
TITLE:**Supplier Quality System Requirements**

warning

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INTRODUCTION

This specification defines supplier quality requirements as agreed upon by the following business entities as UTC members of the ASQR Common Specification Team herein referred to as "UTC member":

Hamilton Sundstrand	HS
Pratt & Whitney	PW
Pratt & Whitney Canada	PWC
Sikorsky Aircraft	SAC
UTC Power	UTCP

This document applies to suppliers and all members of their supply chain who furnish product, material, processes, and services.

UTC members reserve the right to flowdown additional requirements to satisfy specific customer and / or business requirements that will apply only to the UTC member.

Each UTC member has the individual right to disapprove a supplier's Quality System as well as the Quality System of their subcontractors.

This document employs, as a foundation, SAE Aerospace Standard (AS) 9100 requirements and is supplemented by UTC member requirements as defined herein.

Each member, their representatives, and their customers government/regulatory agencies shall have the right of entry into a supplier's facility or that of their subcontractors. Entry shall provide for access to quality system documentation and quality records as well as the ability to conduct audits and verify product and processes.

In an effort to standardize the use and application of the common quality system requirements, the SAE AS 9100 paragraph numbering scheme has been used.

REVISION SUMMARY

This document has been completely revised, please review procedure in its entirety. Major changes include:

- All references to “Sections” (i.e., I, II & III) have been removed.
- Introduction, General Application and Scope has been rewritten entirely, major changes include the following:
 - Updated UTC Fuel Cells organization name to UTC Power.
 - Clarified application intent of ASQR-01; added “processes” and “employed in the manufacturing of these products”.
 - Added “UTC members reserve the right to flowdown additional requirements to satisfy specific customer and / or business requirements...”
 - Added the UTC member right of entry clause for intent / clarification (Note: This was in revision 4 and removed from revision 5 as the right of entry is stipulated in AS9100).
 - Deleted all reference to common & unique requirements throughout the document as all original equipment manufacturing (OEM) member unique requirements have been cancelled.
- Clarified to mention “Quality Management System Requirements of”.
- Editorial change made to made to capitalize database name “OASIS”.
- Editorial change made to explain the “PRI” & “AECMA-EASE” acronyms.
- Paragraph 1.2.3 added note to indicate that ASQR-01 paragraph 7.5.2 shows requirements for special processes.
- Table in paragraph 2.4 revised to remove Performance Review Institute because they do not provide documents and Registration Accreditation Board because they have been dissolved. Also reference SAE AIR 5359 has been removed because it has been replaced by AS 9104.
- Table in paragraph 2.4 revised to add name/address information for the American Welding Society and Aerospace Industries Association that introduced Vision requirements noted in AIA / NAS 410 and AWS D17.1.
- Paragraph(s) 4.2.3, 7.4.1, 7.5.1, 8.2.2, 8.2.4.1, and 8.5.2 editorial change /corrections made to combine series of AS9100 letter prefixes reflecting “No Additional Requirements”.
- Paragraph 4.2.4 (1) added Training records to the list of examples. (2) Revised the 20 year record retention for SSME high pressure turbopump hardware to reflect 30 years for Manned Space Programs. Added a 5 year casting radiograph record retention requirement for military turbine airfoil (blades).

- Paragraph 6.2.2
 - (a) Added two bullets to capture that testing shall be accomplished in at least one eye, either corrected or uncorrected, and to add the Color Vision Testing requirement. Deleted the above from subparagraphs (1), (2), & (3).
 - Revised subparagraph (2) to capture NDT inspection vision testing only, and to align Near Vision Requirement with the industry standard AIA/NAS 410.
 - Created subparagraph (3) to capture weld inspector vision testing only, and aligned Near Vision Requirement with the industry standard AWS D17.1.
 - Added a Note to capture criteria for vision testing equivalence.
- Paragraph 7.2.3
 - (a), Added “and/or Purchasing” for communication and “Product” as another example of change to be communicated.
 - (b), Revised bullet (2) and updated the Note to clarify intent for use of ASQR-01 Form 3 (SRI).
 - (c)(2) Clarified to reflect the intent, requiring a Company owned e-mail address rather than a worldwide web internet address.
- Paragraph 7.4.3 moved paragraph from Paragraph 7.5.1 to better align with AS 9100 placement. This requirement was revised to include additional examples of Government oversight, such as the Department of Energy.
- Paragraph 7.5.2 removed requirement regarding special processes that was already stated in AS9100. Added (a) to reflect use of UTC member designated suppliers and (a) (2) to introduce recognition of Nadcap accreditation and/or NUCAP (Nadcap Users Compliance and Audit Program) approval.
- Paragraph 7.6 (a) 2 moved to paragraph 8.2.4 (3)
- Paragraph 7.6 (a) 3 added “if delivered product has been affected” to clarify intent of when the UTC member requires notification.
- Paragraph 8.2.4.2 revised to include additional First Article Requirements herein, as ASQR-08.2, First Article Inspection Requirements, has been cancelled.
- Paragraph 8.5.2(d), “Corrective Action” item (d), editorial change to replace the word “preventive” with “corrective” to better align with the intent of AS 9100.

