

# B/E AEROSPACE

## Consumables Management

Understanding QAP 33  
& Paperwork Error Reduction Training



## **QAP 33.0 (Quality Assurance Requirements)**

- Quality Clauses are flowed-down by the Purchase Order, Memorandum of Understanding (MOU) or other contract. Product and/or orders not meeting the requirements of the Quality Assurance Clauses QAP 33.0 are subject to return and/or corrective action.

**IMPORTANT NOTICE: Current QAP 33.0 may be found at:**

<http://www.beconsumables.com>

- Site map tab
- Supplier Communications link (found under Quality Section)

# B/E Aerospace Purchase Order Clause Requirements



## Clause A: Certification of Conformance

- A signed Manufacturer's Certification (MCC) required with each shipment
- MCC shall have Quality Rep. or officer's signature with date
- Lot segregation required for each manufactured lot in the shipment
  - Qty by lot is required on the C of C
- Traceability from manufacturer to B/E shall be included for each lot in the shipment – including Distributors C of C (full Chain of Custody)
  - Traceability may be determined by PO/Part Number, Heat #, Manufacturer Lot Number, or any other method that clearly demonstrates traceability. There must be a clear link(s) that tie the entire certification package together
- All Certificates of Conformance shall contain:
  - Purchase Order number
  - Part Number and revision (as ordered). If no revision is noted, provide and certify to latest revision. Reference P/Ns not acceptable
  - Quantity
  - Manufacturer's name and Part Number (if applicable)
  - Lot number
  - Serial number (if applicable)
  - Certification of Conformance statement
  - Shelf life requirements *including cure date* (if applicable)
  - Distributors shall include a signed Distributor C of C (DCC)
  - Statement of Origin (i.e. Made in USA)
  - ITAR / EAR products (based on original design intent) – ITAR category or ECCN is required

# B/E Aerospace Purchase Order Clause Requirements



## Clause A.1: DFAR 252.225-7014 Berry Amendment Specialty Metals applies

- Material on this Purchase Order must comply with \*DFAR 252.225-7009
- The above statement proving DFAR compliance per \*DFAR 252.225-7009 must appear on the Certificate of Compliance or associated paperwork

## Clause A.2: ASQR-01 Supplier Quality System Requirements (UTC End-Use)

- The supplier must ensure that all specifications within ASQR-01 are met. These requirements include but are not limited to:
  - ASQR-07.5 Control of Software
  - AQSR-15.1 Handling, Storage, Packaging, Preservation and Delivery
  - ASQR-20.1 Supplier Sampling Requirement
  - UTCQR-09.1 Process Certification Requirements

**Note:** ASQR-01 Compliant must appear on the Certificate of Conformance or associated paperwork

## Clause A.3: Quality Clause Requirements

- The Quality Requirements on the Purchase Order take precedence over the QAP 33.0
- B/E Aerospace, its customers, and regulatory agencies shall have the right of entry to any place necessary to determine and verify the quality of contracted work, records and material
- All documents must be one-sided, 1 certification per page, legible, reproducible, and no larger than 8 ½" x 11" in size
- For Honeywell Proprietary Parts, the Honeywell SPOC manual and drawing will take precedence over this document
- When Vendor Substantiation Engineering Approval (VSE) is denoted, it is a supplier obligation to obtain, prior to quoting or producing hardware
- Certifications and test reports supplied in fulfillment of orders must be in English
- Certification packages must be available if requested, within 48 hour of request

# B/E Aerospace Purchase Order Clause Requirements



## Clause B: Inspection Sampling Requirements

- Sampling plans for all attributes must be based on C=0 (reject lot on 1 failure)

## Clause C: Protection of Materials

- Adequate packaging to prevent damage / FOD
- Each Box / Carton not to exceed 40 pounds
- Protection from rust, corrosion and elements
- Silver-plated parts / assy's shall be protected from sources that will cause tarnish
- Use Cap Plugs, Sleeves, etc. to protect surfaces as necessary
- Electro Static Discharge (ESD) products require ESD packaging
- Any required repackaging to meet requirements will be at Supplier's expense

## Clause C.1: Thread Protection

- Threads to be sleeved or otherwise packaged to prevent damage. This does NOT take precedence over governing Blue Print specifications

## Clause D: O-Rings / Packings / Rubber Products / Age Sensitive

- Test Report in accordance with Material or Product Specification is required with each shipment
- Certifications must include:
  - Batch Number
  - Cure Date (format may be standard mm/dd/year or 4Q01 format)
- Test Report must include actual values per the specification
- Not more than 15% of the shelf life, or 12 quarters, whichever is less, may have expired prior to shipment to B/E
- All lots shall be segregated and identified to maintain traceability
- All distributors must also include a Certificate of Conformance (DCC)
- Distributors shall include all documents that include full traceability to the original manufacturer for each lot in a shipment
- For rubber products other than O-rings and Packings (seals, gaskets, etc.), a Material Certification with Batch Number and Cure Date is required, if a Test Report is not available

