



B/E Aerospace Enterprise Wide Supplier Quality Requirements



B/E - Enterprise Wide Quality Group

PROCEDURE NO: **BE-PUR-P7.4.3 Appendix P**
 TITLE: **Supplier Quality Requirements Appendix P**
 REVISION: **Rev. T**
 ISSUE DATE: **October 2024**

SITE SPECIFIC REQUIREMENTS FOR B/E AEROSPACE, INC. – Advanced Lavatories & Cabin Interiors (B/E - ALCI) and Waste & Water Systems (B/E-WWS)

Manager, Quality:	<i>See electronic signature</i> <hr/> Taylor Gibb
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REVISION HISTORY

REV	Description	Page Status	Approved	Date
A	Initial Release			
B	<p>2. Normative References: removed references to AS9102 & AS9100.</p> <p>4-1. Added "unless waived in writing by BE-ALCI Supplier Quality and Purchasing."</p> <p>4-2. Removed Communication clause.</p> <p>4-4-5. Removed clauses "Control of Records" & "Control of Documents."</p> <p>4-10. Removed clause "Purchasing."</p> <p>4-12. Removed clause "Extended FAI," added "Net Inspect" clause & Special Processes note.</p> <p>4-13. Removed from note "The following processes are controlled by NADCAP requirements."</p> <p>4-16. Removed "A registry of monitoring and measuring devices..." and sentence 2 of paragraph 2.</p> <p>4-17. Changed paragraph 1 to "Product shall only be conformed to Released Drawings." and removed bullets.</p> <p>4-18. Added additional requirements regarding Sampling Plans.</p> <p>4-20. Added note "On a case-by-case basis..."</p> <p>Added clauses 18-21.</p> <p>Removed "II Extended First Article" from Table 2.</p> <p>Added clause 22 and table 3.</p> <p>Added "Advanced Test Plan Reports (if applicable)" to Table 2, phases I & II.</p>	All	D. Glenn	May 2013
C	<p>Updated internal link http://beintranet/quality/default.aspx</p> <p>1.Update scope</p> <p>3.Changed MANSPEC to MPS (throughout document), added NOE, deleted Safe Launch</p> <p>4.3 Added "encourage suppliers to check MPS daily"</p> <p>4.6 Changed contact email to ALCI Purchasing</p> <p>4.8 Added info about Net Inspect training materials</p> <p>4.9 Deleted Table 1. Changed requirement to mirror NADCAP/D1-4426 except for B/E published processes.</p> <p>Added section 4.16</p> <p>Rearranged section 4.17</p> <p>4.18 Added option to refuse shipment</p> <p>4.20 Redefined/clarified.</p> <p>Added section 4.21</p>	All	D. Glenn	September 2013



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D	Updated revision letter on all pages to D Section 1 SCOPE completely revised Section 4 All clause numbering replaced with letters Section 4 Updated clauses H, I, M, N, O, P, U, T Section 4 Grammatical update on clause K Section 3 Added "Commercial Off the Shelf"	All	J. Michaud	May 2014
E	Include Calibration Providers Section (Section 4V).	10	J. Michaud	August 2014
F	Added new Section G First Article Inspection. Updated Section I Production Process Verification. Updated Section P, clarifying the SRR process.	7, 8, 9	J. Michaud M. Hollinger	January 2015
G	Updated Section C to include NADCAP for Measurement and Inspection (M&I). Updated Section D Control of Work Transfer to provide more clarification and include the use of form F084. Updated Section J Validation of Processes for Production and Service Provision to clarify D1-4426 requirements for suppliers. Updated Section N Monitoring and Measurement of Product to include reduce dimension drawing requirements. Updated Section P Control of Nonconforming Product to clarify requirement to provide B/E-ALCI NCR number on certificate of conformance and to submit SRR a minimum of 3 days prior to the required ship date. Updated Section S Corrective Action Request (CAR) with initial response to CARs to be required within 48 hours. Updated Table 1 to correct references to sections on this document.	6, 7, 8, 9, 10, 11	J. Michaud K. Buckley	February 2017



