Collins Aerospace	PROCEDURE		BE-PUR-P7.4.3 Rev M
A United Technologies Company			Page 1 of 39
Interiors	ISO 9001	AS9100	Rev. M
		8.4	Effective: 01 April 2024
SUPPLIER QUALITY REQUIREMENTS			

APPROVALS

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1. PURPOSE

To define Collins Aerospace, Interiors specific supplier quality requirements in addition to requirements within COL-ASQR-PRO-0003. References within this document to 'Collins' or 'Collins Aerospace' applies to the Interiors group only.

For guidelines on implementing supply chain best practices, reference IAQG Supply Chain Management Handbook (SCMH) at scmh.iaqg.org.

2. SCOPE

When this document is referenced in Collins Aerospace purchase order requirements or other supplier agreements, suppliers and their sub tier suppliers are responsible for compliance to all applicable requirements herein and in COL-ASQR-PRO-0003. COL-ASQR-PRO-0003 does not have to be specifically called out and is invoked by this document.

These requirements apply to Suppliers that furnish product, material, processes, or product related services to the Interiors SBU within Collins Aerospace, regardless of Supplier's industry, regulatory accreditation, or certification status. Supplier shall be responsible for ensuring that all members of their supply chains comply with the applicable requirements set forth herein.

Compliance to revisions of this document must be established within 120 days of effectivity date unless otherwise stated.

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3. RESPONSIBILITY

Collins Aerospace is responsible for including this document in purchasing contracts, purchase orders, and agreements for products, materials, processes, or product related services.

The Supplier is responsible for complying with all documents referenced herein. It is the responsibility of the supplier to obtain and maintain current revision levels of all applicable referenced documents.

Suppliers that have long-term supply contracts with Collins must demonstrate and maintain compliance with these requirements to be eligible to receive Collins orders. Failure to comply with the requirements herein may result in the disqualification of the supplier.

The requirements contained herein are to be satisfied in addition to any other contractual requirements levied by Collins. The Supplier is responsible for the immediate communication to Collins of any conflicts between existing contracts and the requirements herein.

Suppliers are also responsible for flowing down and ensuring that all members of their supply chain comply with Collins requirements.

Collins Aerospace verification activities performed at any level of the supply chain does not absolve the organization of its responsibility to provide acceptable processes, products, and services and to comply with all industry requirements.

The Supplier shall provide contact information and access to the person responsible for ensuring that Collins requirements are promoted throughout the organization. Said person must have the authority to resolve quality concerns.

3.1. Appendices

All the appendices to this document have been incorporated into this document and so are now null and void. To determine site specific requirements, please refer to table 2 in section 15.

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4. DEFINITIONS

Refer to COL-ASQR-PRO-0003 for additional terminology and definitions applicable to this document.

4.1. Terminology clarification:

- The words 'shall' or 'must' indicate a requirement.
- The words 'should' or 'may' indicate a recommendation.
- The symbol:
 \(\Delta\) indicates a requirement which is relevant only to specific site(s) and/or part type(s). Table 2 in Section 15 defines the site(s) and part types(s) for which requirement is applicable.

4.2. Abbreviations, Acronyms & Definitions

- ADCN Advanced Drawing Change Notification.
- AECA Arms Export Control Act.
- ASL/AVL Approved Supplier/Vendor List.
- BSP Buyer-Supplier Portal.
- BU Business Unit.
- CAA Civil Aviation Authority.
- CMMI Capability Maturity Model Integration.
- Collins Procurement/Supply-chain/Purchasing Procurement
 Department of the Collins Aerospace site/division with which the supplier
 is doing business.
- Collins Quality Quality Department of the Collins Aerospace site/division with which the supplier is doing business.
- DDN Drawing Deviation Notification.
- Delegated Supplier A supplier which has demonstrated maintained acceptable performance.
- EAR European Arms Regulations.
- ECG Engineered Components Group.
- EMCD Electronic Manufacturer Component Data.
- EMNOC Electronic Manufacturer Notice of Change.
- FAIR First Article Inspection Report.

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- FTR Functional Test Report.
- IFE In Flight Entertainment.
- ITAR International Traffic in Arms Regulations.
- MANSPEC/MPS Database Manufacturing Process Specification Database.
- MPS Manufacturing Process Specification.
- NADCAP/Nadcap National Aerospace & Defense Contractors Accreditation.
- NOE Notice of Escape.
- NOPQE Notice of Potential Quality Escape.
- PDR Product Deviation Request.
- PDV Pre-Delivery Variance.
- PMA Part Manufacturer Approval.
- PPM Parts Per Million.
- REACH Registration, Evaluation and Authorization of Chemicals.
- RoHS Restriction of Hazardous Substances.
- SCAR Supplier Corrective Action Request.
- SBU Strategic Business Unit.
- SPG Seating Products Group (Kilkeel site & Winston-Salem seating site [previously known as Westpoint & Fairchild sites]).
- Sub-tier Supplier Tier 2 and lower suppliers who provide product or services which will be incorporated into tier 1 product.
- Supplier Planned Work Transfer / Supplier Managed Work Transfer Transfer of work when a Collins Aerospace supplier is changing the source from one plant site to another, or a change in their sub-tier supply chain.
- Tier 1 Supplier Organization that provides and furnishes product or services to Collins Aerospace.

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5. REFERENCES

Refer to COL-ASQR-PRO-0003 for additional references applicable to this document.

- ARP-6448 Gaining Approval for Seats with Integrated Electronics in Accordance with AC-21-49 Section 7.b.
- AS9115 Requirements for Aviation, Space and Defense Organizations Deliverable Software
- ASQR-01 Form 2 Change Notification
- ASQR-01 Form 3 Supplier Request for Information
- ASQR-01 Form 4 Work Transition
- ASQR-01 Form 6 NOPQE
- ASQR-01 Form 9 Qualified Distributor List Request
- ATA-300 Specification for Packaging of Airline Supplies
- CAA Form 1 CAA Authorized Release Certificate
- COL-FRM-0053 QMS Waiver/Exclusion Request
- D6-85622 Foreign Object Debris/Foreign Object Damage (FOD) Prevention Requirements for Boeing Suppliers
- INT-QA-PRO-0006 First Article Inspection
- INTSQR-01 First Article Inspection Requirements
- SPG-MPS-102 Seating Products Group Requirements for Vendor Submitted
 Data
- 70-0003 Cosmetic Inspection Standard (Nieuwegein site and Tanauan, Philippines Ovens site)

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6. GENERAL QUALITY SYSTEM REQUIREMENTS

New suppliers to Collins Aerospace shall be ^{3rd} party certified by an industry accredited body per Section 5.1 and Table 5.1 of COL-ASQR-PRO-0003.

Existing suppliers have 3 years from the effectivity date of this document to become compliant to the certification requirement or obtain a waiver/exception from Collins.

