



Hoist & Winch

Quality Control Requirements	Revision: - Revision Date: 2024/01/30	Instruction No: WI 7.4.2.4 Page Number: 1 of 15
Process Owner: Quality Manager		Document Owner: Supplier Quality

A. PURPOSE AND SCOPE

This document describes the general and special product assurance requirements that are in addition to the requirements in RC-9000 and all documents called out therein (e.g., COL-ASQR-PRO-0003). The Quality Control Requirements specified in herein will be included on the purchase order, contract, or other formal agreement between a supplier and Collins Aerospace. All quality control requirements listed below are considered active clauses.

B. REFERENCE DOCUMENTS

1. POLICY

N/A

2. PROCEDURES

N/A

3. WORK INSTRUCTIONS

N/A

4. FORMS

N/A

C. INSTRUCTIONS

SPECIFIC QUALITY CONTROL REQUIREMENTS (QCR)

16. BEARINGS

All lubricating bearings shall be identified with the lubrication type, the date that they were lubricated and the date when the bearing need to be re-lubricated.

18. FUNCTIONAL TEST CERTIFICATIONS

Each shipment must be accompanied by a legible and reproducible copy of the Suppliers Certification Identifiable with submitted material for which test reports are on file and available for examination. This certificate must contain the signature of the authorized representative and assure conformance to specified requirements.

A - Actual tests results required.

B - Test Certificate of Conformance Required.



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NOTE:

Test certificate of conformance of actual tests are defined as operational inspection, e.g., Mechanical, Electrical, or Hydraulic.

19. PRESSURE OR LEAK TEST

Each shipment shall be accompanied by a legible and reproducible copy of reports of test results, identifiable with test parameters and products submitted. These reports must contain the signature of the authorized representative of the agency performing the test and must assure conformance to specified requirements.

20. STATISTICAL PROCESS CONTROL (CONTROL OF KC/KP CHARACTERISTICS)

Both SAE AS9103 “Management of the Variation of Key Characteristics” and Collins Specification S-372 “Requirements for Implementing Process Controls” apply to this order. Documentation and data shall be managed via the Supplier’s Managed File Transfer account.

21. PROCESS CERTIFICATION

Each shipment must be accompanied by legible and reproducible copy of a certificate containing the signature of an authorized representative for all processes used, such as heat treating, welding, surface preparation and treatment, etc. The certificate shall include the process used, the specification to which it conforms and the name of the sub-tier that performed them if other than the supplier. When parts are serialized, serial number must appear on the certification.

A. Critical Parts: All critical parts listed in Collins S-370 Critical Parts Specification are required to be serialized when processed. Each special process certification must list all serial numbers in the submitted lot. Certification must also have traceability to the supplier job number and the job/lot certificate of conformance.

22. NON-DESTRUCTIVE TEST REPORTS

Each shipment shall be accompanied by a legible and reproducible copy of actual Non-destructive Results identifiable with acceptance requirements and material submitted. These reports must contain the signature and title of the authorized representative of the agency performing the inspection and must assure conformance to specified requirements Fluorescent Penetrant~ Magnetic Particle, Radiographic and other non-destructive evaluation processes as referenced on drawings and / or specifications shall be accomplished by Inspection personnel certified in accordance with MIL-STD-410 or applicable standard. Parts that have been accepted using FPI or Mag particle inspection shall be marked per the applicable non-destructive test specification.

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23. RADIOGRAPHIC INSPECTION

Radiographic inspection results shall be reported on a certification that includes the film reader's name and qualification level (MIL-STD-410). Certifications shall include serial numbers (when applicable and the signature and title of an authorized representative. Unless otherwise specified, radiographic inspection of castings shall be performed after all heat- treat operations.

Radiographic techniques shall be submitted to H&W with the first article sample. Subsequent radiographic technique changes shall be approved by H&W.

- A. Radiographic films to be submitted with shipment.
- B. Radiographic films to be retained by the supplier and made available to H&W's request.

