

**Collins Aerospace**  
An **RTX** Business

# Doing Business with Collins Aerospace

## Aerospace Supplier Quality Requirements

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# RTX Overview





Progress is developed. It is produced. It defines the future, and it defines us.

RTX serves customers in the commercial aerospace and defense industries. We combine complementary technology offerings and world-class engineering teams to deliver innovative solutions.

RTX consists of three businesses – Collins Aerospace, Pratt & Whitney and Raytheon

- <https://www.rtx.com/suppliers> is a great place to start and contains valuable information on:
  - Supplier Cybersecurity
  - Performance +
  - Supplier Diversity
  - RTX potential supplier registration
  - RTX Terms & Conditions
  - RTX Code of Conduct
  - RTX Supplier Resources
    - RTX Statement on Modern Slavery and Human Trafficking
    - RTX business gifts from suppliers' policy
    - RTX conflict minerals policy statement and training
    - RTX diversity policy statement
    - RTX Energy Best Management Practices Guidebook
  - And much more!

**Our Suppliers are an integral part of the global RTX team.**

# Collins Aerospace Overview



# Collins Aerospace



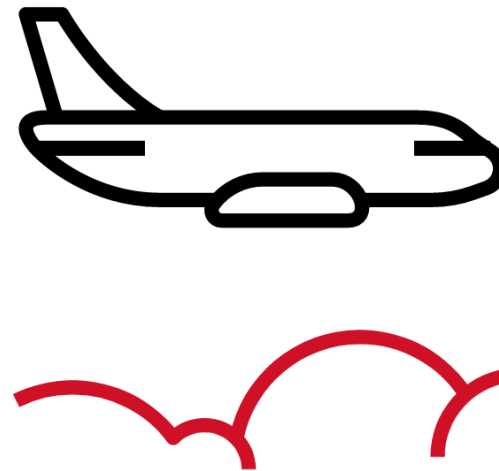
- **Overview**

- At Collins Aerospace, we're working side-by-side with our customers and partners to dream, design and deliver solutions that redefine the future of our industry. By reaching across the markets, we serve and drawing on our vast portfolio of expertise, we are making the most powerful concepts in aerospace a reality every day. Explore all the ways we're redefining aerospace with one of the deepest capability sets and broadest perspectives in the industry.

<https://www.collinsaerospace.com/> provides information on our capabilities and the industries we serve.

- **Our Capabilities**

- Autonomous Operations
- Cabin Experience
- Connected Battlespace
- Connected Ecosystem
- Electrified Aircraft
- Integrated Solutions
- Structural Technologies
- Sustainability
- Digital & Technology Acceleration



- **Our Industries**

- Airports
- Business Aviation
- Commercial Aviation
- Helicopters
- Military & Defense
- Space

# Purchase Order




# Purchase order

- **Elements**

- A purchase order (PO) specifies the items, quantities, prices, terms for a purchase, requirements, etc., and becomes a legally binding contract when a vendor accepts the purchase order.

- Shows Bill to address
- Buyer information
- International Commercial Terms (Inco terms)
- Payment terms
- Delivery address
- Link to online Purchase Terms and Conditions and requirements

Purchase Order : 11682295 Created: 08/24/2021 

Bill To:  
Collins bill to site location

Sold To:

Vendor Address:

Buyer:  
Buyer  
Buyer

Delivery: FCA COLUMBUS, OH  
Payment: Net 75 Days  
Currency: USD

Please Deliver To:  
Location for delivery

IF THIS PURCHASE ORDER IS SUBJECT TO MILITARY CONTRACT REQUIREMENTS,  
UTC-U.S. GOVERNMENT PROVISIONS & CLAUSES FOR ORDERS UNDER U.S.  
GOVERNMENT CONTRACTS FOUND AT  
[HTTPS://WWW.UTC.COM/SUPPLIERS/PURCHASE-TERMS-AND-CONDITIONS](https://www.utc.com/suppliers/purchase-terms-and-conditions) APPLY.

The RTX Terms and Conditions found at  
<https://www.rtx.com/Suppliers/purchase-terms-and-conditions> and the relevant  
Collins Aerospace SBU addendum found at  
<https://www.collinsaerospace.com/supplier-documents> apply to this PO, and  
acceptance is expressly subject to such terms. All other terms proposed by  
Supplier are rejected. This PO shall constitute the final, complete and  
exclusive statement of this contract (unless a master terms agreement or other  
relevant agreement has been executed by Buyer and Supplier and is applicable  
hereto).

\*Note: The above is an example and may not look like the PO you received.



# Purchase order

- **Elements continued...**
- A purchase order (PO) may also specify drawing number, revision, configuration control, the pricing information, delivery dates, vendor promise dates, commit dates, any Berry Compliance information (if applicable), specific information required on invoicing, packing slips, RTX Terms & Conditions and requirements, etc.

Purchase Order : 10648212

| Item  | Material Description         | Quantity Price    | Unit of Measure Per Unit |
|-------|------------------------------|-------------------|--------------------------|
| 00020 | Drawing number               | 75                | each                     |
|       | DWG Rev or DIR: NC Issue: 01 | 8.64              | 1                        |
|       |                              | Net Value: 648.00 |                          |

Vendor Material No:  
Item Last Changed On: 07/15/2016  
Target QM:Quality System Approval Required  
Inspection: Subject to Inspection at UTAS  
Contract:COMMERCIAL  
Tax Code:  
ECCN/USML#: EAR99  
Internal Order:

Condition:  
DPAS Rating:  
Leadtime: 60 Calendar days  
HS Number:

| Total Quantity Spread Over the Following Dates: |      |                     |                        |
|---|------|---------------------|------------------------|
| Qty.  | Unit | Vendor Promise Date | Required Measured Date |
| 29  | each | 07/28/2016          | 07/28/2016             |
| 19  | each | 08/04/2016          | 08/04/2016             |
| 3   | each | 08/12/2016          | 08/12/2016             |

Net Value 2,243.58  
Total Amount 2,243.58

All applicable materials shall meet the Government requirements specified by the Berry Amendment/Commodities Clause, per 10 U.S.C 2533a and DFARS 252-225-7012. All synthetic textile/fabric materials, and coated synthetic fabric used in construction of seat component parts (as listed in table VI) shall meet the above requirement, and shall meet all other requirements of this document.