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H	Renumbered all sections appropriately and all section references throughout document. Updated Normative References. Added Counterfeit Parts, Raw Materials, Sub-Tier Supplier, and Specification Control Document to Terms and Definitions. Section 4.A.Added Purchasing Process Section 4.B. Expanded to include changes to supplier quality management system and flow down of all Appendix P requirements to sub-tier suppliers. Section 4.C. Added Documentation Requirements. Section D. Updated MPS requirements. Section E. Added Right of Entry clause. Section F. Added Resource Management Section H. Included sub-tier suppliers to flow down of Control of Work Transfers. Section K. Updated B/E Aerospace to B/E-ALCI and updated Net-Inspect to include lack of Net-Inspect template does not relieve FAI requirements. Section N. Updated B/E Aerospace to B/E-ALCI. Section O. Added Validation of Raw Material Test Requirements.	All	J. Michaud K. Buckley	June 2017
H	Section S. Added "approved" to drawing requirements. Section V. Added Counterfeit Parts clause Updated Shipping Documentation Table to separate First Article documentation requirements and Standard shipping requirements.	All	J. Michaud K. Buckley	June 2017
J	Section Q. Added Note regarding shelf life	12	J. Michaud D. DiGirolamo	October 2019
K	Added B/E Aerospace, Inc. Water Solutions and all applicable forms and emails throughout entire document.	All	J. Michaud O. Anderson	March 2020
L	Section G "Planning of Product Realization" has been updated to reflect Boeing standard D6-51991	9	J. Michaud M. Stamm	October 2020
M	Added Section N Advanced Product Quality Planning (APQP) and Product Part Approval Process (PPAP)	11	J. Michaud K. Buckley R. Titera	November 2022
N	Section N Advanced Product Quality Planning was updated to include details about PPAP Package submission and periodic surveillance audits.	11, 12	J. Michaud K. Buckley R. Titera	July 2023



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P	Updated B/E-WS Water Solutions to B/E-WWS Waste and Water Solutions. Corrected MPS hyperlink. Added QN to NCR references. Updated SRR Form number to FRM0094	All	T. Gibb R. Harvey M. Fenton	May 2024
R	Updated Section 3C Record Control to align Record Retention requirements with COL-ASQR-PRO-0003. Updated Section 3J to add clarification on communication of Type IIA Minor Changes. Updated section T to add Operator self-verification requirements.	7, 10	T. Gibb M. Warner S. Saari M. Fenton	October 2024
T	Updated Section 3C Record Control and record disposal requirements.	8, 9	T. Gibb M. Warner S. Saari M. Fenton	October 2024



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1 SCOPE:

These requirements apply to orders from the B/E Aerospace, Inc. Advanced Lavatories & Cabin Interiors (B/E-ALCI) and B/E Aerospace, Inc. Waste & Water Systems (B/E-WWS) family of sites or where specifically required by purchase order. These requirements supplement those already identified in BE-PUR-P7.4.3 and are intended to clarify and enhance those requirements. Any conflicts perceived between the documents should be brought to the immediate attention of B/E-ALCI and B/E-WWS Procurement and Quality representatives prior to the acceptance of work.

1. NORMATIVE REFERENCES:

ANSI/ASQC Z1.4	American National Standards Institute's Sampling Procedures and Tables for Inspection by Attributes
AS9100	Aerospace Standard for Quality Management Systems-Requirements for Aviation, Space, and Defense Organizations
AS9102	Aerospace Standard for First Article Inspection Requirement
ATA-300	Industry standard for the packaging of supplies and equipment for air transport
D1-4426	Boeing Approved Process Sources - http://active.boeing.com/doingbiz/d14426/index.cfm
NADCAP	National Aerospace and Defense Contractors Accreditation Program



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2 TERMS AND DEFINITIONS:

Terms and Definitions:

APQP	Advanced Product Quality Planning
B/E-ALCI	B/E Aerospace, Inc. Advanced Lavatories & Cabin Interiors
B/E-ALCI Quality	B/E Aerospace, Inc. Advanced Lavatories & Cabin Interiors Quality Department
B/E-ALCI Procurement	B/E Aerospace, Inc. Advanced Lavatories & Cabin Interiors Procurement Department
B/E-WWS	B/E Aerospace, Inc. Waste & Water Systems
B/E-WWS Quality	B/E Aerospace, Inc. Waste & Water Systems Quality Department
B/E-WWS Procurement	B/E Aerospace, Inc. Waste & Water Systems Procurement Department
CoC	Certificate of Conformance
Commercial off-the-shelf	Products built to industry specifications (e.g. NAS fasteners, AS hoses, etc.)
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.
EASA	European Aviation Safety Association
FAA	Federal Aviation Administration – USA
FAIR	First Article Inspection Report – sometimes referred to as FAI
MPS	B/E Aerospace Inc.'s online repository for B/E Aerospace specific quality requirements and manufacturing process specifications. Located at http://mps.beaerospace.com
NADCAP	National Aerospace and Defense Contractors Accreditation Program
NOE	Notice Of Escapement
PO	Purchase Order
POD	Proof Of Delivery
PPAP	Production Part Approval Process
Raw Material	Base material ready to be used in the creation of a component or part. This includes, but is not limited to, plastics and metals.
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.
Supplier	Direct Supplier to B/E-ALCI and/or B/E-WWS
SI	Source Inspection
SRR	Supplier Rejection Report form FRM0094
Sub-Tier Supplier	Providers of products or services to support fulfillment of purchase order requirements from B/E-ALCI or B/E-WWS to the first tier supplier.
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.
SCD	Specification Control Document
SIC	Supplier Inspection Criteria – document showing the agreed upon inspection criteria and sampling plan status of product under B/E-ALCI or B/E-WWS design control.