**Note:** This Clause applies to all age sensitive products

## Clause E: Material, Physical & Chemical Certifications

- Supplier shall provide full certifications with each shipment
  - Requires actual chem/phys results as required by specifications
  - Requires all special process certifications
- Must be on company letterhead
- Contain the signature and title of authorized Quality representative
- Include specification(s) and revision letters used to produce the order
- Certify in accordance with requirements as applicable
  - Contract / Drawing / Sped
- Each manufactures Lot must be segregated in the shipment
- All processed lots must be segregated and have complete traceability (does not include vendor proprietary catalog items)
  - Special process certifications may be listed on the MCC if process internally
    - Heat Treat, Plating, Passivation, etc.

**Note 1:** Material and process certifications are not required with shipment of Ball Bearing, Roller Bearing and Pin Bearing commodities, unless in support of a First Article package.

**Note 2:** Certifications must be made available within 48 hours of request

**Note 3:** Material Certs may be substituted in lieu of Test Report if product is non-metallic, but shall contain the Batch Number and Cure Date



## Clause F: Special Processes

- Certifications for special processes shall be submitted with each shipment
- Certifications may be transcribed to the MRF Test Report or MFR C of C for parts processed internally
- All special processing requires an approved processor (when applicable/required by the OEM design activity owner and their APSL) and a certification traceable to the manufacturing lot must be provided
- This clause does not apply to Industry Standard or Commercial Standard items
- Approved sources and specifications shall be evaluated during Contract Review and whenever released for production
- If a processor is no longer active on current OEM APSL:
  - Verify that the supplier was approved at the time the parts were processed/manufactured
  - If processor was approved, include on certification document:
    - “Processor was approved at the time the parts were manufactured”
  - Do not ship nor certify, if the processor’s approval status cannot be verified

## Clause F: 1 NADCAP Certified Processor Required

- All special processes identified on the drawing shall be completed and certified to by a NADCAP certified processor
- This requirement may be invoked for special processes on industry standard parts

## Clause G: First Article Inspection Report (FAIR)

- FAIR must be submitted within initial shipment and again as required by CAGE owner's First Article Rules
- FAIR shall be compliant to AS9102
- Forms other than those contained in the AS9102 Appendix may be used, however they must contain all required and conditionally required information and have the same field reference numbers – unless this violates design holder's requirements
- FAIR shall be on file, available upon request

**Note:** Honeywell Proprietary Part Numbers – FAIR requirements of that Customer's Quality System Standard take precedence (Clause R)

## Clause H: Notification, Containment, and Corrective Action

- Supplier shall provide prompt written notification to B/E when nonconforming products or processes have been shipped
  - Notification must include:
    - Part Numbers
    - Traceability (Example: Lot Numbers / Serial Numbers)
    - Ship Dates
    - Quantities
    - Description of the nonconformance
- Upon notification by B/E (Form QAF-06) Supplier shall complete containment activity within 48 hours
- When formal corrective action is required:
  - Utilize B/E Corrective Action process
  - Submit response by the specified due date
  - Request extension as needed – *do not go past due* – this affects your Supplier rating

# B/E Aerospace Purchase Order Clause Requirements



## **Clause I: Lab Control at Source (LCS)**

- Parts must be certified as tested to Pratt Whitney LCS Lab Manual requirements. All documents must be stamped with P & W LCS compliance statement

## **Clause J: Supplier Acceptance Testing Procedure (SATP)**

- A copy of the SATP test data sheet is required with the shipment

## **Clause K: Fixed Process Control (SPOC 110)**

- Process approval is required prior to starting work

## **Clause L: Customer/Government Source Inspection**

- Customer (B/E's customer) or government source inspection is required prior to shipment to B/E

## **Clause M: MRB (Material Review Board) Authority**

- B/E does not grant MRB authority
  - Use As Is or Repair dispositions not allowed on other design owner's products

# B/E Aerospace Purchase Order Clause Requirements



## Clause N: Aircraft Parts Documentation

- The item on face of Purchase Order must be an FAA or JAA/EASA approved article
- Following conditions apply:
  - PMA Holder – the item must be marked appropriately
    - “FAA-PMA” must appear on Certificate of Conformance (C of C) or test reports
    - C of C must include direct ship statement if authorized by Production Approval Holder (PAH)
  - TSOA Holder – the item must be marked appropriately
    - “FAA-TSOA” statement and TSO number must appear on C of C or test reports
    - C of C must include direct ship statement if authorized by Production Approval Holder
- If you are the PAH, a production certificate statement of conformity with certificate number is acceptable in lieu of other certifications (clauses) requested
  - Product must still be marked in accordance with FAA/JAA/EASA requirements
- If you are not the PAH, and do not hold PMA or TSOA for the item ordered and cannot produce an 8130-3 tag, then Supplier MUST take exception to this clause and have it removed
  - Failure to do so will result in the order being rejected and returned