If not 3rd party certified, waiver/exception approval is required using form COL-FRM-0053.

Suppliers shall immediately inform Collins if they lose or fail to renew their QMS certification(s).

Suppliers of critical parts may be required to comply with various FAA/EASA/CAA requirements as well as AS/ISO and NADCAP standards.

The Supplier's quality system shall be maintained to ensure that all products and services offered for acceptance are subjected to all the examinations and tests required to prove conformance to contract or purchase order requirements.

A list of potential changes that could affect product quality and require notification using ASQR-01 Form 2 or equivalent is defined in COL-ASQR-PRO-0003 section 5.7. Collins Aerospace approval of ASQR-01 Form 2 or equivalent does not relieve the supplier of responsibility to meet design characteristics requirements.

6.1. Right of Access

Refer to COL-ASQR-PRO-0003 section 5.6. In addition to this, the Supplier is subject to initial and periodic reviews including but not limited to onsite audits, offsite reviews of quality documents, quality system surveys and source inspections to verify and validate the effectiveness of the quality management system. The Supplier shall provide all necessary information, facilities, equipment, documentation, and personnel required to perform said activities at no additional cost to Collins. These reviews are used to determine the approval status of all Collins suppliers and failure to accommodate the abovementioned reviews may result in the disqualification of the Supplier for future Collins PO's.

6.2. General Communication Requirements

For communication with Collins Aerospace, the supplier shall have the capability to communicate in English including the following documents unless otherwise approved by Collins Aerospace:

Quality manual.

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Process documentation requiring Collins Aerospace review or approval.

 All formal communication (e.g., Collins Aerospace specific Forms, First Article Inspection (FAIs), APQP documents, etc.).

In cases where the supplier maintains copies in their native language as well as in English, the supplier must document which one takes precedence if there is a conflict.

Supplier shall only accept agreements and instructions through formal processes (e.g., purchase order, purchase order supplements/amendments, ASQR-01 Forms and SBU forms or processes).

Agreements and instructions through non-controlled methods such as verbal conversations, e-mails, red-lined drawings, golden samples, shall not be construed as Collins approval or authorization.

All communications related to the fulfillment of PO requirements shall be carried out through Collins Procurement in writing. Communication associated with quality issues including but not limited to nonconformities, corrective action and supplier assessment activities shall be carried out with both Collins Procurement and Collins Quality included on all communications.

6.3. Quality Alerts

Refer to COL-ASQR-PRO-0003 section 5.4

6.4. Government Industry Data Exchange Program (GIDEP)

Refer t to COL-ASQR-PRO-0003 section 5.5.

7. DOCUMENTATION REQUIREMENTS

7.1. Control of Documents & Data

The Supplier is responsible for the control of Collins proprietary documents and for ensuring that they are controlled to preclude their use for other than Collins contracted work.

The Supplier is responsible for acquiring copies of industry or government documents and/or standards available from commercial sources. Any problem experienced by the Supplier in obtaining required documents should be brought to the immediate attention of Collins Procurement prior to acceptance of work.

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7.1.1. MANSPEC/MPS Database

Various Manufacturing Process Specifications (MPS) are made available to suppliers via a controlled website portal. When required, supplier access to the MANSPEC/MPS database is restricted to holders of an ID & Password which is only granted to approved suppliers.

Supplier access to the MPS database is restricted. If you are an approved supplier, you may access to the MPS database as follows:

- Go to https://mps.beaerospace.com
- Click "Global Support"
- Click "Supplier Access"
- Look for section titled "Manufacturing Process Specifications"
- If you are new to MPS, click "Account Request Form" and follow the instructions to request MPS access from one of the Collins sites with whom you are approved
- If you already have ID and Password, proceed to login
- Use the search function to locate and download the required documents

The MPS database contains only certain proprietary specifications that are referenced on a Collins PO or part drawing. The MPS database will not contain technical specs (such as ASTM) that are protected by copyright laws and are commercially available. It is the supplier's responsibility to assure that they have the most current revision of any Collins specification prior to PO acceptance and manufacture.f

Supplier should contact their Collins Site Purchasing representative if any of the non-commercial specifications, forms or documents required for fulfillment of a PO is not available in the MPS database.

7.1.2. Buyer Supplier Portal (BSP)

Purchase Order engagement, acceptance and fulfillment with suppliers is handled via the BSP. The BSP is also the source for the Supplier Performance Scorecards.

7.1.3. ASQR-01 Forms

ASRQ-01 Forms are RTX level forms that can be used by suppliers to communicate to Collins, they are available online at: https://www.rtx.com/suppliers/united-technologies-suppliers/united-technologies-asqrd

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Submittal of ASQR-01 forms to Collins should be through the Collins buyer.

7.1.4. Supplier Quality Resource Portal

The Supplier Quality Resource Portal provides resources ("how to" recordings & documents) related to Quality risk mitigation tools/processes, such as Advanced Product Quality Planning (APQP), Production Part Approval Process (PPAP), Supplier Managed Work Transfer, Zero Defect Plan (ZDP™), along with other topics and can be found at: https://portal.rockwellcollins.com/web/suppliers/supplier-quality-training-welcome

7.1.5. Terms & Conditions

For RTX Terms & Conditions visit: https://www.rtx.com/suppliers/purchase-terms-and-conditions

7.2. Control of Records & Documents

The Supplier shall retain production documentation and quality records for a period of 10 years after final payment. This documentation must include all Material Certifications, Work Orders, approved NCRs/PDRs, Special Process Certifications, Test Reports, Inspection Records, and Shipping Documentation.

Before destruction of records, the supplier shall inform Collins, and Collins reserves the right to have the records transferred to Collins. The disposition of documents post retention period will be by secured destruction methods.

The supplier is responsible for ensuring that records remain legible, readily identifiable, and retrievable.

The Supplier is responsible for the transfer of records to Collins in the event of the Supplier ceasing operation.

The Supplier shall remain responsible for the requirements above regardless of whether the Supplier remains an approved Collins supplier or not.

The supplier shall not use any method to obliterate or permanently alter original data on certifications, test reports or other quality documents. Prohibited methods include, but are not limited to; write-over, white-out & erase.

Changes to documented information (e.g., work instructions, travelers, routers, test reports, shipping documents) shall be recorded, dated, and traceable to a qualified person making the change (e.g., name, signature, stamp, electronic signature) with a permanent marking method and the original information being legible and retrievable after the change.

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8. PRODUCT REALIZATION

8.1. Planning of Product Realization

Prior to acceptance of work, the Supplier shall determine their ability to meet all PO requirements including the manufacture and inspection of all specified design characteristics. If the supplier cannot meet all requirements, they must request a concession (i.e. PDV/PDR) from Collins Procurement prior to acceptance of the work/PO.