\*\*\*\*\*  
The RTX Terms and Conditions found at <https://www.rtx.com/suppliers/purchase-terms-and-conditions> and the relevant Collins Aerospace SBU addendum found at <https://www.collinsaerospace.com/supplier-documents/> apply to this PO, and acceptance is expressly subject to such terms. All other terms proposed by Supplier are rejected. This PO shall constitute the final, complete, and exclusive statement of this contract (unless a master terms agreement or other relevant agreement has been executed by Buyer and Supplier and is applicable hereto).  
\*\*\*\*\*  
DELIVERY DATE(S) ON THIS PURCHASE ORDER REFLECTS CURRENT NEED AT TIME OF PURCHASE ORDER PLACEMENT. ALL DELIVERIES AGAINST THIS PURCHASE ORDER WILL BE IN ACCORDANCE WITH THE MOST RECENT MRP SCHEDULE PRIOR TO DELIVERY.  
All Inspection and quality system requirements shall be in accordance with the current revision of ASQR-01, COL-ASQR-PRO-0003, HSM17, HSM19 and HSM236.  
\*\*\*\*\*  
SUPPLIER SHALL SHIP IN ACCORDANCE WITH INSTRUCTIONS LOCATED IN THE COLLINS ONLINE ROUTING GUIDES LOCATED AT: <https://suppliers.utc.com>. Routing guides are now found under the How do I ship product to COLLINS? section.  
ALL SHIPMENTS BEING MADE BY A THIRD PARTY, WHERE COLLINS IS PAYING FOR THE FREIGHT, MUST BE IN ACCORDANCE WITH THESE INSTRUCTIONS. ANY DEVIATION FROM THESE INSTRUCTIONS REQUIRES WRITTEN BUYER AUTHORIZATION PRIOR TO SHIPMENT. FAILURE TO SHIP IN ACCORDANCE WITH THESE INSTRUCTIONS WILL RESULT IN HAMILTON SUNDSTRAND, A PART OF COLLINS AEROSPACE, DEBITING THE SUPPLIER FOR THE COST OF THE SHIPMENT.

# Supplier Portals



# Supplier Portals

- How do you know which supplier portal to use?
- The purchase order references which portal

```
*****
The RTX Terms and Conditions found at
https://www.rtx.com/suppliers/purchase-terms-and-conditions and the relevant
Collins Aerospace SBU addendum found at
https://www.collinsaerospace.com/supplier-documents/ apply to this PO, and
acceptance is expressly subject to such terms. All other terms proposed by
Supplier are rejected. This PO shall constitute the final, complete, and
exclusive statement of this contract (unless a master terms agreement or other
relevant agreement has been executed by Buyer and Supplier and is applicable
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DELIVERY DATE(S) ON THIS PURCHASE ORDER REFLECTS CURRENT NEED AT
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THE SHIPMENT.
```

The RTX Standard Terms and Conditions of Purchase found at <http://www.rtx.com/en/suppliers/purchase-terms-and-conditions> and other applicable Collins Aerospace terms and other resources for Heritage Rockwell Collins, Inc. suppliers found at <https://portal.rockwellcollins.com/web/suppliers> apply to this PO, and acceptance is expressly subject to such terms."Suppliers shall comply with RC-9000 Supplier Quality Management System Requirements, found at the following link: <https://portal.rockwellcollins.com/web/suppliers>. All other terms proposed by Supplier are rejected. This PO shall constitute the final, complete, and exclusive statement of the contract (unless a master terms agreement or other relevant written agreement has been signed by Buyer and Supplier and is applicable hereto).

\*Note: You may need access to other portals if you are conducting business with more than one entity within Collins Aerospace.

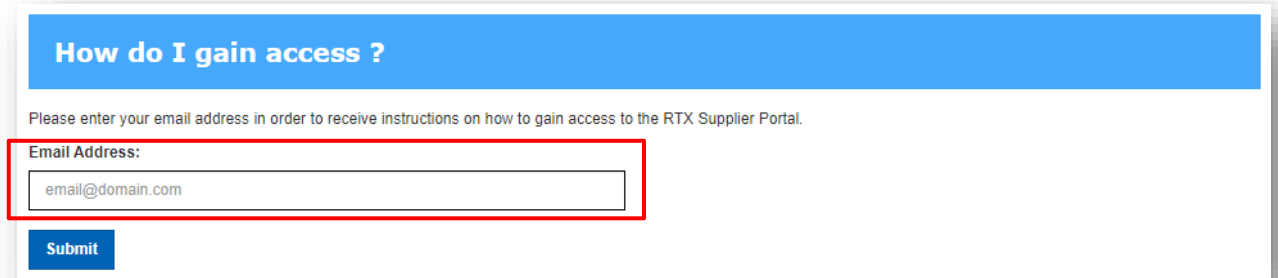
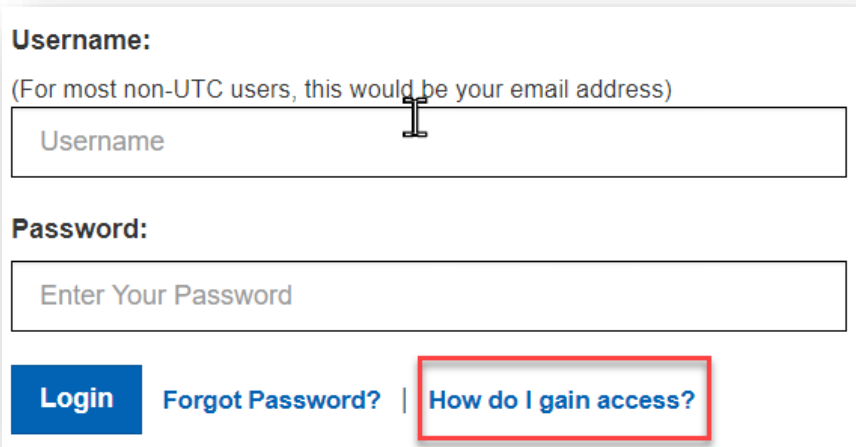
# Supplier Portals

- **Registration**
- Collins Aerospace utilizes different supplier portals. One for heritage Rockwell Collins (RC) teams, one for heritage United Technologies Corporation (UTC) teams, and one for heritage BE teams.
- Please review your purchase order or contact your organizations Collins Aerospace Purchasing or Supplier Quality Representative if you are unsure of which supplier portal to access.

hUTC Supplier Portal - <https://suppliers.utc.com/>

Click on “How do I gain access?”