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QUALITY MANAGEMENT SYSTEMS – REQUIREMENTS**1. SCOPE:**

1.1 General: No Additional Requirements

1.2 Application:

Suppliers and all members of their supply chain that provide UTC member product shall be compliant to all applicable Quality Management System Requirements and ASQR-01.

1.2.1 Suppliers who receive a purchase order from a UTC member company shall be certified / registered to the Quality Management Systems – Aerospace – Requirements of AS/EN/JISQ 9100.

1.2.2 Stockist Distributors or organizations carrying out the purchase, storage, splitting and sale of products without affecting product conformance shall be certified / registered to AS/EN/JIS Q 9100 or Quality Management Systems – Aerospace Requirements for Stockist Distributors AS/EN/JISQ 9120.

1.2.3 Suppliers that only provide special processes (e.g., surface enhancement (shot peen), plating, heat treatment, bonding, nondestructive testing, welding, coating, chemical processing, electro-chemical machining, etc.) that receive a purchase order from a UTC member shall be certified/registered to AS/EN/JISQ 9100 or meet the requirements of SAE AS 7003.

Compliance to SAE AS 7003 is demonstrated by satisfactory audit to National Aerospace And Defense Contractors Accreditation Program (Nadcap) (AC) 7004. Audit is to be performed by Performance Review Institute (PRI) or AECMA-EASE (European Association of Aerospace Industries – European Aerospace Supplier Evaluation).

Note: *Additional requirements for approval and use of special processes are located in ASQR-01 paragraph 7.5.2*

1.3 Supplier Certificate(s) of Registration to applicable Aerospace Quality Management System (AQMS) assessments must be issued by a Certification Registration Body (CRB).

The CRB must be accredited under the control of the International Aerospace Quality Group (IAQG) certification/registration schemes, as recognized by the Aerospace Standard SAE AS 9104. Reference the [IAQG website](#) for a listing of accredited CRBs.

Note: *You will need to register on the IAQG website and receive a password in order to view the list of accredited CRBs.*

- 1.4 Other party Certificate(s) of Registration or Nadcap Accreditation Certificates/documentation must be submitted to each UTC member that issued a purchase order if information has not been entered into the OASIS or Nadcap databases.
- 1.5 Suppliers shall permit UTC members access to all data in OASIS and Nadcap databases including registration documentation, certification, audit reports, findings, corrective actions, etc.
- 1.6 The supplier is responsible to provide each UTC member with notification of any changes in the certification / registration / accreditation or major audit findings within (2) business days of receiving notification of the change or finding. Examples of changes in registration include new certification, suspension, or expiration.
- 1.7 Suppliers not certified / registered / accredited are subject to removal from the Qualified Supplier List. If the UTC member elects to continue a business relationship with the supplier, the supplier is subject to QMS and / or Special Process audits by UTC members. Suppliers may be required to reimburse the UTC member company for the cost of conducting these audits until certification / registration / accreditation is achieved.

2. NORMATIVE REFERENCE:

- 2.1 It is the responsibility of the supplier to ensure that they are working to the latest version of specifications referenced within this document as well as purchase order requirements.
- 2.2 Requests for UTC member-specific specifications that are needed shall be requested from the applicable UTC member's Procurement department.
- 2.3 Supplier shall refer to the Specification Revision List date or the specification revisions identified on the purchase order to determine the revision of the specification that applies.