8.1.1. Configuration Management

The Supplier's quality system shall provide for procedures which will ensure that the latest applicable drawings, specifications, and instructions required by the contract or PO, as well as authorized changes thereto, are used for fabrication, inspection, and testing.

8.1.2. Sub-tier Management

Sub-tier manufacturing and processing is acceptable so long as the Supplier performs the necessary inspection, verification, and certification activities prior to shipment to Collins.

The Supplier shall establish a process for the control of any work contracted to all sub-tiers, including Collins directed sub-tiers. This process shall include the verification of conformity of work contracted prior to shipment to Collins. The Supplier must ensure that the Collins requirements are met by all sub-tiers and shall maintain records accordingly.

It is the Supplier's responsibility to ensure that Collins property and proprietary data are controlled per contractual agreements at all levels of the supply chain.

The Supplier and sub-contractors shall not act as a broker for the manufacture and/or sale of product under Collins design control, to 3rd parties, without prior written authorization from Collins Quality and Procurement using ASQR-01 Form 2 or equivalent form.

When sourcing a Collins Aerospace designed part through distribution and the source is not designated on the drawing, the distributor shall ensure the product is procured from a current Collins Aerospace approved source.

All Distributors of raw metals, electronics, and hardware in the supply chain shall be on the RTX Qualified Distributor List (QDL) unless a directed Distributor is identified on the Collins Aerospace PO. The qualified distributors listed on the QDL can be found at https://www.rtx.com/suppliers/united-technologies-asqrd. ASQR-01 Form 9 shall be used to initiate adding a distributor to the RTX QDL.

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The Supplier shall notify Collins of any revision changes to sub-tier proprietary designs, drawings, specifications, materials, or manufacturing processes used in components or articles for Collins Aerospace using ASQR-01 Form 2 or equivalent form. Collins Aerospace approval of ASQR-01 Form 2 or equivalent does not relieve the supplier of responsibility to meet design characteristics requirements.

8.1.3. Work Transfers

Refer to COL-ASQR-PRO-0003 section 5.8.

Training on supplier planned work transfers can be found at: https://portal.rockwellcollins.com/web/suppliers/supplier-quality-training-welcome. This training also includes contact details for any questions about the process.

Supplier shall adhere to initial data submittal and subsequent change reporting process as defined in ARP-6448. EMCD & EMNOC will be submitted/processed via the Pro-View system. See Section 15.1 for applicability.

SPG-MPS-102 shall be complied with.

8.1.6. A Sub-Contract & Raw Material Procurement Outside USA

The supplier shall inform Collins of any sub-contract work or procurement of raw material from outside the USA.

8.2. Customer Related Processes

All documents including drawings, electronic design approved data & specifications are considered part of the PO requirements when specified directly on the PO or in documents referenced by the PO.

8.3. Purchasing

8.3.1. Purchasing Process

The Supplier is responsible for ensuring that product scheduled for delivery to Collins from sub-tier suppliers (including Collins specified suppliers) complies with all applicable provisions of drawing, specifications, and other requirements of the Collins PO.

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The Supplier shall maintain an Approved Supplier List. Criteria shall be established for sub-tier suppliers to achieve and maintain an approved status. The criteria shall not be limited to third party certifications. The Supplier shall establish periodic reviews of approved suppliers to determine their continued suitability.

When Collins establishes the requirement to use specific sub-tier suppliers, this requirement will be noted on the PO. The Supplier's system shall ensure that only the specified sub-tier suppliers are used to procure products or services for PO fulfillment. The Supplier shall maintain records of Collins authorization or selection of sub-tier suppliers.

All special processes shall be performed in accordance with the requirements of section 8.4.4 at all levels of the supply chain.

The use of distributors not authorized by the OEM, to trade components or parts is prohibited.

For product under Collins design control, the supplier must document changes to sub-tier manufacturing or raw material sources through partial or delta FAI per the requirements of section 8.4.1. This requirement applies at all levels of the supply chain.

8.3.2. Purchasing Information

The Supplier shall flow down all applicable product, regulatory, and quality requirements (including requirements for traceability, documentation, and software) to the Supplier's sub-tiers. The Supplier is responsible for ensuring and validating the compliance of the Supplier's sub-tiers and maintaining documented evidence of such per section 7.2.

8.3.3. Verification of Raw Material

The Supplier shall implement a process for the validation of raw material certifications (i.e., mill reports, etc.). The process of selection and testing must be defined (e.g., one sample from each sub-tier supplier per year). Said testing shall be performed at no additional charge to Collins. Dependent upon the material type, validation may include material composition testing, hardness and conductivity testing, flammability testing, etc. All testing used for validation must be conducted by personnel who are trained and/or by certified third parties. Records of the validation shall be retained per section 7.2. The Supplier shall flow this requirement down to relevant sub-tier suppliers.

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8.4. Production & Service Provision

The Supplier shall employ a system for controlling, documenting, and maintaining required product quality throughout the manufacturing process whether performed by the Supplier or the Supplier's sub-tiers. This shall include a step-by-step sequence of manufacturing operations and inspection points. This documentation shall provide objective evidence that the resultant product(s) conforms to the specified requirements.

Any test, prototype or qualification parts should be made under controlled conditions that ensure conformity to the applicable design data.

8.4.1. First Article Inspection

The supplier is responsible for completing FAIs and submitting FAIRs in compliance with INTSQR-01 for products under Collins design control. FAIs (including Partial or Delta FAIs) are required in accordance with INT-QA-PRO-0006 which is available from Collins upon request. Collins reserves the right to have the FAI performed by a Collins representative at the Supplier's facility. Should the initial submission be found discrepant, additional samples may be requested following correction of the cause of discrepancy by the Supplier. Collins Aerospace may request a supplier to perform or provide a copy of a FAI at any time.

Collins reserve the right to define how the FAIR is submitted. These methods of submission include, but not limited to; hard copy sent with part, soft-copy upload to a defined portal, or through Net-Inspect.

Collins acceptance of a FAIR does not relieve the Supplier of the responsibility for meeting all specifications and requirements on future shipments of the same product.

Certification for material, components, and special processes (anodize, chemfilm, molycote, etc.) must be noted on the FAI form and be supplied with the FAI sample part.

Where multi-cavity tools are used, FAIRs documenting the production results from each cavity must be completed.

For dress covers, Collins Aerospace reserves the right to request 2 fully conformed sets, along with the FAIR, to keep for future reference.

Suppliers of COTS parts and suppliers providing only special processing of parts are exempt from section 8.4.1.

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8.4.2. Control of Production Process Changes

Any production process related to products under Collins design control must not be altered without prior approval by Collins. Communication shall be made, using ASQR-01 Form 2 or equivalent form. Collins Aerospace approval of ASQR-01 Form 2 or equivalent does not relieve the supplier of responsibility to meet design characteristics requirements.