Enter your email address and click on “Submit”

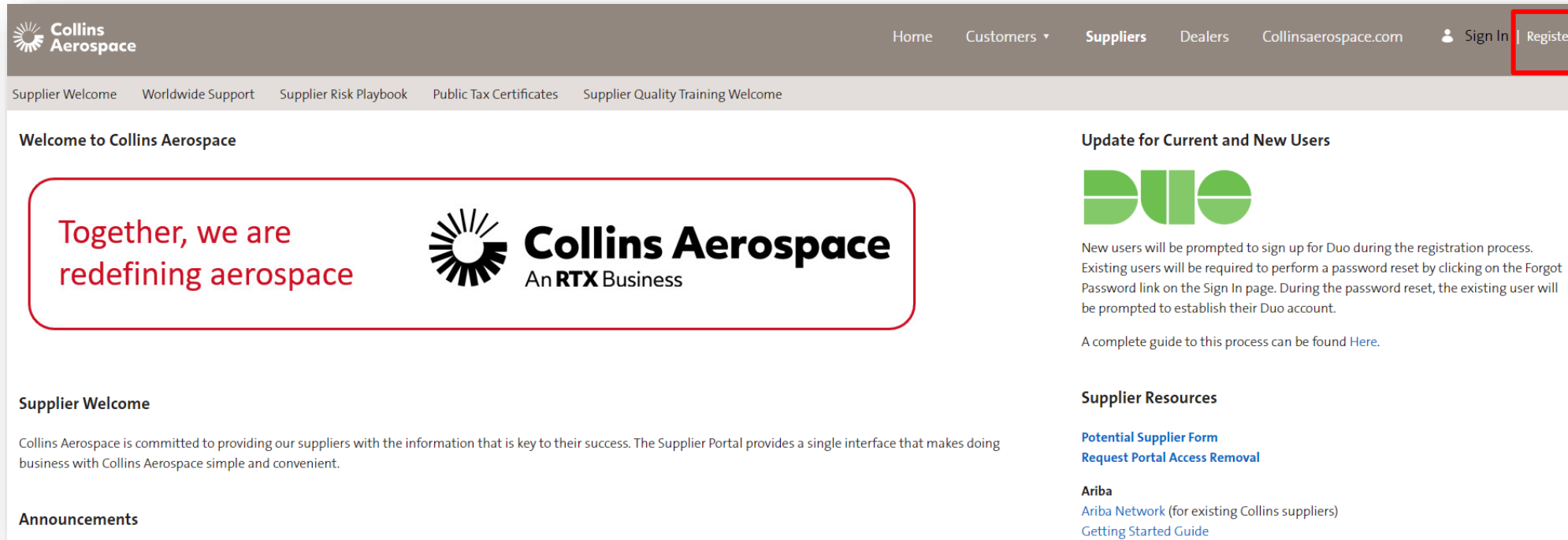


\*Note: You may need access to other portals if you are conducting business with more than one entity within Collins Aerospace.

# Supplier Portals

- **Registration**

hRC Supplier Portal - <https://portal.rockwellcollins.com/web/suppliers>



Click on  
“Register”

\*Note: You may need access to both portals if you are conducting business with more than one business within Collins Aerospace.



# Supplier Portals

- **Registration** hRC Supplier Portal - <https://portal.rockwellcollins.com/web/suppliers>

A red asterisk means the information is mandatory

Review the password rules

Review the terms and conditions, then accept

Submit

NEW USER REGISTRATION

User ID (Email Address) \*

User ID

First Name \*

First Name

Middle Name

Middle Name

Company \*

Company

Company Phone \*

Company Phone

Address Line 1 \*

Address Line 1

Address Line 2

Address Line 2

City \*

City

State \*

State

Postal Code \*

Postal Code

Country \*

Select Country

Password \*

Confirm Password \*

Confirm Password


Password should have combination of uppercase lowercase digit symbol category

☐ I Accept The [Term And Conditions](#) \*

CANCEL SUBMIT

User will receive an email from the portal admin with a 6-digit code.

CONFIRMATION



Thank you for your interest in Collins Aerospace.

You will receive a Confirmation Code from [portaladmin@rockwellcollins.com](mailto:portaladmin@rockwellcollins.com). Please add this address to your email address book and check your junk mail folder for messages that may have been inadvertently placed in this folder. If you have any questions, or if you would like more information, please [contact us](#) and mention communication ID REG-525.

Confirmation Code

SUBMIT

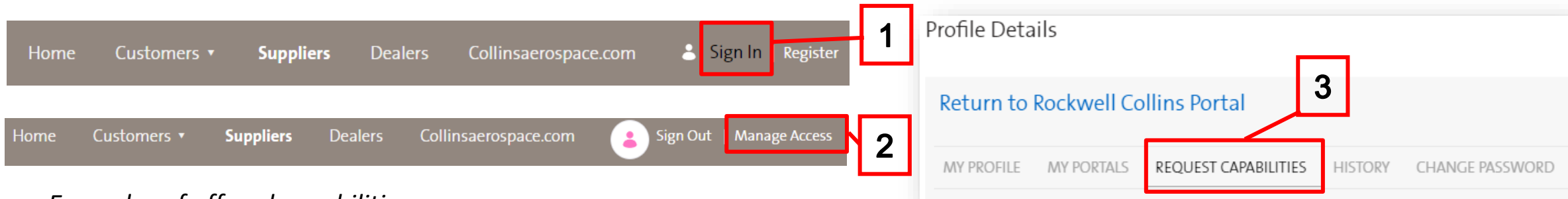
Or

[Resend Confirmation Code](#)

# Supplier Portals

- **Registration**

1. Once you have completed the registration process you will be able to signed into the supplier portal (<http://www.portal.rockwellcollins.com>).
2. After you have signed into the portal, you can request access to capabilities / applications.
3. Select the request capabilities tab to proceed the request screen.