Note: Film shall not be destroyed without prior written approval from H&W purchasing.

24. HEAT TREAT REPORT

Each shipment shall be accompanied by a legible and reproducible copy of the detailed heat treatment cycle used. Details to include date, time, temperature, actual Case Depth Recording on the Heat Treat Certificate, quench method and using sampling plan that meets D1-8007 to achieve NDT Hardness check, if thermal treatment is to achieve final drawing requirements. Unless otherwise specified all parts hardened to Rc 40 and above must be Nital Etch inspected after grinding. Nital/Temper Etch Inspection reports must accompany the heat treat report. The report must contain the signature and title of the authorized representative of the agency performing the tests and inspections.

27. PROPRIETARY PRODUCTS

Unless otherwise specified by contract, supplier shall notify the buyer in writing of any class I change proposed in product design, performance specification, materials or material processes of the proprietary products as ordered there under and shall obtain buyer's approval prior to effecting any such proposed changes. (REF.: DOD-STD-480, MIL-STD-481).

Non-Conforming Material -Supplier Design Components (Proprietary Products)

The supplier shall have a documented and implemented non-conforming material control System Suppliers providing products of their own design may perform material review in accordance with the current issue of MIL-STD-1520 for that non-conformance's that are defined as Type II.

Type I Non-conformance is defined herein as: Those goods and services which depart from contract requirements and affect one or more of the following major areas; performance, durability, inter-changeability, use or operations, weight, appearance (where a factor), health or safety.

Type I non-conformance shall be submitted on the Supplier Variation Request Form. Non-conforming material shall not be presented to H&W for acceptance without prior written approval.

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Type II Non-conformance is defined herein as: Those goods and services that depart from contract requirements and are minor in that they do not affect any of the criteria specified in **Type I**. Under no circumstances shall the supplier or his sub-tiers perform any repair operations without prior written approval from H&W. The supplier shall ensure that the responsibilities for non-conforming materials extend to sub-tiers. Type II non-conformances shall be submitted to H&W for concurrence.

30. SUPPLIER INSPECTION REPORT

The supplier shall provide with each shipment a detailed written inspection report. Each characteristic (including drawing notes) inspected or tested shall be listed as a single line entry and shall indicate the acceptability of that characteristic, including all actions taken in connection with an identified discrepancy. Inspection and testing records shall, as a minimum, indicate the nature of the observations together with the number of observations made and the number and type of deficiencies found. Inspection/testing records shall, as a minimum include the following information:

1. Suppliers name
2. PO number
3. Drawing or plan Revision
4. Quantity Inspected
5. Quantity Accepted (list serial numbers when applicable)
6. Quantity Rejected (list serial numbers when applicable)
7. Characteristics Inspected

NOTE: When this QCR is applied to a critical part, the critical characteristics defined on its drawing will require 100% inspection and recording of their actual results on ALL the parts in the entire lot. When variable data is obtained, the high and the low measured dimensions must be recorded and the tool used to measure must be identified. When attribute data (go no-go) is used, the report will still be required identifying the person and gage used in the inspection process and the results. All of the manufacturing personnel affected by this QCR must be trained on its interpretation and objective evidence of the training created.

34. RAW MATERIAL REQUIREMENTS – IDENTIFICATION

A SHEET OR PLATE STOCK - METALLIC OR NON METALLIC

Each sheet or plate furnished on this order shall be identified by continuous stenciling, of sufficient size to be readily legible, applied by permanent ink or dye of contrasting color, non-injurious to material surfaces and not soluble in cutting and coolant oils. Stencil markings shall occur 12-inch spacing between rows of stenciling. Information must include material type and designation, material, heat number and size.

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B ROD, BAR OR TUBE - 1/4 INCH CROSS SECTION OR LARGER

Each length of rod bar or tube furnished on this order shall be identified by continuous stenciling, of sufficient size to be readily legible, applied by permanent ink or dye of contrasting color, groups of stencil characters shall not exceed ~ 2 inches. Information shall include material type or designation, material specification and heat number.