- 2.4 It is the responsibility of the supplier to obtain copies of non-UTC documents specified by this ASQR. These documents include, but may not be limited to, the following:

DOCUMENT	AVAILABLE FROM
ISO STANDARDS	1. Canadian Source Standards Council of Canada 350 Sparks Street Ottawa, Ontario K1R 7S8, Canada
	2. American Source American National Standards Institute 11 West 42nd Street New York, New York 10036 U.S.A.
	3. European Source International Organization for Standardization Case Oistake 56 CH-1211 Geneve 20 Switzerland
	4. Asian Source The Society of Japanese Aerospace Companies (SJAC) Toshin Tameike Bldg.2nd Floor, 1-1-14 Akasaka, Minato-ku, Tokyo 107-0052 Japan
SAE SPECIFICATIONS	Society of Automotive Engineers 400 Commonwealth Drive Warrendale, PA 15096-0001, U.S.A.
ANSI SPECIFICATIONS	American Society for Quality 611 East Wisconsin Avenue Milwaukee, WI 53201-3005, USA
AWS Specifications	American Welding Society 550 N.W. LeJeune Road Miami, FL 33126
AEROSPACE INDUSTRIES ASSOCIATION NAS STANDARDS	Aerospace Industries Association of America, Inc. 1250 Eye Street, N.W. Washington, D.C. 20005

INFORMATION REFERENCED IN THIS DOCUMENT	
AIA/NAS 410	National Aerospace Non-Destructive Test Project Group
ANSI/NCSL Z540-1	Calibration Laboratories and Measuring & Test Equipment – General Requirements
ANSI/NCSL Z540-2	U.S. Guide to the Expression of Uncertainty in Measurement
ASQR-07.5	Control of Software
ASQR – 09.1	Flight Safety Parts Program
ASQR – 15.1	Handling, Storage, Packaging, Preservation and Delivery
ASQR – 20.1	Supplier Sampling Requirement
AWS D17.1	Specification for Fusion Welding for Aerospace Applications
ISO 10012	Quality Assurance Requirements for Measuring Equipment
ISO 17025	General Requirements for the Competence of Testing and Calibration Laboratories
PRI AC 7004	Nadcap Audit Criteria For Inspection and Test Quality System
SAE AS 7003	National Aerospace and Defense Contractors Accreditation Program (Nadcap) Program Requirements
SAE AS 9100	Quality Management Systems – Aerospace – Requirements
SAE AS 9102	Aerospace First Article Inspection Requirement
SAE AS 9104	Requirements for Aerospace Quality Management System Certification/Registration Programs
SAE AS 9120	Quality Management Systems – Aerospace Requirements for Stockist Distributors
UTCQR – 09.1	Process Certification Requirements

FORM REFERENCE	
ASQR-01 Form 3	Supplier Request for Information (SRI)

3. TERMS AND DEFINITIONS:

No Additional Requirements

4. QUALITY MANAGEMENT SYSTEM:

4.1 General Requirements: No Additional Requirements

4.2 Documentation Requirements: No Additional Requirements

4.2.1 General: No Additional Requirements

4.2.2 Quality Manual: No Additional Requirements

4.2.3 Control of Documents:

(a) No Additional Requirements

(b) Corrections to work instructions or documents must be recorded, dated and signed in ink or other permanent marking method with the original data being legible and retrievable after the change.

(c) and (d) No Additional Requirements

(e) All quality records (non-electronic) shall be documented in ink or other permanent marking.

(f) and (g) No Additional Requirements

4.2.4 Control of Records:

(1) Electronic imaging/microfilming of records in lieu of storing actual inspection records is permissible. All electronic records must be controlled, retained, and retrievable per the same requirements identified for hard copy records. For electronic records that are transferred from computer files, the storage media must be capable of maintaining the data integrity for the full retention period.

Examples of Quality Records to be retained are, but not limited to:

- Deliverable and nondeliverable software verification & validation
- First article inspection reports
- In process / final inspection & test records
- Training records

- Manufacturing / fabrication records (e.g., planning sheets, routers, etc.,)
 - Nonconforming material disposition
 - Procurement documents (supplier placed orders)
 - Process control records (used as acceptance criteria)
 - Radiographs, technique sheets and related acceptance reports
 - Receiving inspection Records (e.g., test reports and material certifications, etc.,)
- (2) Retain Quality Management System (QMS) records as identified per AS9100. The following identified quality records shall be maintained for the minimum retention periods specified below.
- 40 years from time of manufacture for:

Flight safety, Space Shuttle fuel cells, critical / major rotor parts (i.e., turbine and compressor disks, hubs, shafts, free turbine couplings and turbine disk side plates), serialized major engine (cast / fabricated) cases (i.e., inlet, fan, compressor, intermediate, diffuser, combustion, turbine and exhaust cases) and main shaft bearing supports, which are not integral to a major case.
 - 30 years for Manned Space Program Hardware
 - 10 years for all other parts except off-the-shelf industry standard parts.
 - 4 years for off-the-shelf / industry standard parts (e.g., AN, AS, MS, JAN, etc.).
- (3) Radiographs: The Supplier shall retain radiographs.
- 40 Years for:

Flight safety, Critical / major rotor parts (i.e., turbine and compressor disks, hubs, shafts, free turbine couplings and turbine disk side plates), Space Shuttle fuel cells as well as serialized major engine (cast / fabricated) cases, (i.e., inlet fan, compressor, intermediate, diffuser, combustion, turbine and exhaust cases), and main shaft bearing supports which are not integral to a major case and engine components traceable by Engineering Drawing / Quality Assurance Data required serial numbers.

- 10 Years for:
 - Castings or parts where the purchase order, engineering drawing or specifications require serial number traceability.
 - Castings or parts where the purchase order, engineering drawing or specifications do not require serial number traceability, shall be retained only if no other inspection record is retained that documents completion and final acceptance of radiographic inspection.
- 5 Years for:
 - Military hardware – turbine airfoil (blades) casting radiographs for initial casting quality.
 - Military hardware – Radiographs of airfoils for the presence of foreign material need not be retained provided an inspection record is retained that documents completion and final acceptance of radiographic inspection.

4.3 Configuration Management: No Additional Requirements

5. MANAGEMENT RESPONSIBILITY:

- 5.1 Management Commitment: No Additional Requirements
- 5.2 Customer Focus: No Additional Requirements
- 5.3 Quality Policy: No Additional Requirements
- 5.4 Planning: No Additional Requirements
- 5.5 Responsibility, Authority and Communication: No Additional Requirements
- 5.6 Management Review: No Additional Requirements

6. RESOURCE MANAGEMENT:

- 6.1 Provision of Resources: No Additional Requirements
- 6.2 Human Resources:
 - 6.2.1 General: No Additional Requirements
 - 6.2.2 Competence, Awareness and Training:
 - (a) Unless otherwise specified, procedures shall be implemented to ensure that eye examinations, including visual acuity and color vision, as applicable, are administered by a medically qualified/trained person to all individuals performing visual inspection.

- Intervals shall not exceed one year.
- Individuals shall be tested in at least one eye, either corrected or uncorrected.
- Color Perception testing is required one time only. Individuals shall be capable of adequately distinguishing and differentiating colors used in the method for which certification is required, the process being performed or inspection activity. Documentation shall be retained.
- Records shall be retained for each individual.
 - (1) Individuals performing visual inspection (i.e. calibration, non-weld, in-process, layout, dimensional) shall be compliant with near vision requirements of Snellen 14/18, (20/25), Jaegar 2 at 14 inches, or Ortho-Rater 8.
 - (2) Individuals performing visual inspections on welds shall be compliant with the American Welding Society Standard (AWS) D17.1.
 - (3) Individuals performing nondestructive testing (NDT) shall be compliant with Aerospace Industries Association National Aerospace Standard (AIA/NAS) 410

Note: *Vision tests may be substituted for the options listed above providing the equivalence is verified and documented by a licensed optometrist.*

(b) through (e) No Additional Requirements

6.3 Infrastructure: No Additional Requirements

6.4 Work Environment: No Additional Requirements

7. PRODUCT REALIZATION:

7.1 Planning of Product Realization: No Additional Requirements

7.2 Customer-Related Processes:

7.2.1 Determination of Requirements Related to the Product: No Additional Requirements

7.2.2 Review of Requirements Related to the Product:

- (a) Verbal agreements or instructions shall under no circumstances be construed as approval or authorization to proceed.

(b) through (d) No Additional Requirements

7.2.3 Customer Communication:

(a) Changes that may affect quality must be documented and communicated to the applicable UTC member(s) Quality Assurance and/or Purchasing Representative prior to effectivity of the change.

EXAMPLE OF CHANGES

Ownership
Manufacturing location
Process
Product
Inspection Techniques

(b) Supplier Request for Information (SRI), [ASQR-01 Form 3](#), is available as a formal communication process, which is submitted to applicable Procurement personnel.

SRI's may be used for items such as:

- An anomaly noted in a drawing or specification that could result in a nonconformance.
- For clarification / interpretation of a drawing or specification not requiring formal approval or affecting contractual requirements.
- A request for an alternate method to a quality system requirement. Any alternate methods to a quality system requirement must receive approval from the applicable UTC member prior to incorporation.