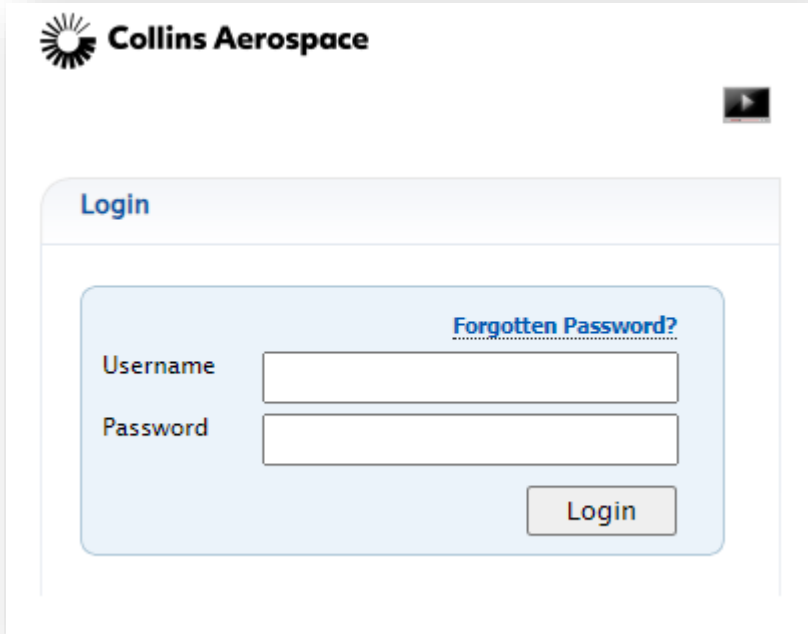
- *Examples of offered capabilities:*

- Drawings: Allows suppliers to download drawings and specifications from the Supplier Portal. Buyers are also able to push relevant drawings to suppliers through this tool.
- Part Changes: Allows suppliers to view and acknowledge part master data and change notifications.
- Quotes: Allows suppliers to view and respond to Electronic Requests for Quotes also known as eRFQs. The portal then completes all quotes and programmatically selects a winning supplier based on a Total Cost of Ownership formula.
- Purchase Orders & Forecast: Provides the ability to manage your open orders.
- FAI: Submit, view, and check acceptance status of First Article Inspection Report documents.
- Corrective Actions: Allows suppliers to view and respond to Supply Chain Corrective Actions (SCARs). Also provides the ability to view past SCARs.
- Supplier Scorecard: Allows suppliers to view how they are performing on Rockwell Collins Supply Chain Delivery and Quality measures. Provides details on supplier shipments that are early or late, as well as an overall quality score.

# Supplier Portals

- **Registration**

hBE Supplier Portal - <http://bsp.beaerospace.com/>



The image shows a login form for Collins Aerospace. At the top left is the Collins Aerospace logo, which consists of a stylized sunburst icon followed by the text "Collins Aerospace". Below the logo is a "Login" section with a light blue border. Inside this section, there are two input fields: "Username" and "Password". To the right of the "Username" field is a link that says "Forgotten Password?". Below the input fields is a "Login" button. The entire form is set against a white background with a subtle shadow.



Training and overview - <http://bsp.beav.com/Public/video/Buyer/BuyerVideo.html>

# Supplier portals

## Content

- The supplier portals contain a lot of information which may include:
  - Playbook
  - Training
  - Requirements documentation
  - Supplier Resources
  - Purchase Order and generator for ANS
  - Account information
  - Scorecards
  - Net Inspect
  - VMI Report
  - Move IT
  - Confirmations
  - Helpdesk
  - Ariba
  - Links to useful information and sites



# Supplier Quality Resource Portal



# Supplier Quality Resource Portal

- <https://portal.rockwellcollins.com/web/suppliers/supplier-quality-training-welcome>
- The Supplier Quality Resource Portal is intended for Collins Aerospace suppliers and internal associates. You will find resources ("how to" recordings & documents) related to Quality risk mitigation tools/processes, such as APQP/PPAP, Work Transfer, Zero Defect Plan (ZDP™), along with other topics.
- The Supplier will have to request access to this site.

## Welcome to the Collins Supplier Quality Resource Portal!

This site is intended for Collins Aerospace suppliers and internal associates. You will find resources ("how to" recordings & documents) related to Quality risk mitigation tools/processes, such as APQP/PPAP, Work Transfer, Zero Defect Plan (ZDP™), along with other topics.

### Advanced Product Quality Planning (APQP) / Production Part Approval Process (PPAP)

[Collins APQP Introduction \(4-min Video\)](#)

[CMS & APQP Infrastructure \(7-min Video\)](#)

[Intermediate PPAP Training \(3-hour Video\)](#) | [Presentation \(PDF\)](#)

[PFMEA & Control Plan Training Material \(PDF\)](#)

[COL-FRM-0990 \(MPR template\) \(Excel\)](#)

[PPAP Supplier Q&A \(PDF\)](#)

[PPAP Tool Box for Collins Aerospace and Pratt & Whitney \(External Link\)](#)

### Supplier Managed Work Transfer (SMWT)

[SMWT Training Video for Suppliers | Presentation \(PDF\)](#)

### Industry Standard Resources and Guidance

[SAE IAQG Supply Chain Management Handbook \(SCMH\)](#)

[American Society for Quality \(ASQ\)](#)

[Automotive Industry Action Group \(AIAG\)](#)

### Zero Defect Plan (ZDP™)

[Methodology Overview \(ZDP™ 102\) Video](#)

[Escape Data Review \(ZDP™ 201\) Video](#)

[Process Risk Identification \(ZDP™ 202\) Video](#)

[Quality Control Plans \(ZDP™ 203\) Video](#)

[Non Advocate Reviews \(ZDP™ 204\) Video](#)

[Process Certification Introduction \(PC 101\) Video](#)

[Key Characteristics and Process Certification Reviews Video](#)

[ZDP™ Template Training Video](#)

[Other ZDP™ Resources](#)