The Supplier shall define and implement a system that ensures equipment used for production is inspected, maintained, and validated prior to use. A schedule of this planned activity shall be documented.

8.4.3. Post Delivery Support

As required, all documentation supporting the build and verification of the product shall be made available within 24 hours of the submitted request.

All process nonconformities identified after shipment of product to Collins shall be communicated per the requirements of section 9.3.

8.4.4. Validation of Processes for Production & Service

For products under Collins design control, the Supplier's in-house or contracted special processes shall follow the requirements of the Table 1.

Special Process	Requirement	
Non-destructive Testing (e.g., radiographic, ultrasonic, fluorescent penetrant, magnetic particle)	Process must be performed by trained and/or certified personnel. Preference will be given to suppliers who obtain NADCAP and Boeing D1-4426 certification.	
Non-conventional Machining (e.g., electrochemical machining, electrochemical grinding, electrical discharge machining, laser beam machining, chemical milling)	Process must be performed by trained and/or certified personnel. Preference will be given to suppliers who obtain NADCAP and Boeing D1-4426 certification. Non-conventional machining methods shall only be used on products under Collins design control when defined on the engineering drawing, specification or PO.	
Shot Peening	Process must be performed by trained and/or certified personnel. Preference will be given to suppliers who obtain NADCAP and Boeing D1-4426 certification.	
Chemical Processing	-	
(e.g., Plating, Anodizing, Chemical Cleaning, Chemical Milling, Conversion / Phosphate Coatings, Paint / Dry Film Coatings, Plating, Stripping, Surface Treatment / Passivation, Etching)	Process must be performed by trained and/or certified personnel. Preference will be given to suppliers who obtain NADCAP and Boeing D1-4426 certification.	
Heat-treating, Hot Forming and Furnace Brazing	Process must be performed by trained and/or certified personnel. Preference will be given to suppliers who obtain NADCAP and Boeing D1-4426 certification.	
Painting	Process must be performed by trained and/or certified	

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	personnel.	
Oxygen Cleaning	Process must be performed by trained and/or certified personnel.	
Pressure Testing	Process must be performed by trained and/or certified personnel.	
Materials Testing (Metal testing only, hardness, conductivity, metallography, microhardness, mechanical testing, chemical analysis)		
Welding	When required by specification or PO requirements, welder must be certified to perform the indicated welding specification.	

Table 1 – Special Process Source Requirements

A Collins process source recommendation or requirement does not absolve the Supplier of the responsibility to ensure that the requirements of Table 1 are met. Collins reserves the right to change or create deviations from the requirements of Table 1 through specification or written Collins Quality approval.

When a specific process source is required by a Collins drawing or manufacturing specification, the Supplier is responsible to ensure that only the specified sources are used. Two examples are shown below:

- Structural bonding primer
- Honeycomb panel fabrication

NOTE: A listing of NADCAP approved sources is available at: www.prinetwork.org

8.4.5. A Embrittlement Relief

Where embrittlement relief is required, a copy of the oven chart must be maintained as per section 7.2. The chart shall show the time necessary to reach the appropriate temperature and the duration of bake-off required along with the actual times for both requirements.

8.4.6. Magnetic Particle Inspection

Track studs or other seat-to-aircraft load bearing parts (as defined by design) are subject to 100% magnetic particle inspection by the supplier. No crack or detectable defect is allowed unless authorized by Collins through concession process (e.g., PDV/PDR).

8.4.7. A Regrind

No regrind is allowable on plastic parts unless authorized by Collins through concession process (e.g., PDV/PDR).

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The Supplier shall have an established and documented process that implements/controls:

- Electrostatic Discharge (ESD) practices as applicable.
- Training programs that ensure all technicians are qualified to applicable industry standards regarding soldering, assembly, testing, etc. of components and harnesses.
- The use of lead free or tin-based solder which may be prohibited per spec or drawing. Certification of compliance is required.

Any contract that includes deliverable software development requires compliance to AS9115 or appraisal to CMMI level 4 or 5 and any additional PO requirements. AS9115 requires second party audits which Collins or a Collins customer reserves the right to conduct with minimum 14day notice.

When supplying software, the Supplier shall establish and maintain a Software Quality Assurance program in accordance with the applicable purchase order or contractual requirements and containing a risk management process and an SBoM.

8.4.10. Foreign Object Debris/Damage (FOD)

Assemblies/components delivering to Collins or direct to the installer will be free of FOD. Seller shall establish a FOD prevention program, this program should be in accordance with AS9146 or D6-85622.

When an FTR is required, each shipment must include the FTR including these minimum requirements:

- Part number & revision,
- Quantity,
- Serial Number and/or date code (as per specification)
- Specification requirement and actual reading,
- List of test equipment used, control number and calibration due date.

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8.4.12. Advanced Product Quality Planning (APQP) & Production Part Approval Process (PPAP)

APQP and PPAP per AS/EN/JISQ9145 may be invoked through the PO or any other contractual document issued by Collins Aerospace.

When invoked, the supplier shall submit (APQP or agreed equivalent) progress reports at intervals established by Collins. Reports will include at a minimum the following sections:

- Design review updates,
- Prototype/testing activities,
- Status of specific quality initiatives.

Where appropriate test specimens may also be requested by Collins.

The Supplier shall comply with the requirements for Advanced Product Quality Planning (APQP) and Production Part Approval Process (PPAP) per AS/EN/JISQ 9145.

When required by Collins, the Supplier shall flow down the requirements of APQP and PPAP to all members of the supply chain and maintain records for compliance.

When required by Collins, supplier shall reduce process risk and variation (i.e., using Process Failure Mode and Effects Analysis (PFMEA), control plans, and process control methods).

For guidelines on implementing APQP and PPAP, reference the IAQG SCMH and templates.

8.4.13. Non-Deliverable Software Control

When supplying software, the Supplier shall establish and maintain a Software Quality Assurance program in accordance with the applicable purchase order or contractual requirements.

For non-deliverable software used in manufacturing, inspection, test acceptance or calibration, that has a direct effect on the deliverable product, the supplier's process shall define (if applicable):

- Types of software to be controlled.
- How requirements are initiated, documented, approved.
- CMM correlation study.
- Naming Conventions and version controls.

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- Storage of master copies.
- Risk Management Program.

The Supplier shall comply with cosmetic standard 70-0003 for all components, sub-assemblies and assemblies supplied to Collins.

8.4.15. Operator Self Verification Programs

When used, Operator Self Verification Programs shall comply with AS9162.

All Non-metallic materials must pass vertical burn test specified in Federal Aviation Regulation 25.853(a) /Code of Federal Regulations (CFR) 25.853(a). Notation that this regulation has been met shall be noted on the Certification of Conformance. The seller must be able to provide burn test results from an FAA approved test facility (which they keep on file) upon request of Collins or the FAA. Audits of certification statements of compliance may be performed by Collins.