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3 REQUIREMENTS:

A. Purchasing Process:

The Supplier is responsible for ensuring that product scheduled for delivery to B/E-ALCI or B/E-WWS from the supplier, sub-tier supplier, including B/E-ALCI or B/E-WWS specified suppliers, complies with all applicable provisions of drawing, specifications, and other requirements of the B/E-ALCI or B/E-WWS PO.

B. Supplier shall have an established quality system compliant or comparable to AS9100:

Suppliers with comparable quality systems e.g. ISO/TS 16949 will be required to complete a gap analysis and provide action plans for compliance to any deficiencies as directed by applicable B/E-ALCI or B/E-WWS group, unless waived in writing by B/E-ALCI or B/E-WWS Supplier Quality and Procurement, respectively.

As appropriate, the Supplier shall inform B/E-ALCI or B/E-WWS Quality, respectively, of any changes to the quality system (including changes in personnel with primary responsibility for the Supplier's quality functions). This does not include minor items such as clerical changes. B/E-ALCI or B/E-WWS Quality, respectively will evaluate the change and the subsequent need for supplier re-qualification activities.

Suppliers shall notify B/E-ALCI or B/E-WWS Quality department, in writing at laws_quality@beaerospace.com or wwquality@beaerospace.com, respectively, immediately should supplier's certification or registration be suspended or withdrawn, or accreditation status of the supplier's CRB is withdrawn.

All suppliers, sub-tier suppliers, and their employees shall ensure awareness of their contribution to product or service conformity, their contribution to product safety and the importance of ethical behavior.

All requirements listed in B/E-PUR-P7.4.3, Appendix P shall be flowed down to sub-tier suppliers and may be subject to audits to ensure compliance.

C. Documentation Requirements:

Upon request, the Supplier shall grant B/E-ALCI or B/E-WWS Quality access to quality system documentation including the quality manual, procedures, records and documents used to demonstrate product conformance. The Supplier shall provide the required documentation in English, unless otherwise specified, and within needed acceptable timeframe.

- Control of Documents and Data: The Supplier is responsible for the control of B/E-ALCI or B/E-WWS proprietary documents and for ensuring that they are controlled in order to preclude their use for other than B/E-ALCI or B/E-WWS work.
- The Supplier is responsible for acquiring copies of industry or government documents, specifications, and/or standards available. Any problem experienced by the Supplier in obtaining required documents should be brought to the immediate attention of B/E-ALCI or B/E-WWS Procurement, respectively.
- Control of Records: The supplier shall retain all documented information, needed to provide evidence of conformance, while the product is being produced and for a minimum of calendar year + 10 years after the date of shipment under each applicable order for all product/part numbers unless otherwise specified on the order or after the



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end of the contract. For flight safety, records shall be maintained for 40 years after the date of manufacture.

- The supplier is responsible for ensuring that records remain legible, readily identifiable and retrievable.
- At the expiration of such period set forth above and prior to any disposal of records, supplier will notify B/E-ALCI or B/E-WWS of records to be disposed of and B/E-ALCI or B/E-WWS reserves the right to request delivery of such records. In the event B/E-ALCI or B/E-WWS chooses to exercise this right, Supplier shall promptly deliver such records to B/E-ALCI or B/E-WWS at no additional cost on media agreed to by both parties.
- The supplier is responsible for the transfer of records to B/E-ALCI or B/E-WWS, respectively in the event that the Supplier ceases operation.
- The Supplier shall remain responsible for the requirements above regardless of whether the Supplier remains an approved B/E-ALCI or B/E-WWS supplier or whether for any reason, the Supplier no longer accepts PO's from B/E-ALCI or B/E-WWS.

D. Manufacturing Process Specifications - Supplier Access Portal (MPS):

B/E-ALCI and B/E-WWS manufacturing process specifications, quality requirements and forms are available through the Manufacturing Process Specifications (MPS) website, which replaces MANSPEC. To access the website follow these steps:

- Go to mps.beaerospace.com.
- If you do NOT have an account, click "Account Request" and follow the instructions.
- If you have already received account information, click "Registered Use Login".
- Read the terms and conditions and then click "I Agree".
- Proceed to login.
- Use the search function to locate the required documents.