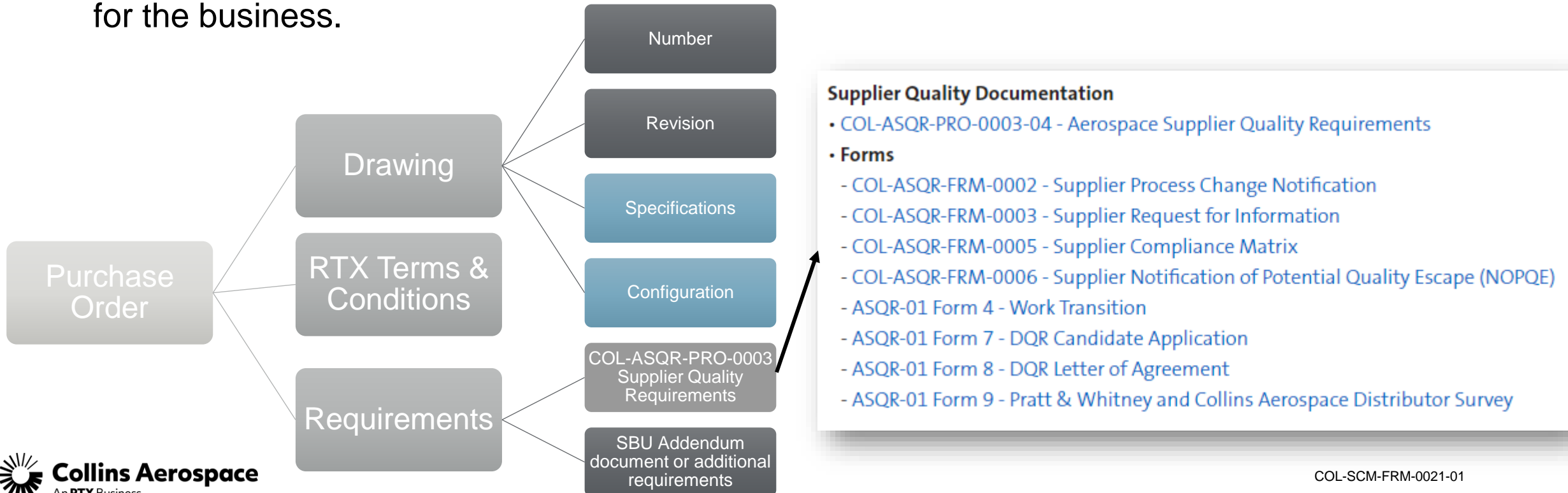
# Flow Down Requirements



# Flow Down Requirements

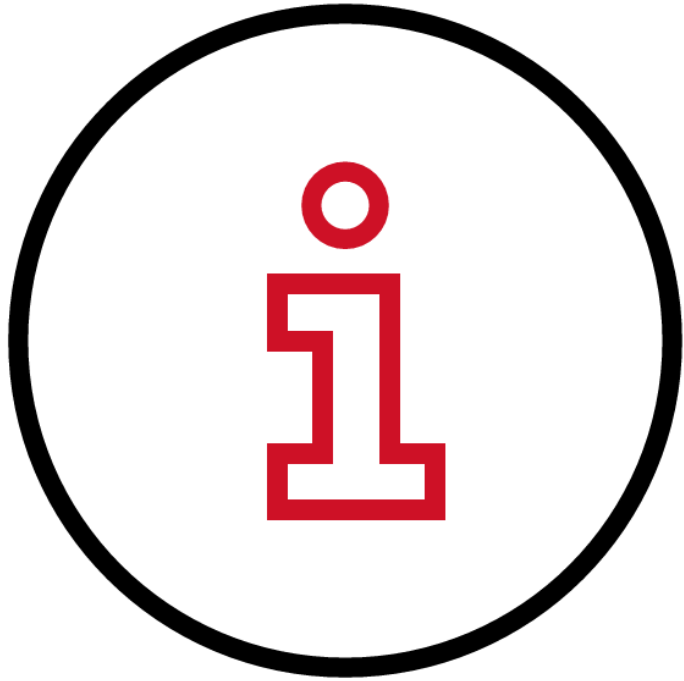
## It starts with your Purchase Order

- The PO will have the requirements referenced which can be accessed through the supplier portals and/or at: <https://portal.rockwellcollins.com/web/suppliers/utc-supplier-docs>.
- It is the supplier's responsibility to ensure they are using the latest specifications.
- COL-ASQR-PRO-0003 (Supplier Quality Requirements) is the Collins common requirements for the business.



# Flow Down Requirements

## Collins Aerospace Strategic Business Unit (SBU) Addendum Documents



- In addition to the COL-ASQR-PRO-0003, SBUs may have an addendum document listing other requirements which would be flown down using the purchase order.
  - The SBU addendum document may reference COL-ASQR-PRO-0003 within the requirements.
- These addendum documents can be located within the supplier portals and/or at:  
<https://portal.rockwellcollins.com/web/suppliers/utc-supplier-docs>.
- Any additional documents or requirements may also be referenced on the purchase order.

Overview

# **COL-ASQR-PRO-0003**

**(Aerospace Supplier Quality Requirements)**





# COL-ASQR-PRO-0003

## Supplier Quality Requirements

- COL-ASQR-PRO-0003 is a Collins Aerospace document that was developed to incorporate quality requirements specifically for the organization to use as a flow down to the supply base in addition to the Raytheon Technologies requirements (e.g., Terms & Conditions)
- The document includes for example some of the topics below:
  - Definitions & Acronyms
  - QMS Certification Requirements
  - Order of Precedence
  - Communication
  - Quality Alerts
  - Government Industry Data Exchange (GIDEP)
  - Right of Access
  - Supplier Initiated Changes
  - Supplier Managed Work Transfer
  - Documented Information
  - Acceptance Authority Media (AAM)
  - Record Retention
  - Supplier Performance
  - Foreign Object Debris (FOD)
  - AS9145
  - First Article Inspection (FAI)
  - Process Capability Study (e.g., sFAI)
  - Raw Material Verification
  - Customer Supplier Or Owned Property
  - Obsolesce Management
  - Counterfeit Risk Mitigation
  - Monitoring and Measurement of Equipment
  - Monitoring and Measurement of Product
  - Configuration Management
  - Inspection Sampling
  - Operator Certification
  - DQR/DPRV Program
  - Special Processing
  - Preservation of Product
  - Direct Shipment / Drop Shipment
  - Zero Defect Plan (ZDP™)
  - Quality Control Actions
  - Product Inspection Certification
  - Corrective Action
  - Nonconformity
  - Notice of Potential Quality Escape (NOPQE) or disclosure