Compliance to 14 CFR 25.853(a) must be established for each lot of raw material or change in manufacturing process used in the manufacture of nonmetallic parts for Collins. Each delivery of product to Collins must include a supplier C of C referencing the lot(s) of material used, original manufacturer's raw material certification(s), and a burn test report from a Collins approved test facility for each lot of material referenced.

Cushion assemblies must meet the requirements specified in Federal Aviation Regulation 25.853(c) /Code of Federal Regulations (CFR). 25.853(c). Notation that this regulation has been met shall be noted on the C of C. The supplier must be able to provide burn test results from an FAA approved test facility (which they keep on file) upon request of Collins or the FAA. Audits of certification statements of compliance may be performed by Collins to verify this ability. This note applies only to supplier designed and approved cushion assemblies. If Collins completed the subject cushion design and flammability approval, for certification purposes, only note section 8.4.16 applies.

8.4.18. Statistical FAI

Collins Aerospace reserves the right to invoke requirements for Statistical FAI (sFAI). This may be invoked through, but not limited to, work transitions, new product introduction, or if a part or site has a history of dimensional escapes. sFAI requires that, every quantitative feature on the design blueprint is

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measured on a 25-piece sample. Further information on sFAI can be found in the "ZDP™ How To Book", which can be provided upon request through https://portal.rockwellcollins.com/web/suppliers/supplier-quality-training-welcome.

A machine capability study should be used for dimensions produced by the same machine and process as an alternative to measuring every dimension on a specific part number and be defined by AS9103.

Alternatives for demonstrating process control can be used with Collins approval.

If destructive analysis is required to perform variable measurements an alternative approach to the sFAI may be used to demonstrate process capability. Typical parts may include complex castings, complex machining's, or composite molds.

sFAI does not apply to categorical (attribute) features that have either binary (i.e., presence or absence) or a fixed number of values (i.e., count).

Reference dimensions and "approximate" dimensions do not require sFAI measurements.

When required, sFAI shall be performed on lower-level parts and assemblies.

8.5. Identification & Traceability

8.5.1. Traceability

The Supplier is responsible to maintain traceability of product and materials through all stages of production including at sub-tier processing sources. The supplier's system shall ensure that products are traceable back to the raw material batch or lot from which they were made, including traceability to the source mill. Supplier's system shall also provide means to trace where raw materials have been used.

NOTE: The requirement for traceability applies to all raw materials and manufactured goods. Examples include but are not limited to alloys, sub-assemblies, machined components, composites, rubber, fabric, foam, and leather.

8.5.2. Identification

Part identification or part marking requirements vary between Collins SBUs/sites. The Supplier must comply with the requirements as defined by the engineering drawing, applicable part marking specification & PO.

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Containers with weight exceeding 35 pounds should be marked as 'Heavy' using appropriate signage (e.g., 'Heavy Load'/ 'Caution, Heavy' labels).

Each box/container/package shipped to Collins must have the part number(s) and quantity clearly displayed and legible on the outside of the packaging. Where one box/container/package is used for multiple part numbers, each part number must be separately sub-packaged within, this sub-packaging must have the part number and quantity clearly displayed and legible on the outside of the packaging.

When shipping raw material each unit must be uniquely identified by lot or batch.

8.5.3. Acceptable Signatures

The Supplier's system shall provide for the control of acceptable signatures or stamps as applicable regarding authority. This control shall include provisions for assignment, issuance, and use.

For computer generated signatures, the Supplier's system shall provide for the control of documents which do not bear the original signatures or where the name(s) of authorized official(s) are computer generated.

Signatures must be rendered in ink.

8.5.4. Counterfeit Risk Mitigation & Reporting

Refer to COL-ASQR-PRO-0003 section 6.7.

Part shall not contain any FAA-PMA (Federal Aviation Authority – Part Manufacturer Approval) markings. Accompanying documentation (e.g. Packaging, shippers, etc.) shall not contain anu FAA-PMA notifications or labeling.

Supplier must notify Collins when cast part(s) are used in the article delivered to Collins. FAA requires Collins verify that any part that is cast or has a cast component is properly identified as critical or noncritical per 25.621 and that a corresponding cast factor and inspection requirements are defined in the design.

Part marking requirements shall be carried out as directed by the drawing and/or per Process Specification for Part Marking (FSI-PS-4010).

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8.6. Customer Property

Refer to COL-ASQR-PRO-0003 section 6.5.

8.6.1. A FAR Control of Government and/or Customer Property

Supplier shall control Collins property, Government property and/or Collins Customer property in accordance with FAR 52.245-2 and FAR 52-245-5.

8.7. Preservation of Product / Packaging

The Supplier's quality system shall ensure that items shipped are effectively preserved, protected, and packaged to guard against damage, degradation, or loss during shipment, including road, sea, and air freight.

This is to be accomplished in accordance with best commercial practices unless otherwise specified on the PO or contract. The supplier shall implement production and packaging practices that ensure detection and removal of foreign objects and debris.

Age sensitive materials or products must be properly identified and labeled to ensure product conformity including necessary environmental conditions. Shipping documentation for age sensitive materials must include date of manufacture and expected product life or expiration date. Age sensitive materials must arrive at Collins with a minimum 80% shelf life remaining unless authorized by Collins through concession process (e.g., PDV/PDR).

The supplier shall ensure that all wood packing material used (eg. Pallets, crates & boxes) are in compliance with ISPN nr.15 (www.ippc.int).

Dangerous goods (per IATA definition) must be packed according to IATA regulations (<u>www.iata.org</u>).

8.7.3. ATA-300 & WI-0922

Supplier shall design and/or use packaging to protect from damage related to transportation and storage with the minimum requirements per ATA-300 and Collins Aerospace Packaging Requirements (WI-0922), latest revision found at:

https://www.rockwellcollins.com/Landing/interior-systems/%20%20%20%20interior-systems-quality-documents.aspx.

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Electrostatic discharge sensitive materials shall be protected/controlled per the latest revision of MIL-STD-1686. Suppliers of sensitive electronics are required to have an ESD Control Program Plan – recommended guidelines per MIL-HDBK-263 E3. Electrostatic discharge sensitive materials must be packaged in the proper protective packing, identified with the proper ESD labels, and receiving paperwork must not be placed inside the ESD bags with the components.

8.8. Control Plan

Collins reserves the right to require a control plan, including inspection steps identified. The control plan is subject to approval by Collins.