The layout of mps.beaerospace.com is subject to change. If the links above are unavailable, Supplier shall contact LAVS_Quality@beaerospace.com or wwquality@beaerospace.com, respectively, for assistance.

Supplier shall contact B/E-ALCI Procurement or B/E-WWS Procurement, respectively to obtain other B/E-ALCI or B/E-WWS proprietary documents required for fulfillment of Purchase Order (PO) requirements when it is found that those documents are not available through MPS.

Suppliers are encouraged to check MPS daily, but are required to check the MPS website at least monthly to ensure that current revisions of the B/E-ALCI or B/E-WWS manufacturing process specifications are being used.

Supplier's system shall include appropriate controls and records demonstrating that reference document revision changes have been implemented at all affected levels.

E. Right of Entry:

B/E-ALCI or B/E-WWS, B/E-ALCI or B/E-WWS's Customers and regulatory agencies reserve the right to have unlimited access to the supplier's and sub-tier supplier's facility and records, as necessary. Where a supplier is registered to AS9100 then B/E-ALCI and/or B/E-WWS shall be given access to the suppliers and relevant sub-tier suppliers OASIS database information.



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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 in order to verify and validate product conformance. The Supplier shall provide all necessary information regarding facilities, equipment, documentation and personnel required to perform said activities at no additional cost to B/E-ALCI or B/E-WWS. These reviews will be used to determine the approval status of all B/E-ALCI or B/E-WWS suppliers. Failure to accommodate the above mentioned reviews may result in the disqualification of the Supplier for future B/E-ALCI or B/E-WWS PO's.

F. Resource Management:

The Supplier shall have a process to identify and perform training for all personnel who directly or indirectly affect product quality. The supplier shall maintain records of this training (including On-The-Job training). These records shall be made available for review upon request.

G. Planning of Product Realization:

Any document revision levels specified on the PO apply to that order. If the revision level of a referenced document is not specified on the PO, the revision level in place at the time the Purchase Order is placed is contractually binding.

If the Supplier is provided any B/E-ALCI or B/E-WWS data files i.e., UG .PRT/ IGES/ STEP/ X_T, in order to manufacture or inspect the product, the Supplier is responsible for establishing and implementing a procedure for the control and use of datasets compliant to Boeing standard D6-51991. This requirement shall be flowed down to sub-suppliers and is subject to compliance audits at the supplier's premises.

H. Control of Work Transfers:

The supplier shall establish a process for control of work transfers. When building product under B/E-ALCI or B/E-WWS purchase order, Supplier shall notify B/E-ALCI or B/E-WWS, respectively of the intent to:

- transfer work from one facility to another
- transfer work from their facility to a supplier's facility
- transfer work from one supplier to another supplier
- relocate production
- transfer inspection or processing facilities
- add an additional source

Said process shall include the verification of the conformity of the work contracted prior to shipment to B/E-ALCI or B/E-WWS. The Supplier must ensure that the B/E-ALCI or B/E-WWS requirements contained herein are met by all sub-tiers and shall maintain records accordingly.

It is the Supplier's responsibility to ensure that B/E-ALCI or B/E-WWS, respectively, property and proprietary data are controlled per contractual agreements at all levels of the supply chain.

The work transfer notification shall be sent to LAVS_Quality@beaerospace.com and Procurement using F084 Supplier Work Transfer Checklist (available in MPS), or wwquality@beaerospace.com and Procurement using WS-084, respectively, a minimum of 60 days before the work transfer takes place. As necessary, B/E-ALCI or B/E-WWS reserves the right to impose additional oversight on the sub-contracting process.

I. Control of Design:

Supplier shall not make any substitutions to any product(s) or service required by the PO, without prior written approval from B/E-ALCI Quality or B/E-WWS Quality, respectively.



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J. Control of Design and Development Changes:

When the PO is for B/E-ALCI or B/E-WWS approved product(s) under Supplier's engineering design control or components built to SCD; Supplier shall notify B/E-ALCI by emailing ALCI_Purchasing@beaerospace.com or for B/E-WWS by emailing the appropriate purchasing agent of design changes according to the conditions outlined below:

B/E-ALCI or B/E-WWS Quality and/or B/E-ALCI or B/E-WWS Procurement reserves the right of disapproval of any changes.