C ROD, BAR OR TUBE - LESS THAN 1/4 INCH CROSS SECTION

Rod, bar or tube furnished on this order shall be identified as specified below: Bars shall be securely bundled together, each bundle containing bars from a single heat of material and an adhesive label or marking tape shall be securely affixed to each end of each bar. This labeler tape shall be permanently marked to indicate material type or designation, material specification and heat number. The label or tape shall be wrapped around or otherwise tightly fastened to avoid projection and shall be coated to provide protection from weather and normal handling.

D CASTINGS MARKING

Each Casting furnished on this order shall be marked in such a manner as to display part Number, "melt" number, heat treat lot (if applicable) and serial number (if applicable).

E TEST SAMPLES

The seller shall furnish for the buyer verification testing one (1) additional product or suitable test sample of the same original material lot and processed simultaneously with the lot of product (s) supplied on this Purchase Order. Both the test sample and seller shipping documents shall identify the sample, part number, process and both or lot number.

F RAW MATERIAL CERTIFICATION

Each shipment shall be accompanied with legible copies of the material certification as furnished by the raw material supplier or an independent test laboratory. Material certifications must agree in all respects with the raw material requirements of their applicable specifications. Unless otherwise specified, all certifications shall state as a minimum, the latest revision of the required specification.

35. MILL HEAT CONTROL/MILL CERTIFICATION

Assigned serial numbers must be consecutive within a mill heat. Actual mill Certifications required.

36. GEAR DATA

A legible gear chart with increment designations shall accompany each shipment of gears. Part number and serial number, which applied to the following Collins Specification S-355 (Gear Inspection Guideline), Table I, II, III requirements (if applicable).

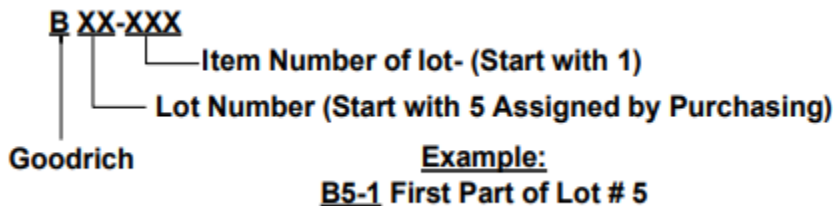
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- A. Table I - Timing Gears: Sample inspection by composite action
- B. Table II - Inspected 100% by composite action and sample inspected analytically for lead error.
- C. Table III - Inspected 100% by composite action and 100% analytically for lead error.

NOTE: Composite action can be inspected by using the (4) elements for analytical Inspection: Lead, Profile, Tooth to Tooth and Pitch.

37. LOT SERIALIZATION REQUIRED

- A. Each part on this order shall be marked with a unique lot serial number provided by purchasing. All parts manufactured and/or processed, as a group in the same time frame shall constitute a lot. If more parts are made than the quantity on the P.O., the supplier shall request additional serial numbers from H&W purchasing. Marking shall be in accordance with Collins' Standard Specification S-369.
- B. MSL (Matched Set Lot) Serialization. Parts that are processed as a set must be identified with a unique MSL (Matched Set Lot) number provided by Purchasing. Both parts of the set must be marked with the same number. Marking shall be in accordance with Collins' Standard Specification S-369.



40. VALIDATION OF WIRING HARNESSSES (A.K.A ELECTRICAL CABLES)

The Supplier's manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items. The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.
- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

The Supplier shall provide the following PRIOR to delivery of production harnesses:

- 1) A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B. FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) The first article specimen (the part from which the actual FAIR recorded values are derived),

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- 3) A copy of the Supplier's manufacturing instructions (router, traveler, etc.),
- 4) Acceptance test data sheet per drawing or specification (if acceptance testing is required by PO), and
- 5) Tooling drawing or specification (if the PO includes tooling).