8.9. A Digital Data

Where applicable, the Supplier shall have a documented process for the control of digital data used for the purpose of design, manufacture, or inspection of materials, components, or articles. The document shall state adequate controls for:

- Verifying the integrity of digital data transfers (translation),
- Storage and maintenance of the digital data,
- Security (limited access) of the digital data,
- Traceability of all derivative data back to the original digital data,
- Effective control and management of changes (including digital data provided to sub tiers).

8.10. Acceptance Authority Media (AAM)

Refer to COL-ASQR-PRO-0003 section 5.10.

All wire/cable lengths must be continuous or longest lengths available. No splicing.

All unmated connectors shall be protected at all times during assembly, storage, and testing. Individually assembled connectors shall have their contacts or sockets protected with protective caps or other suitable packaging

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prior to shipment. Prior to placing caps on connectors, assure that the connectors are free of FOD.

9. MONITORING & MEASUREMENT

9.1. Monitoring & Measurement Equipment

9.1.1. Control of Monitoring & Measuring Equipment

Refer to COL-ASQR-PRO-0003 section 6.8.

All equipment used to verify or validate the conformance of product must be calibrated. All calibrated equipment shall be traceable to the National Institute of Standards Technology (NIST) or a National or International equivalent standard.

Collins shall be notified of any potential nonconformities resulting from equipment used to verify or validate the conformance of product found to be out of calibration (see section 9.3).

9.1.2. Monitoring and Measurement of Product

Refer to COL-ASQR-PRO-0003 section 6.9.

9.2. Collins Source Inspection

Suppliers to Collins are subject to Source Inspection, either contractually or as situations dictate. Source inspections will be performed by Collins and/or Collins Customer representative(s) at the Supplier's facility prior to shipment of items. The Supplier shall furnish at no additional cost to Collins, the necessary facilities, equipment, documentation, and personnel required to perform these inspections.

The source inspection may be a one-time event or continue until the requirement driving the source inspection has been satisfied. When the Supplier has been notified that source inspection is required, no parts are to be shipped until the source inspection has been completed or waived by Collins Quality.

Source Inspection of parts or materials by Collins and/or Collins Customers should not be used as an effective control of quality by the Supplier.

If the Source Inspection is contractual, Collins must be notified at least 10 working days in advance of shipment to permit scheduling of Source Inspection.

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If the Source Inspection is the result of a particular issue or on-going issues, Supplier is required to notify Collins as soon as possible prior to shipping.

Objective evidence of Collins and/or Collins Customer representative(s) Source Inspection must accompany each shipment. Such inspections shall not necessarily constitute final acceptance of the material and final acceptance shall be at the Collins facility.

9.2.1. A Inspection Costs

If Source Inspection is performed by Collins, the cost associated with the Source Inspection may be charged back to the Supplier. Collins will provide the Supplier with a detailed cost breakdown of the Source Inspection. Third Party Source Inspection at the Supplier's expense may also be levied. In this case, the Supplier will be responsible for payment directly to the Source Inspection agent.

9.3. Product Inspection Certification

Refer to COL-ASQR-PRO-0003 section 7.1 for requirements.

Also required, as applicable, are lot / batch numbers (in the case of raw materials, castings, and forgings), shelf-life information / expiration dates, serial numbers, and any part number reference information, for example if the Collins part number is different from the Supplier's part number.

When providing age sensitive materials or products the supplier shall include with the C of C the cure date and a statement that the minimum shelf life is remaining upon receipt, as detailed in section 8.7. Receipt will be at point of delivery into a Collins facility for supplier arranged shipping, and point of pick up for Collins arranged shipping.

For COTS parts, the supplier shall provide the catalogue page or similar technical data/drawing with each delivery.

If non-destructive testing is required by the drawing or specification, a copy of the test report shall be included with each shipment.

When sections 8.4.16 or 8.4.17 apply, the requirements within those sections must be included in the C of C.

If the material is toxic and/or hazardous as defined by applicable law, it must be accompanied by a Material Safety Data Sheet.

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9.4. Control of Non-Conforming Product

The Supplier shall establish a system for identification, segregation and documentation of any nonconforming product(s) found during the Supplier's manufacturing or inspection operations.

Neither the Supplier nor the Supplier's sub-tier(s) is granted Material Review Board (MRB) Authority for product under Collins design control.

Supplier shall have a system for reporting occurrences to ensure that parts with deviation from applicable design data that could lead to an unsafe condition are reported.

9.4.1. Shipping of Nonconforming Product

The Supplier shall not ship any nonconforming material to Collins without first receiving authorization through the MRB at the applicable Collins Site (see section 6.2 for rules on acceptable communication methods). These concessions (e.g., PDV/PDR) must be referenced on the accompanying CofC and be included with the shipping paperwork.

If Collins requirements conflict, the supplier can contact Collins for clarification using ASQR-01 Form 3. The order of precedence for documents is as follows, however, if the conflict means they cannot meet any of the stated requirements, they must receive authorization through the MRB at the applicable Collins Site prior to shipment.

- 1. Contract (e.g., PO, Long Term Agreement (LTA).
- 2. Drawing Referenced on PO.
- 3. Collins Aerospace Specifications Referenced on Drawing.
- 4. Industry Specifications Referenced on Drawing.

9.4.2. Notification of Escape

Within 2 business days of discovery of suspect non-conforming product having been shipped to Collins, the supplier shall notify their supply chain, supplier quality or site quality contact at the affected Collins sites using ASQR-01 Form 6 (Notification of Potential Quality Escape) or an equivalent containing the information requested in sections 1-20 of ASQR-01 Form 6.

9.4.3. Nonconforming Product Discovered at Collins

Any product found nonconforming at Collins may be returned to the Supplier with instructions from the applicable Collins-MRB.

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9.4.4. Product Field Failure or Malfunction

When a product field failure or malfunction is reported by Collins, Collins may request the Supplier to conduct a formal failure investigation and root cause analysis to identify the cause of the failure. Such investigation and analysis shall be completed within the specified time required by the relevant Collins SBU/site and shall include corrective and preventive action.

9.4.5. MRB Dispositions

The decisions and disposition instructions of the Collins MRB shall be binding to the Supplier's organization. Failure to comply with the given decisions and disposition instructions may result in formal corrective action or the disqualification of the Supplier as a supplier to Collins. If the Supplier does not agree with the disposition or can improve upon the disposition given by Collins MRB, the Supplier shall contact Collins and gain written approval via ASQR-01 Form 3, prior to implementation.

Material to be scrapped shall have part number removed and be conspicuously and permanently marked or positively controlled, until physically rendered unusable.

If the Supplier does not agree with the liability/charges associated with a given rejection, the Supplier shall contact Collins Quality with supporting evidence.

Collins reserve the right charge back the cost associated with a verified nonconformance caused by the Supplier, that is not documented on a Collins approved deviation/concession (eg. PDV/PDR). Collins will provide the Supplier with a detailed cost breakdown associated with the nonconformance.