# Associated Forms

| Current Form Number | Title  | Future Form Number | New Title  | Used For   |
|---------------------|--|--------------------|--|--|
| ASQR-01 Form 1      | <i>Internal Audit Checklist</i>  | COL-FRM-0045       | <i>QMS Supplier Audit Checklist</i>                                      | •Self-assessing compliance/gaps to this document   |
| ASQR-01 Form 2      | <i>Process Change Notification</i>                                       | COL-ASQR-FRM-0002  | <i>Supplier Process Change Notification</i>                              | •Notification of and request for approval of changes that may affect product quality and/or product fit, form, or function.<br>•Notification of any potential, known, or planned obsolescence<br>•Notification of work transfers which do not require approval   |
| ASQR-01 Form 3      | <i>Supplier Request for Information (SRI)</i>                            | COL-ASQR-FRM-0003  | <i>Supplier Request for Information (SRI)</i>                            | • Requesting clarification, interpretation, or communication of identified errors for drawings specifications, requirements.<br>• Requesting authorization for deviations/exclusions to quality requirements.<br>• Requesting approval before altering/repairing customer property.<br>• Requesting approval to use material/hardware with broken traceability or from an unauthorized source.<br>• Inform Collins Aerospace about the expiration of tool life.<br>• Requesting approval to use an alternate inspection plan.<br>• For use when situation or communication is not covered by any other form. |
| ASQR-01 Form 4      | <i>Work Transitions</i>  | ASQR-01 Form 4     | <i>Work Transitions</i>  | •Requesting approval of planned work transfers (e.g., make to make, make to buy, buy to buy, and buy to make)  |
| ASQR-01 Form 5      | <i>Compliance Gap Analysis</i>   | COL-ASQR-FRM-0005  | <i>Supplier Compliance Matrix</i>  | •Self-assessing compliance/gaps to this document   |
| ASQR-01 Form 6      | <i>Notice of Potential Quality Escape (NOPQE)</i>                        | COL-ASQR-FRM-0006  | <i>Notice of Potential Quality Escape (NOPQE)</i>                        | •Communicating discovery of suspect and validated nonconforming product having been shipped regardless of destination and time frame   |
| ASQR-01 Form 7      | <i>Delegated Quality Representative (DQR) Candidate Application Form</i> | ASQR-01 Form 7     | <i>Delegated Quality Representative (DQR) Candidate Application Form</i> | •Requesting approval for DQR candidates  |
| ASQR-01 Form 8      | <i>Letter of Agreement DQR Program</i>                                   | ASQR-01 Form 8     | <i>Letter of Agreement DQR Program</i>                                   | •Documenting acceptance in DQR program (approval granted once every three years)   |
| ASQR-01 Form 9      | <i>Qualified Distributor List (QDL) Request</i>                          | ASQR-01 Form 9     | <i>Qualified Distributor List (QDL) Request</i>                          | •Requesting approval to use a Distributor that is not on the RTX QDL   |

Document Highlights

# **COL-ASQR-PRO-0003**

**(Aerospace Supplier Quality Requirements)**



# Technical Data

- Technical Data is information in any form necessary for the design, development, production, operation, installation, modification, or maintenance of Hardware, Materials, Software, or processes related to those necessary actions. Technical Data does not include financial, management, and specific publicly available data.
- Technical data can be a drawing, picture of a part, and even a technical conversation with someone. Technical data is the information ***in any form*** necessary that would allow for reproduction of export-controlled materials.
- Any communication between Collins Aerospace and a supplier that contains technical data must be transferred through the approved process – please contact your Collins Purchasing or Supplier Quality Representative for how to accomplish this prior to sending information.

# Notification of changes

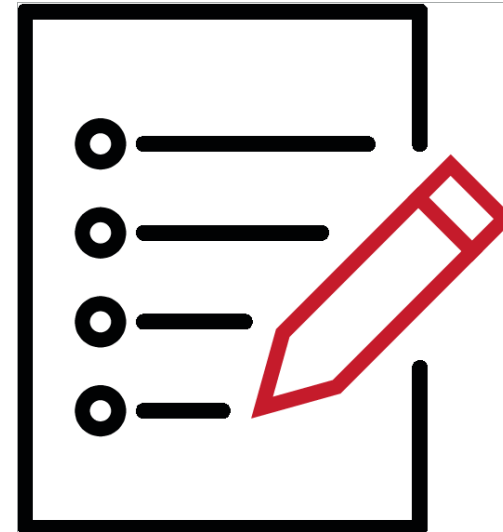


- Collins Quality shall be notified in writing when any changes are made to the quality system that may affect product quality. Including but not limited to the following:
  - Company Ownership or Name
  - Quality Management
  - Sub-tier Suppliers Work Transfer
  - Significant changes in Quality Management Systems (QMS)
    - Loss of certification
    - Registrar
  - Change in manufacturing location
    - Supplier or Sub-tier



# Contract review

- Full contract review is required prior to acceptance of the purchase order.
  - This is the opportunity for the supplier to provide feedback to the bill of material or drawing.
  - The earlier in the process Collins receives this information, the greater the opportunity that request for changes can be accommodated.
- Ensure you have latest released drawings linked to revision called out on the PO.
- Contract review should be carried out by appropriate staff with the knowledge of all aspect of drawing implementation.
  - Material availability and manufacturability
    - Bar stock size
    - Raw material
    - Radius machining
    - Availability of tooling/equipment
    - Etc



# Qualified Distributor List (QDL)

- The Qualified Distributor List (QDL) is a list of Distributors that are qualified by RTX to provide raw metallics, electronics, and hardware. Note: Electronics include electrical, electronic, and electro-mechanical components (e.g., connectors, wire, electronic components, terminals, lugs, pc boards, semiconductors). Hardware includes fasteners (e.g., nuts, bolts, rivets, washers, pins, screws, clamps, springs, seals, O-rings, ferrules, fittings). Raw metallic materials include but are not limited to bar, sheet, plate, tube, wire, forging, casting, billet, ingot.
- Section 5.1.8 of COL-ASQR-PRO-0003, requires that all distributors of raw metals, electronics, and hardware in the supply chain shall be on the QDL unless a directed distributor is identified on the purchase order.
  - The QDL can be found at <https://www.rtx.com/suppliers/United-Technologies-Suppliers/United-Technologies-ASQRD>.
  - ASQR-01 Form 9 is used to initiate the addition process of the QDL and can be found at the link above with the QDL list.

5.1.8 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-suppliers/united-technologies-asqrd>.

- ASQR-01 Form 9 shall be used to initiate adding a distributor to the RTX QDL.

# Work Transfer

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) in section 5.8:

5.8 Supplier Managed Work Transfer

**5.8.1** When a supplier is planning a work transfer (e.g., make to make, make to buy, buy to buy, buy to make), the supplier shall request approval from each impacted Collins Aerospace SBU/site using ASQR-01 Form 4. The movement of work shall not commence until approval from all affected Collins Aerospace SBU/sites is received. Collins Aerospace may notify the supplier of product validation actions that are required to ensure the integrity of the product throughout the life cycle of the project and are maintained after the project is complete (e.g., PPAP, PFMEA). Refer section 5.7 for Supplier Initiated changes requirements.