The FAIR cannot be approved until all items described above are received by H&W.

The specimen (see 2 above) must be identified with a tag to include the following information:

- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and
- e) The phrase "First Article".

The shipping documents must clearly state the delivered item is a "First Article" and reference the PO line that specifies first article (if applicable).

The above items shall be reviewed by H&W to validate the product of the Supplier's manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

Once the process validation is accomplished, the Supplier's manufacturing instructions (see 3 above) are "frozen". When the Supplier plans a change to the manufacturing process that affects the fit, form (including any changes of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

A THE ITEM MAY BE UTILIZED FOR PRODUCTION.

B THE ITEM MAY NOT BE UTILIZED FOR PRODUCTION; THE ITEM MAY BE EITHER SECTIONED OR DISASSEMBLED FOR EVALUATION.

41. VALIDATION OF PRINTED CIRCUIT BOARD ASSEMBLIES (PCBA)

The Supplier's manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items. The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.

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- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

The Supplier shall provide the following PRIOR to delivery of production PCBA's:
A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B.

- 1) The first article specimen (the part from which the actual FAIR recorded values are derived), FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) A copy of the Supplier's manufacturing instructions (router, traveler, etc.),
- 3) Acceptance test data sheet per drawing or specification (if acceptance testing is required by PO),
- 4) Tooling and/or test equipment drawing or specification (if the PO includes tooling), and
- 5) Bare board coupon, if QCR 41B (see below) applies.

The FAIR cannot be approved until all items described above are received by H&W. The specimen (see 2 above) must be identified with a tag to include the following information:

- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and
- e) The phrase "First Article".

The shipping documents must clearly state the delivered item is a "First Article" and reference the PO line that specifies first article (if applicable). The above items shall be reviewed by H&W to validate the product of the Supplier's manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

Once the process validation is accomplished, the Supplier's manufacturing instructions (see 3 above) are "frozen". When the Supplier plans a change to the manufacturing process that affects the fit, form (including any changes of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

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A PRINTED WIRING BOARD COUPON NOT REQUIRED.

B PRINTED WIRING BOARD TEST COUPON REQUIRED. TEST COUPONS ARE TO MEET THE REQUIREMENTS OF MIL-PRF-55110G.

42. VALIDATION OF MACHINED PARTS

The Supplier's manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items.

The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.
- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

The Supplier shall provide the following PRIOR to delivery of production parts:

- 1) A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B. FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) The first article specimen (the part from which the actual FAIR recorded values are derived),
- 3) A copy of the Supplier's manufacturing instructions (router, traveler, etc.),
- 4) A copy of the Supplier's inspection plan¹, and
- 5) Tooling drawing or specification (if the PO includes tooling).

NOTE 1:

The inspection plan is to describe at what stage(s) of manufacture inspection will be performed and how it will be accomplished. If the inspection plan includes a Coordinate Measuring Machine (CMM) program, a printout of the program shall be provided. If the plan includes dedicated tooling (for set-up), a diagram or photo of the tooling and/or set up shall be provided.

NOTE 2:

If the tooling has been manufactured by the Supplier, and procured by H&W, then the Supplier shall provide a copy of the tooling drawing or specification.

The FAIR cannot be approved until all items described above are received by H&W.

The specimen (see 2 above) must be identified with a tag to include the following information:

- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and

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e) The phrase “First Article”.

The shipping documents must clearly state the delivered item is a “First Article” and reference the PO line that specifies first article (if applicable).

The above items shall be reviewed by H&W to validate the product of the Supplier’s manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

Once the process validation is accomplished, the Supplier’s manufacturing instructions (see 3 above) are “frozen”. When the Supplier plans a change to the manufacturing process that affects the fit, form (including any changes of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

43. VALIDATION OF ASSEMBLIES (MECHANICAL, ELECTRO- MECHANICAL AND HYDRAULIC)

The Supplier’s manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items.