Type I Changes

TYPE I Major Change – A type I change appreciably affects weight, balance, structural strength, reliability, operational characteristics, flammability, or other characteristics affecting the parts airworthiness (Fit, Form, Function and Reliability). Type I changes affect certified end items, by part number change and require FAA engineering approval. These changes may require a Service Bulletin.

Any type I change shall be submitted to B/E-ALCI or B/E-WWS, respectively for written approval prior to enacting such change. A copy of all approved Waivers/Deviations shall be included with all shipments.

Type II Changes

TYPE IIA Minor Change – A type IIA change has no appreciable effect on weight, balance, structural strength, reliability, operational characteristics, or other characteristics affecting the parts airworthiness. Type IIA changes may be identified, either by part number change or revision and may require a Service Bulletin.

Any Type IIA change shall be submitted to B/E-ALCI or B/E-WWS, respectively for written approval prior to enacting such change, to allow for review and impact assessment on affected FAA-qualified B/E-ALCI or B/E-WWS products." A copy of all approved Waivers/Deviations shall be included with all shipments

TYPE IIB Clerical Change – Type IIB changes do not require a part number change as they only affect documentation. Type IIB changes are implemented for the correction of errors, omissions, or other clerical changes that do not impact the actual part(s).

Supplier may incorporate Type IIB changes without prior approval. Supplier shall furnish a copy of the product description or waiver prior to delivery of the revised product. A copy of all approved Waivers/Deviations shall be included with all shipments.

K. First Article Inspection (FAI):

The supplier shall perform a full FAI or a partial FAI (for affected characteristics,) when any of the following occurs:

- A change in the design characteristics affecting fit, form, or function of the part.
- A change in a manufacturing source(s), process(es), inspection method(s), location of manufacture, tooling, or materials that can potentially affect fit, form, or function.
- A lapse in production of two years shall require an update for any characteristics that may be impacted by the inactivity. This lapse is from the completion of last production operation to the actual restart of production.
- At the request of B/E-ALCI or B/E-WWS, respectively.



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An AS9102 FAIR is required for product under B/E-ALCI or B/E-WWS design approval and product designed by the supplier (excluding commercial off-the-shelf products - see section 3 Terms and Definitions for clarification).

The FAIR, including all supporting documents, must be submitted a minimum of 5 business days prior to the required ship date. Product shall **not** be released for shipment until after B/E-ALCI Quality or B/E-WWS Quality, respectively, has provided the supplier with written approval and/or waiver of the FAIR.

Net-Inspect: Net-Inspect is the mandatory method to submit FAIR, unless otherwise approved by B/E-ALCI Quality or B/E-WWS, respectively. Incomplete FAIR's (per the definition of AS9102, meaning non-conforming) will not be accepted without pre-arrangement.

If suppliers do not have a Net Inspect account, they must request access by emailing lavs_quality@beaerospace.com or wwquality@beaerospace.com, respectively. Please include in the email the name of your Net-Inspect System Administrator needing access, their first and last name, position/title, phone number and email address. Training materials are available upon request. B/E-ALCI may, at its discretion, provide FAI templates upon request by email to Lavs_Quality@beaerospace.com with the part number and revision of the template needed. The lack of a provided Net-Inspect template does not relieve the requirement for the supplier to submit the appropriate FAI report per schedule.

L. Control of Production and Service Provision:

When manufacturing specifications, inspection plans or sequence of operations are specified by B/E-ALCI or B/E-WWS, Supplier's shall assure compliance to such plans, subject to verification by B/E-ALCI or B/E-WWS representatives.

M. Production Process Verification:

An AS9102 FAIR may be requested when:

- A change in numerical control program or translation to another media that can potentially affect fit, form, or function.
- A natural or man-made event, which may adversely affect the manufacturing process.
- An implementation of corrective action required to complete a previous FAI.
- As deemed necessary by B/E-ALCI Quality or B/E-WWS Quality.

N. Advanced Product Quality Planning (APQP) and Production Part Approval Process (PPAP) Responsibilities:

A Supplier of products, materials, equipment, information, or services shall implement Advanced Product Quality Planning (APQP) and Production Part Approval Process (PPAP) per the requirements contained in AS/EN/SJAC 9145 when invoked by drawing related documents, purchase order, or any other contractual requirement.