# B/E Aerospace Purchase Order Clause Requirements



## **Clause O: Airworthiness Approval Tag**

- FAA Form 8130-3, JAA Form One or EASA Form One required

## **Clause P: B/E Bar-Coded Supplier Shipping Label**

- A bar-coded shipping label required on outside of each container
- If you have questions, contact your B/E Supplier Engineer or Buyer

## **Clause Q: Lubrication Requirements**

- All lubrication dates must be current within six (6) months of shipment to B/E

# B/E Aerospace Purchase Order Clause Requirements



## Clause R: Honeywell Aerospace Quality Requirements

- Invokes SPOCs (refer to Honeywell SPOC Manual)
- Adherence to the appropriate Group Codes is dependent on your manufacturing design authority

SPOC Group Number	Individual SPOCs Invoked by SPOC Group
SPOC 001 * Manufacturer with Design Authority	Sections 1.0 and 2.0, 100, 106, 124, 127, 128, 129, 130, 140, 142, 149, 154, 200, 239, 267, 354, 410, 418, 419
SPOC 002 * Manufacturer without Design Authority	Sections 1.0 and 2.0, 100, 106, 124, 127, 128, 129, 130, 140, 142, 149, 154, 165, 200, 239, 267, 354, 410, 418, 419
SPOC 003 * Standard and/or Catalog Hardware	Sections 1.0 and 2.0, 100, 106, 140, 142, 200, 239, 267, 354, 418, 419

## The following items are exempt from the requirements of this SPOC:

- Honeywell vendor items including specification-controlled, 10- or 11-digit drawings and S-numbered drawings
- Nonfunctional hardware (protective covers, shipping hardware, etc.)

# B/E Aerospace Purchase Order Clause Requirements



## Clause R: Honeywell Aerospace Quality Requirements

- The latest version of the Honeywell Aerospace Supplemental Purchase Order Condition (SPOC) Manual, SPOCS 001, 002 or 003 are invoked on this order as per Note 1 below – minus SPOC 149 (Honeywell’s SPOC 149 is not a requirement on these orders)
- The Honeywell Aerospace SPOC Manual can be obtained on the Internet at [www.supplier.honeywell.com](http://www.supplier.honeywell.com)
- For purposes of interpreting SPOC Manual requirements by Honeywell Aerospace site, the blueprint Cage Code will identify the Cage Code holder and Honeywell site

Honeywell Aerospace Site	Cage Code
Phoenix, AZ	99193, 91547, 9AA11
Tempe, AZ	59364, 00672, 72914, 89513, 077L2
Rocky Mount, NC	06848, 34270, 55284
Torrance, CA	70210, 77068, 5T400
Tucson, AZ	64547, 83298



## Clause R: Honeywell Aerospace Quality Requirements

### Critical Notes:

- Adherence to the appropriate Group SPOC codes for the following are based on your manufacturing authority and are invoked on this order:
  - SPOC 001 is for manufacturers with design authority
  - SPOC 002 is for manufacturers without design authority
  - SPOC 003 is for standard and/or catalog hardware providers
- SPOC 124 rules for FAIR apply to all manufacturers of HW parts, to include all Purchase Orders issued by B/E Aerospace
- A FAIR meeting all requirements of SPOC 124 SHALL be sent with the initial shipment of any Part Number and then again as necessary, in order to meet the SPOC 124 Event Table requirements. Honeywell FQE validation not required
- A complete Detailed Inspection Plan (DIP), meeting the requirements of SPOC 128 and pertaining to the lot shipped, SHALL be provided with each shipment

## Clause R: Honeywell Aerospace Quality Requirements

- Material Certifications (SPOC 001 & 002 requirements):

Certifications shall include name of process source, specifications and revision used. The physical and chemical process and heat numbers shall be indicated. Certifications must clearly state conformance to all specifications in their entirety, including embedded specifications with specific acceptance criteria, additional processing requirements and any specific requirements that pertain to hardware approval or acceptance (Drawn directly from SPOC 140.2, Table III C of C Requirements)

# B/E Aerospace Purchase Order Clause Requirements



## **Clause S: Left Blank**

## **Clause T: Mercury Free Certifications**

- Materials must be certified to be mercury free

## **Clause U: Record Retention**

- Serialized parts require 30 years
- Non-serialized and radiographic film require 10 years
- Certification requests – Certs must be made available within 48 hours of request

## **Clause V: Quality System Approval**

## **Clause W: Source Inspection Required**

- Source Inspection not required at Self Release Suppliers

## **Clause X: Suppliers with Design Authority**

- Suppliers are required to notify B/E Aerospace promptly with any changes to fit, form, function or safety of product and obtain approval prior to delivery

## **Clause Y: Non-Flight Hardware – Packing Slip Only**

## **Clause Z: Deleted**