

Title: BE-PUR-P7.4.3 Appendix J	
Department: Supplier Quality	Issue Date: 05/10/2021 Effective Date: 08/06/2021

APPROVALS:

Mark A Campanelli

Mark A Campanelli (Aug 11, 2021 08:16 EDT)

Mark Campanelli / Quality Engineer, Quality Assurance Date

Gregory J. Nasta

Gregory J. Nasta (Aug 10, 2021 16:34 EDT)

Gregory Nasta / Sr. Manager, Quality Assurance Date

George Olatunde

George Olatunde (Aug 15, 2021 23:21 EDT)

George Olatunde / Manager, Supply Chain Date

Rev.	Revised Date	Initiated By	Reason
A	05/10/2021	Mark Campanelli	Initial Release
B	08/06/2021	Mark Campanelli	SPCN 788

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1. SCOPE

These requirements apply to orders from Collins Aerospace – New Berlin, WI and Bohemia, NY sites or where specifically required by purchase order. These requirements supplement those already identified in BE-PUR-P7.4.3, including appendices, and are intended to clarify and enhance those requirements. Any conflicts perceived between the documents should be brought to the immediate attention of Collins Procurement and Quality representatives prior to the acceptance of work.

2. RESPONSIBILITY

Primary: Supplier Quality

Support: Supply Chain

3. REFERENCES

Due to company transition of document names, the letters of BOH (for Business Unit representation of Bohemia) is placed before a document name which will be captured during a REVISED revision process.

ANSI/ASQC Z1.4	American National Standards Institute’s Sampling Procedures and Tables for Inspection by Attributes
AS9102	Industry standard developed by IAQG as the Aerospace First Article Inspection Requirement. The First Article form associated with this standard consists of three parts including: Part Number Accountability, Product Accountability, and Characteristic Accountability.
AS9100	Industry standard Quality Management System, including all elements of ISO9000, with additional requirements for the Aerospace Industry.
ATA-300	Industry standard for the packaging of supplies and equipment for air transport

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4. DEFINITIONS

C of C	Certificate of Conformance
Counterfeit Parts	A fraudulent part that has been confirmed to be a copy, imitation, or substitute that has been represented, identified, or marked as genuine, and/or altered by a source without legal right with intent to mislead, deceive, or defraud.
FAIR	First Article Inspection Report – sometimes referred to as FAI
MANSPEC	B/E Aerospace Inc.'s online repository for B/E Aerospace specific quality requirements and manufacturing process specifications. Located at http://www.beaerospace.com/
NADCAP	National Aerospace and Defense Contractors Accreditation Program
NCR	Nonconformance Record
NIST	National Institute of Standards and Technology
PO	Purchase Order
Repair	Work performed to a product that reduces but does not completely eliminate the nonconformity.
Rework	A process applied to a nonconformance that will completely eliminate it and result in characteristics that conform completely to the drawings, specifications or contractual document.
Scrap	Nonconforming material that is unusable for its intended purpose which cannot be economically reworked or repaired in a manner acceptable to B/E-FSI
SI	Source Inspection
Use-As-Is	A disposition of material, with one or more minor nonconformities, determined to be usable for its intended purpose in its existing condition.

5. PROCEDURE

1. REQUIREMENTS:

The Supplier is responsible for ensuring that product scheduled for delivery to Collins from the supplier or sub-tier supplier, including Collins specified suppliers, complies with all applicable provisions of drawing, specifications, and other requirements of the Collins PO. All requirements listed in this document shall be flowed down to sub-tier suppliers, and suppliers and sub-tier suppliers may be subject to audits to ensure compliance.

Supplier shall flow-down all applicable product, regulatory, and quality requirements (including requirements for traceability, documentation, and software control) to sub-tier suppliers. The supplier is responsible for ensuring and validating the compliance of the sub-tier suppliers and maintaining documented evidence of such.

Supplier shall have an established Quality Management System (QMS) compliant to AS9100 and/or ISO9001 to ensure that provided products meet Collins and applicable regulatory requirements. Non 3rd-party certified suppliers are required to complete a gap analysis and provide action plans for compliance to any deficiencies identified by Collins unless waived in writing by Collins Supplier Quality and Procurement.

The QMS shall be maintained to ensure that all products and services offered for acceptance are subjected to inspections and tests required to prove conformance to contract or PO requirements.

