



*B/E Aerospace Enterprise Wide
Supplier Quality Requirements*



B/E - Enterprise Wide Quality

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: **Supplier Quality Requirements Appendix A**
REVISION: [Rev. F](#)
ISSUE DATE: [October 12, 2018](#)

**SITE SPECIFIC REQUIREMENTS FOR
B/E AEROSPACE, INC. – WINSTON SALEM (SAO)
WINSTON SALEM, NC
B/E AEROSPACE, INC. – LEIGHTON BUZZARD (SAO)
LEIGHTON BUZZARD, U.K.
B/E AEROSPACE, INC. – PHILIPPINES (SAO)
TANUAN PHILIPPINES**



B/E Aerospace, Inc. Seating Products Group

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B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
 TITLE: Supplier Quality Requirements Appendix A
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REVISION HISTORY

REV	Description	Page Status	Approved	Date
N/A	No Release			
A		All	Quality	April 2015
B	Updated all references to files and records being maintained from 7 years to 10 years, to align with the corporate requirements. Deleted Clause #56 from page 3, Quality Clause Table.	All	Quality	April 2016
C	Added note #58 for counterfeit parts, Unapproved parts and Detection and Reporting. Added note #59, Acceptance Authority Media (AAM)	Page 4 and 9	Quality	December 2017
D	Added note #60 for suppliers to comply with B/E Aerospace customer requirements when providing parts or services.	Page 9	Quality	February 2018
E	Added note #61 to reflect communication to the supply base of contribution to product or service conformity, to product safety, and their importance of ethical behavior as specified in AS9100 Revision D, section 8.4.3.	Page 10	Quality	April 2018
F	Added Leighton Buzzard and Philippines facilities to the appendix. Added verbiage to clause #24.	All	Quality	October 2018



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
 TITLE: Supplier Quality Requirements Appendix A
 REVISION: F
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Quality Note assignment method:

Purchase orders may contain numeric values that relate to specific quality requirements (clauses). The specific clauses noted in the table below relate to each particular commodity. Purchase Orders are not limited to these minimum requirements noted in the table. The definitions of the numeric values follow this table. Quality clauses do not supersede, but may be addition to, part drawing or other pertinent component documentation requirements. These Quality clauses are intended to assist the supplier with quality objectives.

QUALITY REQUIREMENTS:

COMMODITY	QUALITY CLAUSES
Items not categorized; Distributors, IFE or CFE	1,2,4,5,6,8,10,11,12,14,16,22,23,24,26,27,29,31,33,34,35,36,38,50,53,54,55,58,59,60,61
Hardware	1,2,4,5,6,8,10,11,12,20,22,23,24,26,27,29,31,33,34,35,36,38,44,50,52, 54,55,58,59,60,61
Cushions	1,2,4,5,6,8,10,11,12,20,22,23,24,26,27,29,30,31,33,34,35,36,38,39,50, 54,55,57,58,59,60,61
Vacuum Formed Parts	1,2,4,5,6,8,10,11,12,20,22,23,24,26,27,29,30,31,33,34,35,36,38,50,51,52, 53,54,55,57,58,59,60,61
Heat Treating	1,2,4,5,6,8,12,22,23,24,26,27,29,30,31,33,34,35,36,40,44,50,54,58,59,60,61
Machined Parts	1,2,4,5,6,8,9,10,11,12,21,22,23,24,26,27,29,30,31,33,34,35,36,40,44,50,51,52,54,55,58,59,60,61
Plating Operations	1,2,4,5,6,8,12,22,23,24,26,27,29,31,33,34,35,36,44,50,54,58,59,60
Dress Covers and Liners	1,2,4,5,6,8,10,11,12,22,23,24,26,27,29,30,31,33,34,35,36,38,50,54,55,57,58,59,60,61
Raw Materials, Castings, Forgings and Plastics	1,2,4,5,6,8,10,11,12,20,21,22,23,24,26,27,29,30,31,33,34,35,36,38,40,44,50,52,54,55,57,58,59,60,61
Injection Molded Plastics	1,2,4,5,6,8,10,11,12,20,22,23,24,26,27,29,30,31,33,34,35,36,38,50,51,53,54,55,57,58,59,60,61
Composite Parts	1,2,4,5,6,8,10,11,12,20,21,22,23,24,26,27,29,30,31,33,34, 35,36,38,50,51,53,54,55,57,58,59,60,61
Powder Coating and Painting	1,2,4,5,6,8, 10,11,12, 20,22,23,22,24,26,27,29,31,33,34,35,36,50,52,54,58,59,60,61
Track Studs, Track Fittings	1,2,4,5,8,9,10,11,12,13,14,15,16,17,19,21,22,24,26,27,28,29,30,31,34, 35,36,37,40,46,50,51,52,54,55,58,59,60,61
Gauge and Equipment Calibration	2,8,12,24,26,27,34,50,58,59,60,61