B/E-ALCI and/or B/E-WWS reserves the right to make final determination of Supplier's compliance to the AS/EN/SJAC 9145 aerospace standard and APQP/PPAP deliverable requirements list:

1. Design Records
2. Design Risk Analysis, DFMEA (DFMEA per SAE J1739)
3. Process Flow Diagram
4. Process Failure Mode and Effects Analysis, PFMEA
5. Control Plan
6. Measurement System Analysis, MSA
7. Initial Process Capability Studies



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8. Packaging, Preservation and Labelling Approvals
9. First Article Inspection Report, FAIR
10. B/E-ALCI and/or B/E-WWS Specific PPAP requirement
11. PPAP Approval Form

The PPAP Package, including all supporting documents, must be submitted a minimum of 5 business days prior to the required ship date. Suppliers shall utilize the approved digital portal for PPAP Package submission, In the event a digital portal is not available, the Collins PPAP submission form COL-FRM-0093 or AS9145 PPAP submission form may be used. Product shall not be released for shipment until after B/E-ALCI Quality or B/E-WWS Quality, respectively, has provided the supplier with written acceptance and/or conditional acceptance of the PPAP Package.

Prior to PPAP package submission, the supplier may be requested to provide preliminary artifacts to demonstrate compliance with APQP / PPAP processes. Additionally, B/E-ALCI reserves the right to perform a site visit at any time for the purpose of verifying compliance to the APQP / PPAP requirements.

O. Validation of Processes for Production and Service Provision:

For B/E-ALCI or B/E-WWS published process specifications, NADCAP accreditation may be required.

If design requirements are Boeing Specifications, certification of special process shall be per D1-4426. If design requirements are not Boeing Specifications, NADCAP certification of special process is required. Only B/E-ALCI Quality or B/E-WWS Quality, respectively have the authority to approve the use of non- NADCAP or non-D1-4426 approved source for a specific process. Approvals must be received in writing through B/E-ALCI Quality at LAVS_Quality@beaerospace.com or B/E-WWS Quality at wwquality@beaerospace.com, respectively. Products shall not be processed until approval is obtained.

NOTE: A list of NADCAP certified sources are available at (www.pri-network.org) and must be adhered to, unless authorized in writing by B/E-ALCI Quality or B/E-WWS, respectively. The requirements of D1-4426 can be found at: <http://active.boeing.com/doingbiz/d14426/index.cfm>.

The supplier is responsible for maintaining records of the process control testing required by B/E-ALCI or B/E-WWS process specifications. Upon request, the supplier is required to e-mail copies of these records for review within 24 hrs. Process control testing records must be available no later than 24 hrs. after shipment of affected product unless pre-arranged via SRR (see Section U).

P. Validation of Raw Material Test Requirements:

The supplier must periodically validate test report data for raw material accepted on the basis of test reports. That validation must be accomplished by the supplier or other independent party through periodic, scheduled tests of raw material samples. Schedules for frequency of tests will be established by the supplier based on historical performance of the raw material supplier. Suppliers will make this information available to B/E-ALCI Quality or B/E-WWS, respectively, when requested.

Q. Customer Property:

Supplier shall not modify, sell, or transfer any B/E-ALCI or B/E-WWS furnished equipment, material, or excess inventory to a third party without prior written permission from B/E-ALCI or



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B/E-WWS, respectively. Supplier is held responsible for strict control of B/E-ALCI or B/E-WWS inventory of furnished equipment.

NOTE: B/E-ALCI or B/E-WWS furnished equipment pertains to all tooling (Calibrated and Uncalibrated), and measuring and inspection equipment.

R. Preservation of Product:

Supplier is responsible to ensure that all items are delivered without damage or deterioration including damage from electrostatic discharge. It is strongly recommended that ATA 300 standards be used.

NOTE: The use of newspaper and plastic or foam "peanuts" as packaging material is prohibited.

NOTE: Age-sensitive materials must arrive at B/E within limitations of BE-PUR-P7.4.3, except as follows:

- LCMS-301, TYPE 1 materials must arrive at B/E with a minimum 50% shelf life
- LCMS-301, TYPE 2 materials must arrive at B/E with a minimum 50% shelf life

S. Control of Monitoring and Measuring Equipment:

All calibrated equipment shall be traceable to the National Institute of Standards Technology (NIST) or International equivalent. Where no such standard exists, the basis for calibration must be documented.

Calibration must at a minimum be re-accomplished annually unless otherwise specified in writing by the manufacturer or the calibration service provider.

T. Monitoring and Measurement of Product:

Product shall only be conformed to Approved Drawings.

If the Supplier converts or translates any B/E-ALCI or B/E-WWS drawing dataset (example UG IDGS/IGES files) in order to manufacture or inspect the product, the Supplier is responsible for establishing and implementing a plan for the validation of the conversion or translation. Suppliers who receive reduced content drawings with an associated 3D model, must be able to extract information from the 3D model sufficient for manufacturing and inspection in addition to the 2D drawing. Also, the supplier who utilizes the dataset, needs to conform to Section G. Planning of Product Realization, of this document. Compliance to this requirement is subject to surveillance audits upon the request of B/E-ALCI or B/E-WWS, respectively.