The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.
- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

The Supplier shall provide the following PRIOR to delivery of production parts:

- 1) A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B. FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) The first article specimen (the part from which the actual FAIR recorded values are derived),
- 3) A copy of the Supplier’s manufacturing instructions (router, traveler, etc.),
- 4) Acceptance test data sheet per drawing or specification (if acceptance testing is required by PO),
- 5) Inspection plan*, and

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6) Tooling and/or test equipment drawing or specification (if the PO includes tooling).

***NOTE:**

The inspection plan is to describe at what stage(s) of manufacture inspection will be performed and how it will be accomplished.

The FAIR cannot be approved until all items described above are received by H&W.

The specimen (see 2 above) must be identified with a tag to include the following information:

- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and
- e) The phrase “First Article.”

The shipping documents must clearly state the delivered item is a “First Article” and reference the PO line that specifies first article (if applicable).

The above items shall be reviewed by H&W to validate the product of the Supplier’s manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

Once the process validation is accomplished, the Supplier’s manufacturing instructions (see 3 above) are “frozen”. When the Supplier plans a change to the manufacturing process that affects the fit, form (including any change of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

44. VALIDATION OF CASTINGS AND FORGINGS

The Supplier’s manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items.

The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.
- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

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The Supplier shall provide the following PRIOR to delivery of production parts:

- 1) A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B. FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) The first article specimen (the part from which the actual FAIR recorded values are derived),
- 3) Tooling 2 drawing or specification (if the PO includes tooling), and
- 4) Physical and chemical test reports

NOTE 1:

The inspection plan is to describe at what stage(s) of manufacture inspection will be performed and how it will be accomplished. If the inspection plan includes a Coordinate Measuring Machine (CMM) program, a printout of the program shall be provided. If the plan includes dedicated tooling (for set-up), a diagram or photo of the tooling and/or set up shall be provided.

NOTE 2:

If the tooling has been manufactured by the Supplier, and procured by H&W, then the Supplier shall provide a copy of the tooling drawing or specification.

The FAIR cannot be approved until all items described above are received by H&W.

The specimen (see 2 above) must be identified with a tag to include the following information:

- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and
- e) The phrase "First Article".

The shipping documents must clearly state the delivered item is a "First Article" and reference the PO line that specifies first article (if applicable).

The above items shall be reviewed by H&W to validate the product of the Supplier's manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

Once the process validation is accomplished, the Supplier's manufacturing instructions (see 3 above) are "frozen". When the Supplier plans a change to the manufacturing process that affects the fit, form (including any change of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

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NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

45. VALIDATION OF CRITICAL PARTS NOT COVERED BY OTHER SPECIFIC 40 SERIES

The Supplier's manufacturing method must be validated to meet drawing requirements PRIOR to delivery of production items.

The Supplier shall provide the following PRIOR to start of production:

- 1) A copy of the proposed shop traveler with all in process inspection points for H&W approval.
- 2) The in-process inspection will be performed by H&W source inspection.
- 3) Source inspection request will be by email, 1-2 days prior completion of the operation for source to be scheduled. This is required for all inspection operations and FAI review.

The Supplier shall provide the following PRIOR to delivery of production parts:

- 1) A First Article Inspection Report (FAIR) in accordance with the requirements as outlined in Appendix B. FAI will be reviewed and accepted by H&W source inspector. Ref. AS9102 Form 1, Block 23 (Inspector name & stamp).
- 2) The first article specimen (the part from which the actual FAIR recorded values are derived),
- 3) A copy of the Supplier's manufacturing instructions (router, traveler, etc.),
- 4) A copy of the Supplier's inspection plan, and
- 5) Tooling drawing or specification (if the PO includes tooling).

NOTE 1:

The inspection plan is to describe at what stage(s) of manufacture inspection will be performed and how it will be accomplished. If the inspection plan includes a Coordinate Measuring Machine (CMM) program, a printout of the program shall be provided. If the plan includes dedicated tooling (for set-up), a diagram or photo of the tooling and/or set up shall be provided.