- Suppliers shall validate all affected features, characteristics, and compliance to Collins Aerospace requirements.
- Transfer of any work (feature, operation, etc.) and multi-sourcing are also work transfers and all requirements shall be met.

**5.8.2** If changing from one source performing a special process to another Collins Aerospace approved source a partial FAI shall be completed to document and validate the new special process source; ASQR-01 Form 4 is not required. Refer to section 6.14 for Special Process requirements.

**5.8.3** For guidelines on implementing a work transfer process for the supplier and their supply chain, reference IAQG SCMH section 7.1 (Work Transfer Management).

- Suppliers shall notify Collins prior to commencing any work transfer activities using ASQR-01 Form 4. This can be accessed using the following link:
  - <https://www.rtx.com/suppliers/united-technologies-suppliers/united-technologies-asqrd>
- Training on the Collins work transfer requirements can be accessed using the Supplier Quality Resource Portal (refer to slide 19).

# Foreign Object Damage (FOD)

## Flow Down Requirements

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) section 5.13 flows down FOD requirements.
  - A copy of this standard can be obtained from SAE International at <http://standards.sae.org/>
  - Foreign Object Damage material in the IAQG/SCMH Section 3.4 handbook. A copy of this handbook is available through the IAQG web-site: <http://www.sae.org/iaqg/handbook/scmhtermsofuse.htm>

### 5.13 Foreign Object Damage (FOD)

5.13.1 For Foreign Object Damage (FOD) Prevention, supplier shall comply with the requirements of AS/EN/JISQ 9146.



- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) in section 6.7:

6.2.1 FAls shall be performed per AS9102 requirements, COL-ASQR-WRK-0001 and any additional SBU/site requirements.

- # Form 1

# Form 2

# Form 3

### **Characteristic Accountability**

# Raw Material Verification

## Flow Down Requirements

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) section 6.4 flows down raw material verification requirements.

### 6.4 Raw Material Verification

- 6.4.1 The supplier shall develop, document, and implement a periodic raw material verification program that will ensure that material(s) received from the supplier's sub-tier sources meets the applicable technical and quality requirement **to include validation of certification authenticity.**
- 6.4.2 Additional raw material verification (e.g., independent lab testing, XRF) shall be based on risk and SBU/site requirements.



# Counterfeit part detection and prevention

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) in section 6.7:

## 6.7 Counterfeit Risk Mitigation

- 6.7.1 Suppliers and distributors shall implement and enforce a documented Counterfeit Parts Prevention and Control Plan per industry standards. The plan shall flow down requirements of AS5553, AS6174, DFARS 252.246-7007, and/or DFARS 252.246-7008 as applicable throughout the supply chain.
- 6.7.2 The use of material and hardware with broken traceability or sourced from a non-authorized supplier (e.g., independent distributor/broker) is prohibited unless approved by Collins Aerospace. Supplier shall request approval from Collins Aerospace using COL-ASQR-FRM-0003 or SBU equivalent. Collins Aerospace will then provide direction for it, and how, the material can be used.
- 6.7.3 The use of Electrical, Electronic, and Electromechanical (EEE) parts with broken traceability or sourced from a non-authorized supplier (i.e., independent distributor/broker) is prohibited unless the non-authorized supplier is AS6081 certified and the EEE is subject to a Counterfeit Avoidance Program in accordance with the guidelines of ARP6328. Supplier shall request approval from Collins Aerospace using COL-ASQR-FRM-0003 or SBU equivalent prior to shipment.

- AS5553 for electronic components and AS6174 for non-electronic products (Note: there is a cost incurred for access to AS standards)
  - <https://www.sae.org/standards/>

# Customer Owned Property

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) in section 6.9:

6.9 Customer Supplied or Owned Property (Including but not limited to tooling, gages, fixtures, materials, test standards, and equipment)

6.9.1 Suppliers acquiring and/or controlling customer property accountable to Collins Aerospace shall be required to adequately care for, maintain, and assure property is used only as authorized.

6.9.2 Suppliers shall have a property control system which includes a property management plan, acquisition, receiving, identification, records, physical inventory, subcontractor control, reports, relief of stewardship, utilization, including consumption, movement and storage, maintenance, property contract closeout and self-assessment.

- The supplier receiving Collins Aerospace owned customer property shall return any customer property after PO requirements are completed unless documented approval is received from buyer for an alternative, disposition, including retention by the supplier.
- Once repair is performed on customer property validation and verification shall be conducted prior to use.
- The supplier is responsible for the repair of all supplied property damaged after receipt by the supplier, and for the preservation of customer property which are not in use.
- The supplier is responsible for the preventative maintenance of the customer property and shall have a documented process.
- The supplier is responsible to notify Collins Aerospace SBU/site for any worn customer property.
- The supplier is responsible for the replacement or replacement costs of any customer property that are lost, damaged beyond repair, or not returned.
- All supplied tooling/gages/fixtures in the custody of a supplier are subject to periodic inventory audits and calibration.

6.9.3 Suppliers shall maintain an accountable property log to monitor activity and location of customer supplied or owned property in their custody. This list shall include both the customer property supplied by a facility and fabricated by the supplier to manufacture contracted components but owned by its customer(s).

6.9.4 A surveillance audit of supplier's property management system may be conducted. Periodic onsite assessments may be necessary to verify quantity, storage conditions, and that items are used only for purposes authorized by the contract.

6.9.5 The supplier shall submit a documented request and receive formal approval before any alteration or repair is performed on customer property using COL-ASQR-FRM-0003 or SBU equivalent and ensure all calibration requirement activities are coordinated with the applicable SBU/site.

# Configuration Management

## Flow Down Requirements

- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) section 6.10 flows down configuration management requirements.

### 6.10 Configuration Management

6.10.1 The supplier shall have a process in place for configuration management (e.g., EIA649).

6.10.1.1 For suppliers with design authority, additional development and production configuration management requirements apply:

- Includes generation and maintenance of a complete Bill of Material (BOM), as applicable. This may include parts, standard parts, consumable parts, bulk parts, catalog parts, assemblies and subassemblies, software code, name, identification number, quantity and revision.
- Submit any supporting documentation for the configuration change, as applicable using COL-ASQR-FRM-0003 or SBU equivalent
- Submit evidence that supplier approved alternate parts and associated identification data are complete using COL-ASQR-FRM-0002 or SBU equivalent.