Note: *SRI's are not used for processing product nonconformances or altering contractual requirements.*

(c) All communications between the supplier and the UTC member must be written in the English language. These communications include:

- Quality Systems Manual and Procedures
 - Process documentation which requires approval or source qualification by the UTC member.
- (1) In cases where the supplier maintains copies in their native language as well as in English and there is a conflict, the English language document shall take precedence.
- (2) Provide UTC members Supplier Quality Assurance with a company owned e-mail address to permit communications with

the suppliers quality department. The e-mail address and any changes shall be sent to the applicable UTC member Supplier Quality Assurance (SQA) organization.

7.3 Design and Development: No Additional Requirements

7.4 Purchasing:

7.4.1 Purchasing Process:

(a) through (c) No Additional Requirements

(d) When specified on the drawing or purchase order, suppliers must use only sources approved by the specific UTC member company to perform special processes (each special process supplier must obtain initial approval from each specific UTC member company).

Note: *The use of directed sources does not relieve the responsibility for subcontractor control (i.e., an approved source for Non-Destructive Testing, Plating, Coating, etc.).*

(e) No Additional Requirements

7.4.2 Purchasing Information:

(a) through (i) No Additional Requirements

(j) Where a UTC member owns the design of an article purchased from a supplier (first-tier) who further subcontracts all or portions of that work to other subcontractors (second-tier), the first-tier supplier's purchase order must state that the articles are for applicable UTC member's "end use" and must be controlled per applicable purchase order requirements.

7.4.3 Verification of Purchased Product:

(a) Suppliers must provide raw materials test reports / certification results / laboratory analysis requirements (e.g., tensile strength, stress rupture, hardness, chemical composition, etc.), as defined by the product definition and/or the purchase order.

(b) through (e) No Additional Requirements

Upon receipt of a UTC member purchase order requiring Government oversight (e.g., Government Contract Quality Assurance (GCQA), Department of Energy, (DOE), etc.) notify the Government Representative who services your facility or if there is none, the Government Inspection office nearest to your facility.

7.5 Production and Service Provision:

7.5.1 Control of Production and Service Provision:

(a)

(1) Flight Safety Parts: The requirements and definition for Flight Safety Parts are contained in [ASQR-09.1](#) and applies when invoked by purchase order.

(2) Process Certification: Suppliers shall implement Process Certification per the requirements contained in [UTCQR-09.1](#).

(b) through (e) No Additional Requirements

(f) Product identified with UTC member acceptance symbols can only be shipped to the UTC member or a UTC member approved destination.

(g) through (k) No Additional Requirements

7.5.1.1 Production Documentation: No Additional Requirements

7.5.1.2 Control of Production Process Changes: No Additional Requirements

7.5.1.3 Control of Production Equipment, Tools and Numerical Control (NC) Machine Programs:

Suppliers shall, for control of software, implement requirements per [ASQR-07.5](#).

7.5.1.4 Control of Work Transferred, on a Temporary Basis, Outside the Organization's Facilities: No Additional Requirements

7.5.1.5 Control of Service Operations: No Additional Requirements

7.5.2 Validation of Processes for Production and Service Provision:

(a) Suppliers shall use UTC member approved suppliers when a specific material or manufacturing special process is identified by individual UTC members.

(1) Only UTC member approved Special Process suppliers can be used.

(2) Special Process suppliers must be Nadcap accredited or have NUCAP (Nadcap Users Compliance and Audit Program) approval.

(b) through (e) No Additional Requirements

7.5.3 Identification and Traceability: No Additional Requirements

7.5.4 Customer Property:

Return all documents, records, gaging, stamps, or other customer supplied product upon written notification from UTC member or when business with the UTC member has ceased.

7.5.5 Preservation of Product:

The requirements for Handling, Storage, Packaging, Preservation and Delivery are contained in [ASQR-15.1](#).

7.6 Control of Monitoring and Measuring Devices:

Calibration Systems shall meet the applicable requirements of ISO 10012, ISO 17025 or ANSI/NCSL Z540-1.

If ANSI/NCSL Z540 is applicable, the Handbook shall be used as the interpretive guide.

(a) In accordance with the industry standards and guidance referenced above, stated reliability goals, accuracy ratios and Significant-Out-Of-Tolerance condition criteria must be established.

(1) The Calibration interval analysis methodology used to maintain the reliability of M&TE, shall have a stated reliability goal to meet a minimum 95% reliability target for M&TE in-tolerance at the end of their interval schedule.