In cases of conflict between drawing and model, the drawing takes precedence.

Operator self-verification programs are not allowed, except as explicitly approved by B/E-ALCI and in compliance with the requirements set forth in SAE industry standard AS9162, "Aerospace Operator Self Verification Programs", as may be amended from time to time. B/E-ALCI reserves the right to conduct surveillance at supplier's facility to determine that supplier is compliant to the requirements of AS9162.

As necessary, B/E ALCI or B/E-WWS, respectively and/or the supplier may request the production of a Supplier Inspection Criteria (SIC) document. These documents are used to assist in the clarification of supplier inspection requirements and are part/revision specific. Requests for an SIC should be sent to LAVS_Quality@beaerospace.com for B/E-ALCI and wwquality@beaerospace.com for B/E-WWS. Upon agreement and release to the MPS website (See clause B), the SIC will be effective for all orders of the affected part number until made obsolete by drawing revision.



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U. Statistical (reduced) Sampling:

Supplier shall obtain written B/E-ALCI or B/E-WWS Supplier Quality approval prior to implementing statistical sampling methods. Without an approved Sampling Plan, supplier is required to perform 100% inspection on all Characteristics designated by the B/E-ALCI or B/E-WWS engineering drawing.

Supplier's desiring to achieve an approved statistical sampling plan should submit their internal sampling plan to LAVS_Quality@beaerospace.com for B/E-ALCI or wwquality@beaerospace.com for B/E-WWS. Upon agreement, said plan will be documented via Supplier Inspection Criteria (SIC) document. In general the supplier should target a Cpk of $\geq 1.33^*$ prior to submitting a request for approval. Data collected in support of a request for approval is subject to review by B/E-ALCI Quality or B/E-WWS Quality, respectively, and shall be submitted with the request.

*Smaller sample sizes will require the achievement of higher Cpk values before an approval will be granted.

V. Control of Nonconforming Product:

Related to section 11.3 of the main document, when manufacturing to B/E-ALCI or B/E-WWS design authority and/or B/E-ALCI or B/E-WWS approval, Supplier shall not issue Use-As-Is dispositions or perform any repairs or repair methods to nonconforming product, unless such repairs are specifically authorized by B/E-ALCI Quality or B/E-WWS, respectively through the Supplier Rejection Report (SRR) process outlined below:

- Quarantine nonconforming product (Given the supplier has determined that "rework" and/or "scrap and remake" dispositions are not possible).
- Obtain an SRR (form number FRM0094) from MPS.
- Complete the SRR including all necessary detail, photographs, drawing mark-ups, etc. The form MUST indicate which site product is shipping to (i.e. EVT or PHL).
- Send the SRR and supporting documents to LAVS_Quality@beaerospace.com and B/E-ALCI Procurement for B/E-ALCI and wwquality@beaerospace.com and appropriate purchasing agent for B/E-WWS.
- The SRR response will be e-mailed by B/E-ALCI Quality or B/E-WWS Quality to the supplier in the form of a dispositioned quality notification/nonconformance report (QN/NCR).
- Perform any operations required by the SRR response and retain the document as part of the build record.
- Include a copy of the SRR with the affected product for shipment. SRR affected products shall be segregated from the remaining quantity of products delivered. Affected certificates of conformance shall prominently reference the B/E-ALCI or B/E-WWS QN/NCR number. (provided by B/E-ALCI or B/E-WWS prior to shipment)

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. Any nonconformance identified during this review should be resolved, or controlled by use of the above SRR process.

B/E-ALCI or B/E-WWS may require a formal corrective action as a result of the SRR process. This includes:

- Failure of the supplier to prevent repetitive SRR submissions
- Shipment of nonconforming product prior to the receipt of the SRR response



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- Impact to schedule due to SRR submittal (SRR's shall be submitted a minimum of 3 days prior to the required ship date)

Note: On a case-by-case basis, supplier may be directed to ship product once a QN/NCR has been generated, to better evaluate the parts under review.

W. Counterfeit Parts:

B/E-ALCI and B/E-WWS requires procurement from the OEM or their authorized distributors. If an occurrence arises where that is not possible, B/E-ALCI or B/E-WWS approval is required and a risk mitigation plan will be required which details the inspections and tests to be performed to authenticate the product, including acceptance criteria.

Supplier shall have a plan and control process in place to prevent, detect and control suspect counterfeit or counterfeit parts usage and inclusion in B/E-ALCI and B/E-WWS products. This requirement must be flowed down to all sub-tier suppliers.