NOTES:

- CFE includes but is not limited to: customer supplied electronics, dress covers and raw material.
- All PO's for non-metallic materials (i.e. fabric and plastic materials) require burn test per FAR 25.853(a).
- Raw material: bar stock, sheet goods, flat plate, extrusion, castings, fabrics, adhesives, etc.



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

1. **First Article:** Prior to quantity delivery of articles specified in this order, Seller shall submit "First Article" inspection samples to Buyer or its representative. The Buyer reserves the right to have the First Article inspection performed by a representative of B/E Aerospace at the Seller's facility. The samples submitted (minimum two for dress covers, fire-block liners, and other sewn items created to a pattern) shall be accompanied by objective evidence of conformance to all drawing requirements and be representative of the production process. If more than one mold or cavity is used to manufacture product, the Seller must maintain objective evidence, on file, in the form of inspection results to substantiate compliance to all drawing requirements for each mold or cavity. Shipment of articles shall, unless otherwise directed by the Buyer, be withheld pending Buyer's written approval of the "First Article". Should the initial submission be found discrepant, additional samples may be requested following correction of the cause of discrepancy by the Seller. Buyer's approval of a "First Article" shall not relieve the Seller of responsibility for meeting all specifications and requirements on other parts delivered hereunder.

Note:

- A. First Article samples must be made from production tooling.
 - B. After First Article approval, no change in process, tooling or material can be made without first obtaining written permission from B/E Aerospace.
 - C. Any revisions or specification changes will require the repeat of this approval process unless waived by B/E Aerospace.
 - D. Material certification for metallic and nonmetallic components as well as certification for special processes (anodize, chemfilm, molycote, etc.) must be annotated on the FAI form and supplied with the FAI sample part.
 - E. All Non-metallic components, unless identified by the B/E Aerospace Certifications group as a "Minor Component", must include appropriate burn test report and showing compliance to FAR 25.853 / CFR 25.853. Make reference to PO note #57 for flammability validation requirements.
2. **Quality Control System:** The Supplier shall provide and maintain a Quality Control System that will assure B/E Aerospace that parts/materials are shipped defect free. The system shall provide for an effective program of preventing defects. The supplier shall also notify B/E aerospace in writing any changes to their Quality System and or any changes to their special processes.
 3. **Statistical Process Control:** The manufacturing process(es) used by the Supplier is crucial to the product delivered to B/E Aerospace. The refinement of the process(es) is directly related to the B/E objective to purchase only that product that is defect-free. Information feedback should be manufacturing process resultant that provides valuable data for a never-ending improvement in quality and productivity. Statistical Process Control is to be used by the Supplier to obtain and control those features and characteristics that effect manufacturing, function and reliability of the product. The Statistical Process Control Program must address employee training, gauge studies, machine/process capability studies, continual monitoring based on process capabilities supported with statistical data. Statistical Process Control methods must be applied to problem solving with a persisting commitment to improve the product.
 4. **Customer Source Inspection:** All work under this order is subject to B/E Aerospace's customer inspection and/or acceptance either on a random or 100 percent basis at the Supplier's facility during the performance of this contract.