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Supplier's quality management system shall be subject to evaluation by Collins and Collins Quality shall be notified in writing when changes are made to the quality system that may affect quality.

Audits, surveillance, inspections, tests and/or verbal or email communication made by Collins or Collins representatives at either the Supplier, sub-tier, or Collins's facility shall NOT relieve Supplier of their primary responsibility to furnish product(s) which conforms to all requirements of the PO.

2. TRACEABILITY AND DOCUMENTATION:

Supplier shall ensure that the product and associated paperwork complies with Collins PO requirements and that all manufacturing, product inspection, and acceptance requirements have been satisfied prior to shipment.

The supplier must submit with each shipment a Certificate of Conformance per BE-PUR-P 7.4.3. In addition, the following documents are required with shipments when applicable:

- FAA 8130-3 Certificate or local Airworthiness equivalent when supplier provides certified airworthy components.
- Special Process Certification from processor.
- Test Reports / Acceptance Test Plan (ATP) results when test is specified in PO or Collins design documents.
- Certification of solder composition as specified in ANSI-J-STD-006, C8 Spot-weld per Mil-W-6858 Class C.
- Shelf Life Indication: For shelf life limited items, Date of Manufacture (DOM) suggested life or date of expiration shall be included in the certification. Product shall be identified with DOM or Expiration date when practical.
- If parts are either replacement or reworked parts per an RMA number, the supplier's certificate of compliance must indicate the RMA number and phrase "Reworked parts" or "Replacement parts", as applicable.
- Rev items indicated as, "**" or "***" on the purchase order must be manufactured to the latest documented revision. The actual revision shall be listed on the Certification of Conformance.

Distributors' Certificate of Compliance must identify the original manufacturer and lot number / Certification of Compliance for traceability. The original manufacturer's Certificate of Compliance must be provided with the shipment and maintained by the Distributor for a minimum of 10 years and be available upon Collins Aerospace request. Full traceability from original manufacturer must be provided.

All fasteners and/or electrical, electronic and electro-mechanical parts delivered and/or used in the manufacture of deliverable products shall be from the Original Component Manufacturer (OCM)/ Original Equipment Manufacturer (OEM), or their franchised dealer / authorized distributor chain.

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Parts shall be new, not used or reclaimed and misrepresented as new. Parts shall not be acquired from independent distributors or brokers unless specifically authorized in writing by Collins Aerospace. The supplier shall flow this requirement down to all sub-tier suppliers to prevent the inadvertent use of counterfeit parts and materials

Supplier is responsible for verifying certification documents furnished by supplier's sub-tier sources for adequacy and authenticity before providing to Collins. The certification shall indicate the name of the issuing organization and shall be signed by an official of that organization. Supplier shall retain these documents for 10 years and be available upon Collins Aerospace request.

3. PRESERVATION AND PACKAGING OF PRODUCT:

Supplier is responsible to ensure that all items are delivered without damage or deterioration including damage from electrostatic discharge (ESD). 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%20interior-systems-quality-documents.aspx>.

ELECTROSTATIC DISCHARGE SENSITIVE MATERIALS (ESD): Electrostatic discharge sensitive materials shall be protected / ESD 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.

FOD PREVENTION: Supplier is responsible to ensure a provision for the prevention, detection, and removal of foreign objects in accordance to IAQG 9146 Foreign Object Damage (FOD) Prevention Program. Prevention program includes:

- A Review of manufacturing processes to identify and eliminate foreign object entrapment.
- Periodic self-audits.
- Buyer's right to perform FOD Prevention Program audits.
- Periodic self-audit of Supplier's internal FOD prevention practices.
- Provide periodic FOD training to employees.

PACKAGING: The following products shall be individually wrapped or otherwise protected to prevent part to part contact and handling damage.

- Top coated or finish coated products
- Finished trims and extrusions (protective films shall be utilized on decorative surfaces of trim and extrusions)
- Machined parts
- Assemblies (loose items shall be individually packaged and labeled)
- Electrical connectors shall be capped with caps provided by manufacturer

NOTE: The use of newspaper as packaging material is prohibited.

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4. SHELF-LIFE PROVISIONS:

Shelf life limited product and materials shall be identified by a shelf-life certificate and packages marked with shelf life information (i.e. expiration date). The material shall be received with at least 70% of the specified shelf-life remaining.