X. Notification of Delivered Nonconforming Product:

In accordance with section 11.3.2, NOE emails are to be sent to Lavs_Quality@beaerospace.com and B/E-ALCI Procurement for B/E ALCI and wwquality@beaerospace.com and the appropriate purchasing agent for B/E-WWS.

Y. Responsibility for Conformance:

Neither audit, surveillance, inspection and/or tests made by B/E-ALCI, B/E-WWS, B/E-ALCI or B/E-WWS's representatives at either the Supplier's or B/E-ALCI or B/E-WWS facilities, shall relieve Supplier of their primary responsibility to furnish product(s) which conforms to all requirements of the PO.

Z. Corrective Action Request (CAR):

Upon request, the supplier is responsible for the completion of B/E-ALCI or B/E-WWS online corrective action form. Completion of the corrective action includes the submittal of objective evidence for each action taken in the corrective action process. Initial responses to CAR's are required within 48 hours of the issue date, with Containment, Root Cause and Corrective Actions due within the following 14 days unless otherwise agreed upon. B/E-ALCI and B/E-WWS reserves the right to withhold acceptance of shipments until the Seller corrective action is submitted to B/E-ALCI or B/E-WWS's satisfaction.



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AA. Qualification and Test Component Requirements:

Suppliers shall perform 100% dimensional inspection of all products shipped to B/E-ALCI and B/E-WWS. Supporting documentation shall include verification of traceability for all materials and special processes.

Any deviations from drawing requirements shall be documented on a Supplier Rejection Report- See section 16.

BB. Documentation:

Final Inspection records shall be maintained in accordance with the record retention requirements contained herein and shall be provided within 24 hours upon request.

Supplier is responsible for ensuring that all shipments are accompanied by the appropriate documentation as specified in Table 1 below unless otherwise approved in writing by B/E-ALCI Quality or B/E-WWS Quality, respectively.

CC. Direct Shipment and Drop shipment:

Suppliers are not permitted to perform direct and/or drop shipments without prior written authorization. Please contact Procurement and Lavs_Quality@beaerospace.com for B/E-ALCI or wwquality@beaerospace.com and the appropriate purchasing agent for B/E-WWS, for process steps, documentation and inspection requirements, POD expectations prior to accepting the PO, etc.

DD. Calibration Providers:

When calibration service is required, calibration activities must be against measurement standards traceable to international or national measurement standards; when no such standards exist, the basis used for calibration or verification shall be documented.



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TABLE 1: STANDARD SHIPMENT DOCUMENTATION REQUIREMENTS BY PRODUCT TYPE

Standard Shipping Requirements	B/E Parts	Supplier Parts	SCD Parts	Commercial Off the Shelf	Standards	Raw Materials	DETAIL
Certificate of Conformance	X	X	X	X	X	X	
Material Certifications						X	
Material Test Reports						X	
Sub Tier Processor Certifications, as applicable	X						
SRR, as applicable	X						
Regulatory Airworthiness Approval Document- (8130-3 or EASA Form 1)				X			If eligible
Acceptance Test reports, as applicable	X						



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TABLE 2: FIRST ARTICLE SHIPMENT DOCUMENTATION REQUIREMENTS BY PRODUCT TYPE

First Article Requirements	B/E Parts	Supplier Parts	SCD Parts	Commercial Off the Shelf	Standards	Raw Materials	DETAIL
AS9102 FAI Report	X	X	X				Via Net-Inspect
Certificate of Conformance	X	X	X	X	X	X	
Material Certifications	X	X	X			X	As applicable.
Material Test Reports	X	X	X			X	As applicable.
Sub Tier Processor Certifications	X	X	X				As applicable.
SRR, as applicable	X	X	X				
Regulatory Airworthiness Approval Document (8130-3 or EASA Form 1)	X	X	X				If eligible
Acceptance Test reports	X	X	X				As applicable.

Definitions:

- B/E Parts - B/E Part Number, Drawing or SCD Part number
- SCD Parts - Specification Control Drawing

**When supplier is shipping a B/E-ALCI SCD part, Certificate of Conformance from supplier is required to call out the B/E-ALCI SCxxxxxxx part number, current revision, in addition to their part number.

- Supplier Parts - Parts ordered are Supplier Part Number or Drawing
- COTS - Commercial Off the Shelf Parts
- Standards - Industry specifications – SAE Document (i.e. NAS, MS, AN, etc.)
- Raw Materials - Base material used in the creation of a component or part. These include, but are not limited to, plastic and metals.