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

5. **B/E Aerospace Source Surveillance Inspection:** Work under this order may subject to Buyer surveillance at Seller's plant if deemed necessary by the buyer. The Buyer's Quality Assurance Representative may elect to conduct inspection either on a random basis or to the extent of 100 percent inspection. Seller will be notified if in-process or final shipment inspection is to be conducted. No in-process or final shipment inspection is to be held for Buyer's inspection unless notification is received prior to or at the time of in-process inspection or material being ready for shipment.
6. **B/E Aerospace Source Inspection:** Items on this order may be subject to inspection and/or test at Seller's facility by the Buyer prior to shipment. Seller shall furnish at no cost, acceptable facilities, equipment and assistance, as necessary for such inspections or tests. This requirement may, at Buyer's discretion, be either waived or satisfied by Buyer's representative witnessing final inspections and/or tests normally performed by Seller. Evidence of Source Inspection by Buyer shall accompany Seller's shipment. Such inspection shall not necessarily constitute Final Acceptance of the material. Final Acceptance shall be at the Buyer's facility. Seller shall notify Buyer not less than ten days in advance of material ready for Source Inspection.
7. **Seller Developed Drawings:** If the Seller uses internally developed drawings to manufacture or inspect product under this order, drawings must have B/E Aerospace approval when requested prior to use. The Seller shall submit to Buyer, legible copies of drawings within 5 days of receipt of this order.
8. **Drawing Contract System:** Seller shall maintain a system which assures only the latest applicable drawings, specifications and instructions required by the purchase contract as well as authorized changes thereto are used for fabrication, inspection and testing.
9. **Furnished Material Certification:** If raw material to be used on this order is furnished by the Buyer. Certification shall be submitted with Seller's shipment stating (or similarly): "It is hereby certified that the subject parts were manufactured from material furnished by B/E Aerospace for use on B/E Aerospace Purchase Order No. _____; Type of material is _____. B/E Aerospace's material Lot No. is _____." Disposition of any excess material will be Buyer's responsibility but under no circumstance shall B/E Aerospace's lot number identity be lost.
10. **Quantitative Raw Material Certification:** Each shipment of material, parts or assemblies furnished hereunder shall have a quantitative chemical/physical report(s) showing raw material conformance to the specific applicable specifications on file and available for review upon request for a period of not less than 10 years. If more than one raw material item is included in the furnished parts or assemblies, a certification is required for each material. The certification(s) shall identify the material specification (including applicable grade, type, class etc.); manufacturer, manufacturer's lot, batch, heat or serial identity, and quantity of material covered and test results obtained.
11. **Qualitative Raw Material Certification:** Each shipment of raw material furnished hereunder have on file and available upon request, a Qualitative Certification identifying, as applicable, the specification number (including applicable grade, type, class, etc.) to which the material conforms, Buyer's purchase order number and quantity of material covered by the certification. The certification must be maintained for a period of not less than 7 years.
12. **Certification of Conformance:** Submit with each shipment a written statement signed by a qualified party certifying that items or services are in accordance with specified requirements and stating that the manufacturer has objective evidence of compliance to applicable specifications on file, traceable to the material/equipment supplied and available for review upon request. The certification must include the Part Number, Part Revision, material lot numbers (in the case of raw materials, castings, and forgings), B/E P.O. Number, and a list of special processes that the material has undergone (i.e.: Heat treat per APS 57.0, Meets the requirements of FAR25.853 (a), etc), delivery quantity, and certification statement with signature.
13. **Deleted** – Refer to Item 12



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

14. **Test Data:** A copy of actual test results showing compliance with acceptance requirements of an applicable specification is required to be maintained and available upon request for a period of not less than 10 years. Such data shall be reported but no discrepant parts shall be shipped without explicit direction from the Buyer. Any functional acceptance and any lot sample test discrepancies shall be reported to the Buyer within 24 hours of occurrence. Unless otherwise directed, the lot represented by a lot sample failure shall be withheld from shipment pending investigation. Seller shall investigate cause of all such failures and report findings and preventative corrective action to the Buyer or appropriate Quality Representative.
15. **Inspection Data:** A legible reproducible copy of the Seller's actual inspection results shall be maintained under this order and be available upon for review upon request for a period of not less than 10 years.
16. **Operator Certification:** Seller and individual operators performing nondestructive examination shall be in possession of a valid NDE certificate for the test issued by Buyer prior to start of testing.