9.5. Corrective & Preventative Action

Suppliers shall have a documented procedure for corrective & preventative action which includes requirements to respond to Customer complaints and requests for corrective action. The supplier is required to utilize appropriate methods such as Eight Disciplines (8D) or an equivalent process for problem solving to develop appropriate root cause analysis and corrective & preventative actions.

The Supplier shall take prompt action to correct assignable conditions which have resulted, or could result, in products or services being offered to Collins for acceptance which do not conform to any of the following:

The quality assurance provisions of the item specification.

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- Inspections and tests required by the contract or purchase order.
- Other inspections and tests required to substantiate product conformance.
- The requirements contained herein.

When a quality system or product nonconformance is identified, Collins may request a formal corrective action response from the supplier through issuance of a SCAR.

The Supplier shall complete the corrective action response within the time frame specified by Collins.

9.6. Materials Acceptance Authority

The Supplier shall have no authority to accept materials, components, or articles on behalf of Collins unless the Supplier has been issued a formal letter granting such authority from Collins Quality.

9.7. Acceptance Sampling

Supplier shall perform 100% inspection for in-process and final inspection, or Supplier shall conform to the Acceptance Sampling requirements stated herein. Acceptance Sampling (statistical product acceptance) of parts and assemblies is authorized (except where prohibited by drawing or specific PO note), provided the Supplier has a documented process in place that meets the requirements of AS9138.

It is recommended that suppliers carry out plating integrity testing and raw material composition testing. It is recommended that an independent resource periodically test for these properties. The MPS for plating, etc., specifies extensive test requirements for chemical analysis, adhesion, salt spray, etc.

9.8. A Key Characteristics

All Key Characteristics identified in the materials, components, and articles technical requirements documents (i.e., Engineering Drawing, Parts Lists, Specifications, Purchasing Documents, etc.) shall be 100% inspected or require a Statistical Process Control Plan. The Supplier's Statistical Process Control Plan is subject to review by Collins at any time.

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9.9. Supplier Performance

Refer to COL-ASQR-PRO-0003 section 5.12.

9.10. Obsolescence Management

Refer to COL-ASQR-PRO-0003 section 6.6.

If the instance of obsolescence means the supplier cannot meet the requirements placed on them, authorization to ship non-conformances must be in compliance with section 9.3.1.

9.11. Operator Certification

Refer to COL-ASQR-PRO-0003 section 6.11.

9.12. Delegated Quality Representative (DQR)/Delegated Product Release Verification (DPRV)

Refer to COL-ASQR-PRO-0003 section 6.12.

9.13. Zero Defects Plan (ZDP)

Refer to COL-ASQR-PRO-0003 section 6.16.

9.14. Quality Control Actions

Refer to COL-ASQR-PRO-0003 section 6.17.

9.15. A Safety, Critical or Safety-Critical Characteristics

All Safety, Critical or Safety-Critical defined characteristics identified in the materials, components, articles and/or technical requirement documents (i.e., drawings, BoMs, specifications, purchasing documents, etc.) shall be 100% inspected. Statistical process methods for product acceptance of safety, critical or safety-critical characteristics or parts shall be submitted to Collins for approval. No sampling is allowed for safety, critical or safety-critical characteristics or parts.

9.16. Additional Customer Requirements

Supplier shall be informed when additional customer requirements are applicable.

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9.17. Advanced Drawing Change Notification (ADCN) & Drawing Deviation Notification (DDN)

In addition to released drawings, product may be conformed to ADCNs or DDNs for the 1st shipset only.

10. REGULATORY REQUIREMENTS

10.1. A Restriction of Hazardous Substances (RoHS)

Supplier shall provide a statement regarding the product's compliance to RoHS directives 2002/95/EC, 2011/65/EU, and all applicable amendments. This statement must be directly traceable to the shipped product (i.e. via shipment list, lot numbers, etc.) Identification of RoHS compliance is in addition to, not in place of, applicable material traceability requirements.

10.2. Registration, Evaluation and Authorization of Chemicals (REACH)

Suppliers are required to assist Collins in the registration and accounting of certain substances used in the production of articles we export to Europe.

10.3. Direct & Drop Shipment

Direct/Drop shipments to Collins customers or suppliers are prohibited unless specifically defined and approved by the Collins site issuing the PO.

Those suppliers approved by Collins to ship product direct to Boeing shall place the following statement on the shipping documentation:

"Seller hereby acknowledges that the parts and/or materials being shipped under this order are intended for use under Boeing's Federal Aviation Administration (FAA) issued Production Certificate 700 and no articles (or constituent parts thereof) or the accompanying paperwork (e.g., packages, shippers, etc.) contain any Federal Aviation Administration- Parts Manufacturer Approval (FAA-PMA) markings."

The required location of the statement is on the shipping document, following the C of C. The statement may be printed, stamped or attached as a label or sticker to the shipping documentation. It is permissible to replace the word "Seller" with the company name. The Supplier must provide a statement on the packing sheet certifying its quality assurance department has inspected the parts and they adhere to all requirements, applicable drawings/specifications.

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10.4. AECA, ITAR and EAR Provision

Suppliers who design, procure, produce, process, import or export designated defense articles or services may be subject, under US law, to the requirements of AECA, ITAR or EAR. It is the supplier's responsibility to ensure they are compliant applicable laws.

10.5. Military/Defense Flow Down

When the purchase order is related to military contracts, the supplier shall comply with the DFAR and related Prime Contract flowdown.

DPAS Rated Orders (DX) are certified for national defense use.

All parties are required to follow all provisions of the Defense priorities and allocations systems regulations (15 CFR 700). In essence, this means that no commercial work shall take precedence over this military order.

Elimination of use of Class I ozone depleting substances in Air Force procurement.

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11.SUPERSEDED DOCUMENT(S)

All appendices to BE-PUR-P7.4.3 are superseded by this revision and are now obsolete. List of appendices included below for reference.

Appendix	SBU/Site	Notes
A	Aftermarket Services: Winston-Salem / Leighton Buzzard / Tanauan	Obsolete, requirements now included in this document.
B	Seating Products Group (SPG)	Obsolete, requirements now included in this document.
C	Kilkeel (obsolete, see Appendix B)	Obsolete, requirements now included in this document.
D	Leighton Buzzard	Obsolete, requirements now included in this document.
E	Miami (Medley)	Obsolete, requirements now included in this document.
F	Lenexa / Tanauan (Refrigeration Products)	Obsolete, requirements now included in this document.
G	Lenexa / Tanauan (OXY/BMP)	Obsolete, requirements now included in this document.
H	Nieuwegein / Tanauan	Obsolete, requirements now included in this document.
I	Everett (FSI)	Obsolete, requirements now included in this document.
J	Holbrook	Obsolete, requirements now included in this document.
K	Westminster	Obsolete, requirements now included in this document.
L	N/A	Obsolete, requirements now included in this document.
M	N/A	Obsolete, requirements now included in this document.
N	Lübeck	Obsolete, requirements now included in this document.
O	Everett LSS	Obsolete, requirements now included in this document.
P	ALCI – Everett / Tanauan and Water Solutions	Obsolete, requirements now included in this document.
Q	Teklam	Obsolete, requirements now included in this document.
R	Engineered Components Group (ECG)	Obsolete, requirements now included in this document.
S	Philippines (A350 Galley)	Obsolete, requirements now included in this document.

