signature or electronic signature and title of authorized supplier representative with date. 16. Source or DQR/ or Third-Party inspection stamp or electronic equivalent with date if applicable. 17. All documents provided with the CoC shall be legible. 18. All other requirements as specified by the Purchase Order.
Q11	Special Process Certification – NADCAP: 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.

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Q11A	Special Process Certification – BOEING: 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
Q11B	Special Process Certification – NADCAP and NORTHROP: 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/
Q11C	Special Process Certification – NADCAP and LOCKHEED MARTIN: 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.
Q11D	Special Process Certification – NADCAP and RAYTHEON: 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.
Q11E	Special Process Certification – NADCAP and BELL HELICOPTER: 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.

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Q11F	Special Process Certification – NADCAP and HAMILTON SUNDSTRAND: 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
Q12	Soldering Requirements: Soldering shall be performed to ANSI/J-STD-001 or other specification as indicated.
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.

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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.
Q32	Woven Electronics Source Inspection Required: Woven QA to be notified 5 days prior to shipment to receive source inspection instructions.
Q33	Government and / or Woven Customer Source Inspection Required: Notify Woven QA 10 days prior to shipment to receive source inspection instructions.
Q34	Special Quality Provisions: As noted on PO text flow down.
Q35	UL or CSA Listing / Recognition Requirements: 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: Material supplied shall meet the requirements UL 94V-0.
Q36A	UL 94V-1 Requirements: Material supplied shall meet the requirements UL 94V-1.
Q36B	UL 94V-2 Requirements: Material supplied shall meet the requirements UL 94V-2.
Q41	Standard Level Packaging

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Q42	Special Packaging Requirements: As noted on the Purchase Order.
Q43	Mercury Non-Contamination Certification Requirements: 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: Inspection or tests are delegated to the supplier per the attached detail.
Q60	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	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	RoHS Requirements: Items are required to be RoHS compliant.
Q75	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.

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	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.					
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.					

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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.			
Q114	Printed Wiring Board Requirements: 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 Board Requirements – IPC-6012, Class 3: Rigid PC boards shall be certified to conform and comply with IPC-6012, Class 3 for manufacturing, inspection, test and acceptance. The purchased lot shall be inspected to IPC-6012, Class 3, AQL 4.0; sampling plan.			
Q115A	Rigid PC Board Requirements – IPC-6012, Class 2: Rigid PC boards shall be certified to conform and comply with IPC-6012, Class 2 for manufacturing, inspection, test and acceptance. The purchased lot shall be inspected to IPC-6012, Class 2, AQL 4.0; sampling plan.			
Q116	Boeing Quality Clauses listed below can be found at: http://www.boeingsuppliers.com/idscommon/clauses/clause_index.htm			
	Q116A	Boeing clause Q011S	Q116C	Boeing clause Q020
	Q116D	Boeing clause Q029	Q116E	Boeing clause Q074
	Q116F	Boeing clause Q132	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

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	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
	Q116HH	Boeing clause Q019	Q116KK	Boeing clause Q041
	Q116LL	DFARS 252.204-7012	Q116OO	Boeing clause Q028
	Q116PP	Boeing clause Q090	Q116RR	Boeing clause Q123W
	Q116TT	Boeing clause Q510W	Q116VV	Boeing clause D604
Q117	Raw Material & Certified Material Test Report (CMTR) Submittal Requirements: The supplier shall: 1. 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. 2. 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. 4. Package the specimens and CMTR in an envelope or separate package marked for QA Receiving Inspection.			
Q118	Solder Content and Surface Finish PCB shall be Sn63 Pb37 (63% Tin/37% Lead) Solder Type Surface Finish			

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