Nondestructive examination, as used herein, includes the following inspections: Radiographic, ultrasonic, magnetic particle, liquid penetrate, Eddy Current and Eddy Sonic, but not limited to the above.

Requests for certification of the Seller's personnel and/or equipment shall be made to the representative Buyer by the Seller. This request shall include a list of all sub-suppliers who will be performing any of the nondestructive examination of this purchase order.

17. **Nondestructive Examination Records:** Submit with each shipment, one (1) reproducible record of nondestructive test results. Test reports shall conform to the requirements stated in applicable test specification. As a minimum, the report shall indicate:
 - A. Date tested
 - B. Name of testing organization
 - C. Buyer P.O. number
 - D. Drawing number and revision
 - E. Specification number and revision
 - F. Quantity and serial numbers or lot numbers
 - G. Actual NDE stamp/Signature of operator who performed work
 - H. Results of test
18. **Advance Quality Planning:** The Seller shall submit quarterly quality progress reports to Buyer which shall include the following parts as a minimum:
 - A. Design review activities conducted during the period including a discussion of significant accomplishments.
 - B. A summary of all testing activities (planning, execution and evaluation) including significant results and problems encountered.
 - C. The status of the Quality Assurance Program including significant development of control techniques and potential problem areas.
 - D. Summary of all failures indicating data and cause of failure.
 - E. Status of tool design in fabrication efforts and tool proving.
19. **Special Processor Approval:** Seller is requested to submit to Buyer, within ten calendar days following receipt of this order, the company names and addresses of all Sub-vendor special processors planned for use in accomplishment of work hereunder. Buyer reserves the right to disapprove any such sub-vendor processor. Neither Buyer's formal approval nor failure to acknowledge names submitted shall relieve Seller of full responsibility for meeting specification requirements.
20. **Age Control Data:**
 - A. Synthetic raw materials furnished hereunder shall have certification showing the date of manufacture and recommended shelf-life limitation, as applicable on file and available for review upon request for a period of not less than 10 years.