5. HAZARDOUS MATERIAL PROVISIONS:

If the material supplied is either toxic, hazardous, or both as defined by applicable law, code statute or regulation, it must be accompanied with a Material Safety Data Sheet (MSDS).

Hazardous material must have a C of C's from Supplier of Product including: Expiration date of material (if applicable), Date of Manufacture (DOM), MSDS, OEM certifications (if applicable)

6. FIRST ARTICLE INSPECTION:

Supplier is required to maintain a FAI system compliant to AS9102. First Article Inspection documentation per AS9102 Standard (Latest Revision) is required with the first shipment of a part, revision of the part, or any other criteria requiring a new FAI per AS9102 (i.e. 2-year gap in production). The First Article piece shall be tagged as such.

7. SPECIAL PROVISIONS

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 test.

- Individually assembled connectors shall have their contacts or sockets protected with protective caps or other suitable packaging prior to shipment.
- Prior to placing caps on connectors, assure that the connectors are free of foreign objects.

8. KEY CHARACTERISTICS:

When the drawing, specification, or purchase order includes key characteristic requirements, the supplier shall employ a process certification program compliant with AS9103 Standard.

9. CALIBRATION:

Supplier providing calibration services shall be compliant with the requirements of ANSI/NCSL Z540-1, including a certificate of calibration that contains information required by ANSI/NCSL Z540-1.

10. OBSOLESCENCE:

Suppliers shall provide evidence of an obsolescence management process that includes risk as well as definition of affected or potential parts and assemblies. Suppliers shall provide evidence of compliance per planned internal and external assessments with the supply base.

Notification of any potential, known or planned obsolescence, or if planning to procure obsolescent product shall be submitted on ASQR-01 Form 2 to the affected Collins Aerospace SBU buyer with sufficient lead time so as not to disrupt schedules.

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11. SPECIAL CUSTOMER PROVISIONS

A. LOCKHEED MARTIN PROVISIONS:

When Lockheed Martin (Lockheed) is indicated on the print, design specification, referenced documentation, purchase order, or the order is directly related to a Lockheed Martin Aeronautics Company purchase order, processing must be accomplished in accordance with process specification(s) on the purchase order and the revision in effect as of the date of this PO of Lockheed Martin Aeronautics Company Appendix QJ.

All requirements of such Appendix QJ paragraph 12. a. – f. shall be accomplished. Appendix QJ is located at <http://www.lockheedmartin.com/material-management/>."

B. NORTHROP GRUMMAN FLOW DOWN PROVISIONS

When Northrop Grumman is indicated on the print, design specification, referenced documentation, purchase order, or the order is directly related to a Northrop Grumman purchase order, process specifications called out require Northrop Grumman approval and supplier/s must use Northrop Grumman approved special processors for processes listed in Northrop Grumman Approved Special Processors List (ASPL).

C. BOEING FLOW DOWN PROVISIONS

Supplier must use Approved Processors listed in Boeing, D1-4426, "Boeing Approved Process Sources", for all processes requiring a Boeing approved processor.

12. MILITARY FLOW DOWN:

When the purchase order is related to Military contracts, Seller 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.

Refer to RTX terms and conditions for additional information.

13. STATEMENT OF WORK:

When the Purchase Order contains a Statement of Work (SOW), the material supplied shall comply with the requirements of the attached SOW.

Contact the cognizant B/E Aerospace buyer if you do not have a copy of the SOW.

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14. ACCEPTANCE AUTHORITY MEDIA:

All Suppliers are required to include AAM (Acceptance Authority Media) in annual self-assessment activities, both internally and amongst the sub-tier supplier base. The organization must document the status of outputs with respect but not limited to conformity, configuration, monitoring and measurement and identification throughout the product life cycle, including: stamps, electronic signatures, passwords, badges (code bars, chip, magnetic bands), personal signatures and or personal initials, stamp controls, electronic controls and physical controls.

15. CUSTOMER NOTIFICATION OF CHANGES:

Supplier and their sub-tiers shall notify customer of changes to processes, products, design, product validation and/or services, including changes of their external providers or location of manufacture, and obtain the organization's approval prior to implementation.

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Final Audit Report

2021-08-16

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