(2) Significant-Out-Of-Tolerance conditions are defined as any M&TE out-of-tolerance condition exceeding 25% of the product tolerance. These conditions require documented review of impact on quality and notification to the UTC member if product received by UTC has been affected.

(b) through (f) No Additional Requirements

8. MEASUREMENT, ANALYSIS and IMPROVEMENT:

8.1 General: No Additional Requirements

8.2 Monitoring and Measurement:

8.2.1 Customer Satisfaction: No Additional Requirements

8.2.2 Internal Audit:

Audits of the entire Quality Management System must be conducted annually. Alternate plans may be accepted by the UTC members.

(a) and (b) No Additional Requirements

8.2.3 Monitoring and Measurement of Processes: No Additional Requirements

8.2.4 Monitoring and Measurement of Product:

- (1) Statistical Techniques: Provide for inspection of articles/characteristics per [ASQR-20.1](#).
- (2) The use of an operator certification program or other special manufacturing methodologies (e.g. manufacturing controlling features, die/mold control, method of manufacturing, etc.) must be approved prior to implementation by the appropriate UTC member via [ASQR-01 Form 3](#).
- (3) The supplier shall generally select measuring and test equipment (M&TE) with an accuracy ratio of 10 to 1 (product tolerance to M&TE tolerance) however, accuracy ratios as low as 4 to 1 are acceptable, unless otherwise specified. Use of M&TE with accuracy ratios less than 4 to 1 are not permitted unless a detailed measurement uncertainty analysis in accordance with ANSI/NCSS Z540-2 indicates an uncertainty ratio of 1.5 to 1, or better, and the measurement process is maintained under statistical quality control.

8.2.4.1 Inspection Documentation:

(a) and (b) No Additional Requirements

(c) When functional performance / test data is required, include the following minimum requirements:

- Test specification number, revision status, amendment number and addendum.
- Part number / serial number and revision letter of material / component being tested.
- Test paragraph, required reading, actual reading (use positive statement, e.g., "No Leakage" if actual reading is not quantifiable).
- Date test was performed.
- Operator identification.
- Inspection approval signature / stamp.
- Blank entries that are not applicable shall be noted "N/A".

(d) No Additional Requirements

8.2.4.2 First Article Inspection:

First Article Inspections (FAI) shall be performed in accordance with SAE AS 9102 and the additional requirements below.

- A replication of product part marking (via photograph or sample) that represents production marking must be included within the FAI Report.
- The Supplier holding the UTC member purchase order is responsible for assuring completion of the FAI Report for all finished part characteristics generated by Sub-tier Suppliers.
- At any time, a UTC member may request a complete FAI to be performed in lieu of a partial (delta) FAI.
- Additional requirements for AS 9102 FAI Form 1:
Field 11, Supplier Code:
 - Record UTC Member assigned Supplier Code.Field 12, P.O. Number:
 - Record UTC Member Purchase Order Number.
- Additional requirements for AS 9102 FAI Form 3:
Field 14, For each characteristic:
 - Record FAI Inspection Measuring Equipment used as a media of inspection. Record FAI inspector identification (e.g., signature, stamp, electronic authorization, etc.) used to signify the person that accomplished the inspection.

8.3 Control of Nonconforming Product:

- (a) No Additional Requirements
- (b) Suppliers shall coordinate all reports of nonconformances for UTC member supplied material in accordance with the applicable UTC member's requirements.
- (c) Articles deemed scrap must be clearly identified and rendered unusable within 30 days of final disposition unless otherwise instructed, in writing, by the applicable UTC member.

The cognizant UTC member must be informed immediately (not to exceed 24 hours or the next business day) of suspect nonconforming product shipped regardless of destination. Method of notification is determined per applicable UTC member requirements.

Ensure that related characteristics which may be affected by rework or repair operations are identified and reinspected after these operations are performed.

8.4 Analysis of Data: No Additional Requirements

8.5 Improvement:

8.5.1 Continuous Improvement: No Additional Requirements

8.5.2 Corrective Action:

(a) through (c) No Additional Requirements

(d) When requested to provide corrective action, prepare a report documenting the occurrence, findings, and assessment of the affected product and submit to the applicable UTC member. Provide objective evidence of relentless root cause analysis and implementation of corrective action that eliminates risk of reoccurrence.

(e) To ensure effectiveness of the corrective action, suppliers shall perform 100% inspection of the deviated characteristics for the next (3) three consecutive manufactured lots.

(f) through (h) No Additional Requirements

8.5.3 Preventive Action: No Additional Requirements

***** End of Document *****