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

- B. Synthetic parts and assemblies furnished hereunder shall have certification showing date of manufacture (cure date) on file and available for review upon request for a period of not less than 10 years.
21. **Raw Material Analysis:** Seller shall, at no charge, periodically validate raw material certifications and flow this requirement to their sub-tier suppliers. Validation will be conducted by an independent verification source. Records of the validation shall be retained per the record retention policy and available for review.
22. **Nonconforming Seller and Corrective Action:** The supplier shall notify B/E Aerospace of nonconforming product prior to shipment and the supplier shall not ship any product until the material was deemed acceptable to B/E aerospace. The Seller shall establish and maintain a positive system of identification and segregation to assure that nonconforming material cannot be intermingled with accepted material. The Seller, through Buyer's purchasing department, may make a request for material review. Buyer's purchasing department may request Seller to submit cause and corrective action on hardware found discrepant at the Seller's facility or any time after delivery to B/E Aerospace. In either instance, the Seller shall report his investigation in detail and the action implemented to prevent recurrence. The decisions and disposition instructions of Buyer's Material Review Board shall be binding to the Seller's organization.
If the seller determines that discrepant product may have escaped their system and has been delivered to B/E Aerospace, the seller shall immediately inform B/E Aerospace of the condition and establish resolution plans with B/E Aerospace.
23. **Seller Designated Items:** Seller agrees not to make any change in materials or design details which would effect the part or any component part thereof with regard to (A) Part number identification (b) Physical or functional interchangeability, and (c) Repair and overhaul procedures and processes and material changes which affects these procedures without prior approval of Buyer and without revising the part numbers of the originals of all drawings or data affected by the change. Copies of the revised drawings or data shall be forwarded to Buyer.
24. **Retention of Data:** Until ten years after final payment, Seller shall keep on file actual test data and records reflecting that all materials and finished items were controlled, tested in accordance with, and met all specifications and requirements. These records shall be made available to: B/E Aerospace, FAA, Regulatory Agency upon request.,
25. **Catalog Page:** Seller will furnish copy of catalog page or drawing with shipment to Buyer.
26. **Supplier Tool and Gauge Control:** Seller is required to implement and maintain a system for the control of gauges, tools, fixtures, jigs and test equipment to the requirement of ISO-10012-1 "Calibration Assurance Requirements For Measuring equipment"
27. **Sub-Supplier Entry:** The Seller is required to extend to his sub-suppliers the right of the Buyer to perform inspections at their facilities to the extent necessary to assure product conformance. All B/E Aerospace customers, including the FAA, have the right to visit and or audit any approved supplier or sub-supplier as the customer may deem necessary upon request.
28. **Inspection Plan:** The Seller will provide to Buyer, if requested in writing, prior to fabrication, a Quality Control Plan, including as a minimum, a Flow Chart depicting sequential manufacturing points for the article(s) procured, and in addition, a narrative description explaining each of the manufacturing points shown in sufficient detail to communicate an understanding of the occurring event. Inspection test and acceptance points shown shall be explicitly described, including features being examined, special tooling used, nature of documentation generated, use of certified personnel and processes, interchangeability demonstrations and the like. The plan shall also describe the nature of the documentation received and generated at each of the points shown and the records that will be maintained as objective evidence of the integrity of the item(s) being fabricated.
29. **Packaging/Shipping:** The Supplier shall assure that material(s) supplied to B/E Aerospace is packaged, as agreed to, by specification. If none exists, the Supplier shall ensure that the material received will be to the drawing and all applicable specifications. The packaging shall contain applicable part numbers, lot/batch control numbers to be readily identifiable, and be sufficient to protect the parts/materials from damage or alteration until receipt at Buyers facility.



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

30. **Lot Control:** Product on this order is subject to lot control and shall be grouped into identifiable lots or batches. Each batch or lot shall consist of units of product of a single type and material manufactured under the same conditions. All means of identification will carry applicable lot batch number and be traceable to records and documentation to substantiate any requirements.
31. **Weight:** Cartons should not exceed 35 pounds.
32. **Count:** Count gross and net weight.
33. **Right to Refuse:** The Buyer reserves the right to refuse or cancel an order if the price invoiced or to be invoiced is higher than that quoted in the order. If the Seller provides the Buyer with due notification of a price increase applying against an outstanding order, the Buyer shall have the option of accepting the price or canceling the order.
34. **Configuration:** All documents (packing list, certification, etc.), must show current product drawing revision letter.
35. **Not before:** No partials unless authorized.
36. **No Substitution:** No substitution of items to be delivered hereunder or any parts or components of such items shall be made unless the Buyer has been notified and approval has been given by issuance of a written change order. When any change in design, material, servicing or part number is desired to be made to replace or substitute any item to be furnished hereunder, or any parts or components hereof, the Seller shall furnish for the item to be substituted, two (2) copies of detailed drawings or, if finished detailed drawings are not available, shop drawings in the form used by the Seller, together with a detailed explanation of the reason(s) for the effect of the change. Such explanation will also include, but not be limited to, a complete description of the effect on the form, fit, function and interchangeability of the item affected by the proposed change.
37. **Approved Suppliers:** Only B/E Aerospace approved sub-tier vendors are to be used.
38. **Federal Aviation Regulation 25.853(a):** 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 B/E Aerospace or the FAA. Random audits of certification statements of compliance will be performed by B/E Aerospace QA to verify this ability.
39. **Federal Aviation Regulation 25.853(c):** Cushion assemblies on this order 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 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 B/E Aerospace or the FAA. Random audits of certification statements of compliance will be performed by B/E Aerospace QA to verify this ability. This note applies only to seller designed and approved cushion assemblies. If B/E Aerospace completed the subject cushion design and flammability approval, for certification purposes, only note 38 applies to the seller.
40. **Copy of Heat Treat Furnace Chart:** If material on this order has been heat treated, the Seller shall assure that material(s) supplied to B/E Aerospace have been heat-treated to all applicable specifications and/or drawings. A copy of the Furnace Chart that shows the heat treat cycle (temperature and duration) must be maintained and available for review upon request for a period of not less than 10 years.
44. **Embrittlement Relief:** Where embrittlement relief is required, a copy of the Oven Chart must be maintained and available for review upon request for a period of not less than 10 years. The chart shall assure the proper time necessary to reach a specified temperature and the duration of the bake. A record shall be maintained stating the actual time between the final plating process and the time that the oven reaches a specified bake temperature.