NOTE 2:

If the tooling has been manufactured by the Supplier, and procured by H&W, then the Supplier shall provide a copy of the tooling drawing or specification.
The FAIR cannot be approved until all items described above are received by H&W.

The specimen (see 2 above) must be identified with a tag to include the following information:

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- a) The Supplier name,
- b) The part number,
- c) The revision letter,
- d) The FAIR date, and
- e) The phrase “First Article”.

The shipping documents must clearly state the delivered item is a “First Article” and reference the PO line that specifies first article (if applicable).

The above items shall be reviewed by H&W to validate the product of the Supplier’s manufacturing process meets requirements. H&W Procurement shall notify the Supplier of the results. If the results are positive, the H&W Buyer shall notify the Supplier that production material may be delivered. If the results are negative, the Buyer shall notify the Supplier of the reason for disapproval.

NO PRODUCTION MATERIAL MAY BE DELIVERED WITHOUT APPROVAL BY H&W.

Once the process validation is accomplished, the Supplier’s manufacturing instructions (see 3 above) are “frozen.” When the Supplier plans a change to the manufacturing process that affects the fit, form (including any changes of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

46. FROZEN PROCESS

Once the process validation is accomplished, the Supplier’s manufacturing instructions are “frozen”. When the Supplier plans a change to the manufacturing process that affects the fit, form (including any changes of material), or function of the product, including sub-tier suppliers used for manufacturing or special processing, the Supplier shall submit the proposed change to H&W for approval. H&W reserves the right to reject process changes based on the effect of the changes on the final product.

51. CRITICAL PARTS REQUIREMENTS

- a) Collins Standard S-370 identifies Critical Parts and specific manufacturing procedures for processing and handling of the parts.
- b) All Supplier manufacturing documents: Drawings, Work Sheets, Routers, Inspection Plan, Control Plans shall be clearly identified with “Critical Part” to bring attention to personal Involved in manufacturing and inspections,
- c) In addition, a statement will added to the documentation “Frozen Process no changes to this process shall be made without Collins approval”
- d) Provision for Collins approval shall be added to supplier planning or router document master.

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All of the manufacturing personnel must be trained on the interpretation of “Critical Part” and objective evidence of the training created for all personnel working with the parts this QCR applies to.

52. REQUIREMENTS FOR REPAIR STATION SUPPLIERS

Suppliers performing work or services for H&W repair station products must comply with FAA Regulation - Drug & Alcohol Testing CFR Part 120 by:

- a) Maintaining a current FAA Repair Station Part 145 Certificate or,
- b) Register with the FAA and begin a drug testing program,
- c) Initiate and maintain a testing program that meets CFR 120 requirements,
- d) Provide evidence of compliance of CFR. Part 120 to H&W prior to acceptance of work.

52A. GOVERNMENT PROPERTY MANAGEMENT THAT APPLIES TO REPAIR STATION SUPPLIERS:

For products submitted to repair station suppliers that are government property, the Supplier has the following obligations for controlling property and will:

- a) Maintain records, secure, protect, and maintain property
- b) Ensure property is used only where authorized by the assigned contract, including purchase order and sub-contractors
- c) Ensure proper disposition of property as required

Government Furnished Property (GFP) FAR 52.245-1(a) - Property in the possession of, or directly acquired by, the Government and subsequently furnished to the Contractor for performance of a contract. Government-furnished property includes, but is not limited to, spares and property furnished for repair, maintenance, overhaul, or modification. Government furnished property also includes contractor-acquired property if the contractor-acquired property is a deliverable under a cost contract when accepted by the Government for continued use under the contract.

Government Property (GP)- All property owned or leased by the Government and includes Government Furnished Property (GFP) and Customer Acquired Property (CAP). GP also includes material, equipment, special tooling (ST), special test equipment (STE) and real property.