# Packaging specification requirements

## Flow Down Requirements

- Customer Requirements
- Packing requirements are flown down / contract - are in accordance with or reference:
  - ASTM D3951 (Standard Practice for Commercial Packaging)
  - MIL-STD-2073 (Standard Practice for Military Packaging)
- Supplier Quality Flow Down Requirements
- COL-ASQR-PRO-0003 (Aerospace Supplier Quality Requirements) section 6.15.5 flows down packaging requirements.

6.15.5 The packaging of product shipped to Collins Aerospace shall ensure protection from transit damage and at a minimum comply with the following as applicable (in addition to any stated requirements in Drawings / Specifications):

- Reference ASTM-D3951 for Standard Practice for Commercial Packaging
- Reference MIL-STD-2073 for Standard Practice for Military Packaging

# Certificate of Conformance

- Minimum CoC requirements are listed in COL-ASQR-PRO-0003 (Supplier Quality Requirements) section 7.1.1.

Table 7-1: Certificate of Conformance Minimum Information

|  |   |
|--|---|
| 1. Certificate of Conformance/Compliance   | 9. Part nomenclature or description per PO line item  |
| 2. Name and address of the organization/ supplier/ manufacturer providing product to Collins Aerospace | 10. Quantity of parts delivered   |
| 3. Name and address of Collins Aerospace facility product is delivered to.                             | 11. Serial number(s) of parts delivered for serialized parts. If serialization is not required, Work Order or Batch/Lot number shall be provided  |
| 4. Commercial and Government Entity (CAGE) Code / Unique Entity Identifier (UEI) Code (as applicable)  | 12. If applicable, non-conformance report number (e.g., QN, MRB #, etc.) Additional SBU requirements may apply.   |
| 5. Country of Manufacture and/or Country of Origin   | 13. Statement of conformity to Collins purchasing requirements (e.g., "I hereby certify the material / service supplied was produced in accordance with the PO, and all applicable drawings and specifications.") |
| 6. PO #, Revision, and Line Item   | 14. Signature or electronic signature and title of authorized supplier representative with date   |
| 7. Full drawing or specification number with revision(s) per PO (Configuration Requirements)           | 15. Source or DQR/ or Third-Party inspection stamp or electronic equivalent with date if applicable.  |
| 8. Part number as listed on the PO   |   |

- Raw material certs must be referenced or provided when applicable.
  - Suppliers must maintain traceability records for all material used to produce Collins parts and should be readily available upon request.
- Part number listed on PO must match part number on CoC.
- Electronic copies may be accepted if directed by the SBU.

**Add Vendor Name and Address**

## CERTIFICATE OF COMPLIANCE

Date: 4/11/2023

Customer: B/E Aerospace

Purchase Order No: 4508490386 Line Item No: 40

Part #  Rev.  Part Name:

Drawing #:  Rev.

Lot#: 209668 Qty: 100 Manufacturing Date: 04-11-2023 Shelf Life: 04-11-2025

Special Process:  Source of Process:  Cert./Lot No:

The following materials were used in the manufacture of P/N 1110315-459

Materials

|                           |                 |                                      |
|---------------------------|-----------------|--------------------------------------|
| Type <input type="text"/> | Lot# 872969     | Burn Cet. Test# <input type="text"/> |
| Type <input type="text"/> | Lot# C193593744 | Burn Cet. Test# <input type="text"/> |

This is to certify that material furnished for referenced purchase order has been manufactured in accordance with the applicable Government and customer specifications.

Supplier certifies material used to manufacture the part number listed above conforms to the controlling design data, and parts meet all requirements/specifications in the design data at the revision specified. The supplier also certifies that they have objective evidence of compliance to applicable specifications on file, traceable to the material/equipment supplied and available for review upon request.

Test reports and/or evidence of complete inspection are on file subject to examination and indicate conformance to applicable military and commercial requirements.

Vendor Responsible person  
Signature

  
 Signature: \_\_\_\_\_

Vendor Responsible person Name  
Printed

  
 Printed Name: \_\_\_\_\_

# Sub-Tier Management

- Supplier shall maintain their own approved supplier list (ASL) in accordance with Collins flow-down requirements and their own Quality Management System (QMS).
- Suppliers shall flow-down Collins requirements to their suppliers.
- 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.





# Sub-tier management

## Flow Down Requirements

- COL-ASQR-PRO-0003 (Supplier Quality Requirements) sections below flow down sub tier management requirements.
  - **Section 1.4 - 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 (reference Appendix 2).**
  - Section 2.3 - Collins Aerospace verification activities performed at any level of the supply chain does not absolve the organization of its responsibility to provide acceptance processes, products, and services and to comply with all industry requirements.
  - Section 5.1.2 - The supplier shall ensure that members within its supply chain are compliant to applicable industry specification listed in table 5-1.
  - Section 5.1.7 - All distributors within the supply chain shall be certified by an industry accredited body to AS/EN/JISQ 9100, AN/EN/JISQ 9120, ISO 9001, or IATF 16949.
  - Section 5.8.3 - For guidelines on implementing a work transfer process for the supplier and their supply chain, reference IAQG SCMH section 7.1 (Work Transfer Management).
  - Section 5.10.1 - 5.10.1 The supplier shall, within its organization and its supply chain, ensure that the use of Acceptance Authority Media (AAM) (e.g., Stamps, electronic signatures/ initial log, passwords) is clearly defined within its QMS. Supplier shall ensure the method of AAM is controlled and secure. The use of AAM is considered personal commitment of accuracy of work performed or witnessed. If an employee is terminated or leaves the Supplier's employment, their AAM access is removed.

# Sub-tier management

## Flow Down Requirements

- COL-ASQR-PRO-0003 (Supplier Quality Requirements) sections below flows down sub tier management requirements.
  - Section 6.1.3 - When required, the supplier shall flow down the requirements of APQP and PPAP to all members of the supply chain and maintain records for compliance.
  - Section 6.4.1 - The supplier shall develop, document, and implement a periodic raw material verification program that will ensure that material(s) received from the supplier's sub-tier sources meets the applicable technical and quality requirement to include validation of certification authenticity.
  - Section 6.7.1 - Suppliers and distributors shall implement and enforce a documented Counterfeit Parts Prevention and Control Plan per industry standards. The plan shall flow down requirements of AS5553, AS6174, DFARS 252.246-7007, and/or DFARS 252.246-7008 as applicable throughout the supply chain.
  - Section 7.1.9 - Supplier shall verify product compliance from certification received from their sub-tiers.