B/E Aerospace, Inc. Seating Products Group

PROCEDURE NO: BE-PUR-P7.4.3 Appendix A
TITLE: Supplier Quality Requirements Appendix A
REVISION: F
ISSUE DATE: October 12, 2018

46. **Caution:** Article(s) on this order cannot be shipped direct to a B/E Aerospace customer or marked with TSO identification for which B/E Aerospace holds TSO authorization unless the B/E Quality Assurance Director has granted Direct Ship Authorization for that part or has approved a delegated source inspection process.
50. **Right of Entry:** Our customers and regulatory Agencies reserve the right to have unlimited access to supplier's facility and records as necessary.
51. **Mechanical Finishing:** When a drawing contains a note "Part to be free of burrs" accompanied by a key symbol, a 100% mandatory inspection must be performed to ensure that no burrs are evident.
52. **Magnetic Particle Inspection:** Track studs listed on this Purchase Order are subject to 100% magnetic particle inspection by the supplier. No crack of any nature is permissible. Test data to be supplied with delivery of parts.
53. **No Regrind Allowed:** For all plastic type of parts, no amount of regrind is allowable for use for any reason. Exceptions to this will only be made if the vendor has written authorization from B/E Engineering specifically related to specific part numbers.
54. **Identification of Product:** Parts of each lot must be clearly identified by the supplier of said parts as to; part number, revision level, work order number/purchase order number or unique supplier logo/ID/Inspection stamp with date of manufacture. This applies to any process that performs final ID for traceability. Reference B/E quality Procedure SPG-QA-P8, "Product Identification".
55. **Airbus Specification ABD0031:** Material must pass the requirements of Airbus Specification ABD0031 as required by drawing requirement. Notation that this specification has been met shall be noted on the Certification of Conformance that accompanies this order.
56. **B/E Quality Requirements, Supplier Flow Down to Sub-Tier Suppliers:** B/E Aerospace purchase order Quality requirements to suppliers will be flowed down to all sub-tier suppliers via the suppliers purchase order process. Objective evidence must be available and maintained.
57. **Lot to Lot Flammability Validation Required:** 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 B/E Aerospace. Each delivery of product to B/E 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 B/E approved test facility for each lot of material referenced on the C of C. All flammability documentation must remain on file with the supplier for seven (10) years after product delivery to B/E.
58. **UNAPPROVED PARTS – DETECTION AND REPORTING:** Unapproved or counterfeit parts shall not be used for any type certificated aircraft or aircraft components. The Supplier shall ensure that the parts they supply are compliant with the requirements. If Supplier suspects the use of unapproved parts, the guidelines in AC 21-29 should be used to report to B/E Aerospace and the applicable regulatory agency.
59. **Acceptance Authority Media (AAM):** Suppliers shall comply with the AS/EN/JISQ 9100 requirements and 14CFR Part 21.2 regarding the application of the Acceptance Authority Media (AAM) requirements and shall document such requirements within its Quality Management System (QMS). Suppliers shall maintain compliance to the AAM requirements by assessing its process as part of internal audit activities.
60. **Flow Down – Customer Requirements:** When applicable, suppliers shall comply to all customer requirements when providing parts or services to B/E Aerospace purchase orders.
61. **QMS Awareness:** Supplier Personnel must be made aware of their contribution to product or service conformity, to product safety, and their importance of ethical behavior.