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12.FLOWCHART(S)

N/A

13. APPENDICES

13.1. Site Specific Applicability Table

This table defines the site(s) and part type(s) for which non-standard requirements (signaled by the \triangle symbol) are applicable.

Section	Applicable Site(s) Including Plant Number and Previous Appendix	Applicable Supplier Type(s)	
	- — — — — — — — — — — — — — — — — — — —	(defined by section 15.2)	
8.1.4	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 5 & 8	
8.1.5	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 8, 9 & 12	
<mark>8.1.6</mark>	Lenexa (00340) & Tanauan (00341) - (G).	All Types	
	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 2 & 4	
8.4.5	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types	
	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 2 & 4	
8.4.6	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types	
	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Type 1	
8.4.7	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types	
8.4.8	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 3, 4, 5 & 8	
	Leighton Buzzard (00365) - (D).	All Types	
	Lenexa (00340) & Tanauan (00341) - (G).	All Types	

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8.4.9	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 5, 8 & 11
8.4.11	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	All Types
8.4.14	Nieuwegein / Tanauan (00350) - (H).	All Types
0.4.14	Lenexa (00340) & Tanauan (00341) - (G).	All Types
8.4.16	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types
8.4.17	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types
<mark>8.5.5</mark>	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6 & 8
<mark>8.5.6</mark>	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 2, 3, 4, 5 & 8
<mark>8.5.7</mark>	FSI Everett (00360) – (I).	All Types
<mark>8.6.1</mark>	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	All Types
	Engineered Components Group (00263) - (R).	All Types
8.7.1	Nieuwegein / Tanauan (00350) - (H).	All Types
8.7.2	Nieuwegein / Tanauan (00350) - (H).	All Types
8.7.3	Bohemia (00612)- (J).	All Types
8.7.4	Bohemia (00612)- (J).	All Types
0.0	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 8, 9 & 12
<mark>8.9</mark>	Leighton Buzzard (00365) - (D).	All Types
	Lenexa (00340) & Tanauan (00341) - (G).	All Types
<mark>8.11</mark>	Bohemia (00612)- (J).	All Types
9.2.1	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 9 & 12
9.4.6	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 9, 10, 11 & 12
	Lenexa (00340) & Tanauan (00341) - (G).	All Types
9.7	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 8, 9 & 12

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	Leighton Buzzard (00365) - (D).	All Types
	Winston Salem SAO (00274), Leighton Buzzard SAO (00250) and Philippines SAO (00280) – (A).	All Types
	Lenexa (00340) & Tanauan (00341) - (G).	All Types
9.8	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6, 8, 9 & 12
	Leighton Buzzard (00365) - (D).	All Types
	Lenexa (00340) & Tanauan (00341) - (G).	All Types
9.15	Lenexa (00340) & Tanauan (00341) - (G).	All Types
9.17	FSI Everett (00360) - (I).	All Types
10.1	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601) - (B).	Types 1, 2, 3, 4, 5, 6 & 12
10.5	Bohemia (00612)- (J).	All Types

Table 2 - Site Specific Requirement Applicability

13.2. Part Type Definitions

This table defines part types (which, if applicable, will be stated on the PO) and the sites which use these definitions.

Type	Description	Site(s) using this type
1	Build to print: plastics & composites.	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
2	Build to print: machinings, stamped parts, castings & weldments.	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
3	Build to print: electrical assemblies & electronic components	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
4	Design & manufacture: mechanical assemblies	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
<mark>5</mark>	Design & manufacture: electrical & electromechanical assemblies	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
<mark>6</mark>	Soft goods: cushions, diaphragms, dress covers, etc.	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
<mark>7</mark>	Hardware, catalogue parts, COTS parts	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)

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8	IFE	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
9	3 rd Party Procured Tooling	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
10	Services, testing & calibration	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
11	Software	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)
12	Outside manufacturing processes	Kilkeel (4501), Winston-Salem Seating (4001/4002) & Philippines Seating (4601)

Table 3 – Site Specific Part Types

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	REVISION HISTORY				
Rev	Release Date	Modification Description	Author		
Α	Jul 2010	New Release	-		
В	Sep 2012	Revised Appendix G & added Appendix P.	_		
		Restructured the required approval signatures.			
_		Revised para 6.2 to include explicit reference to legibility and retrieval.			
С	Dec 2012	Change of document retention period.	-		
		Update table of content numbering.			
		Removed QSI link and reference.			
		Added revising authority.			
D	Nov 2013	Added Appendix revision status and bookmarks.	-		
		Added definitions, activated PRI-Network link, amended 10.5.1 details on Traceability.			
E	Apr 2016	Removed verbiage from section 9.0, Resource Management and relocated it to section 6.0, General Quality System Requirements.	-		
F	Apr 2018	Edited Section 6.0 (Quality System) and 7.2 (Control of Records) – added disposition.	-		
G	May 2018	Added Appendix S - Philippines	-		
Н	Jan 2019	Updated the following sections: 9.0, 10.4, 10.8, 11.3	-		
J	Apr 2020	Updated the following sections: Appendix Table	-		
		Added Section 6.2 General Communication Requirements			
K	Aug 2022	Added guidance on marking of containers exceeding 35lbs - Section 10.5.2	Patricia Cunningham		
		Updated NOE requirements to align with ASQR-01 – Section 10.3.2			

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L	Nov 2022	Document reformatted using Interiors Procedure Template INT-QA-TMP-0001. Section 6. Added requirement for new suppliers to be AS9100/9120 certified. Added requirement for suppliers to inform Collins if they lose or fail to renew QMS certification. Section 10.1.3. Work transfer section updated to require use of ASQR-01 Form 4 to comply with INT-QA-PRO- 0008. All instances of 'B/E' replaced with 'Collins'. Section 4. Abbreviations and definitions added. Approvals list updated. Appendix F & G titles corrected.	Simon McCartan
M	Dec 2023	All appendices obsoleted. Requirements from appendices added to this document. Rewrites to bring requirements into compliance with COL-ASQR-PRO-0003. Added site locations into SPG group to identify addition of Philippines Seating business unit. List or approvers updated – Supply Chain and Ops Quality removed. Supplier Quality approvers retained.	Simon McCartan