

14153 QAP-CSI003121138
DTD 31 DEC 08

**DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION**

**NSN: 5315-00-312-1138
P/N: 68A450649-2001**

This Quality Assurance Provision (**QAP**) is to be used in conjunction with any orders/contracts for the cited **NSN**

FURNISH THE COGNIZANT ENGINEERING ACTIVITY WITH THE FOLLOWING INFORMATION ON THE PREVIOUSLY SUPPLIED ARTICLE:

A. PROCURING OFFICE B. CONTRACT NUMBER C. DATE OF CONTRACT D. SPECIFICATION NUMBER AND REVISION

12. REMARKS

NAME Blommer, Michael J

DATE 16 DEC 2008

The critical nature of the part requires a first article from a contractor who has never produced the item or has not produced the item for an extended period of time. The Government reserves the right to assure all materials and process certifications are correct and to test the item to any or all drawings, specifications and other contract requirements. A vendor will normally be allowed only one attempt to receive full or conditional approval. Failure to receive approval of First Article inspection will, at the discretion of the Government, result in termination of the contract. The contractor shall produce a report on the subject item with all dimensions and tolerances specified on the manufacturing data listed in one column and the actual corresponding reading obtained from the inspection of the part listed in another column. Materials utilized in the manufacture of First Article items shall be identified and certified along with a copy of material purchase requests as conforming to applicable data requirements. Material processing, including finish requirements-plating, casting, forging, heat treatment, welding, inspecting, anodize, painting, etc-utilized in the manufacture of First Article items shall be identified and certified along with a copy of material purchase requests as conforming to applicable data requirements. A copy of the purchase order certifying the process accomplished at other than the contractor's facility shall be included.

Mike Blommer
F-15 Landing Gear Engineer
801/777-6338

13. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING AND/OR APPROVING TEST (*Name, Organization, Phone*)

14. PR INITIATOR (*Name, Organization, Phone*)

REV:	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")	
<i>NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.</i>		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF: PIN, JURY BRACE, ATTACHMENT - NOSE LANDING GEAR		
2. PART NUMBER: 68A450649-2001	3. NATIONAL STOCK NUMBER: 5315-00-312-1138SX	

4. THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC. WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.

5. 417 SCMS/GUEB ENGINEERING RETAINS ALL RIGHTS TO REVIEW AND ACCEPT MATERIAL REVIEW BOARD (MRB'S) DISPOSITIONS PRIOR TO SHIPMENT OF DISCREPANT ITEM. ALL DEVIATIONS, MINOR AND MAJOR, FROM THE ENGINEERING DRAWING PACKAGE SHALL BE SUBMITTED FOR MRB DISPOSITION.

6. PRIOR TO CONTRACT AWARD, THE CONTRACTOR SHALL CERTIFY TO THE GOVERNMENT IN WRITING FULL COMPLIANCE WITH MANUALS, SPECIFICATIONS, AND STANDARDS CALLED OUT AND REQUIRED FOR THE MANUFACTURE OF THIS CONTRACTED LANDING GEAR COMPONENT/ASSEMBLY. CONTRACTOR IS RESPONSIBLE TO COMPLETELY SEARCH THESE MANUAL, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO 417 SCMS/GUEB ENGINEERING.

7. DIMENSIONING AND TOLERANCING PER ASME Y14.5 IN LIEU OF USASI Y14.5.

8. CLEANLINESS PER SAE AMS 2300 IN LIEU OF AMS 2300.

9. HEAT TREAT TO 280,000 TO 300,000 PSI PER SAE AMS-H-6875 IN LIEU OF PS15296.

10. ON PARTS HEAT TREATED 180 KSI AND ABOVE, ANY SURFACES GROUND/MACHINED AFTER HEAT TREAT WILL BE INSPECTED FOR BURNS PER MIL-STD-867 IN LIEU OF PS21205. NO MORE THAN THREE SUCCESSIVE INSPECTIONS SHALL BE PERFORMED WITHOUT A WAIVER FROM 417 SCMS/GUEB ENGINEERING. GRINDING WILL BE PER MIL-STD-866.

11. STRESS RELIEVE PER SAE AMS-2759 AND 2759/11 IN LIEU OF PS15063.

12. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF PS21201. USE FLUORESCENT TYPE, FULL WAVE DIRECT CURRENT (FWDC), AND WET CONTINUOUS METHOD WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO RELEVANT DEFECTS ALLOWED. THE INTENT OF NO RELEVANT DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO RELEVANT INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTIONS SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN AIA/NAS NAS 410.

13. UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130 IN LIEU OF PS16001. THE UID SHALL BE BOTH HUMAN READABLE INFORMATION (HRI) MARKINGS AND MACHINE-READABLE INFORMATION (MRI) MARKINGS. THE HRI SHALL INCLUDE BOTH THE PART NUMBER AND THE SERIAL NUMBER. THE SERIAL NUMBER SHALL BE LIMITED TO 16 ALPHANUMERIC CHARACTERS INCLUDING THE VENDOR CAGE (FSCM) OF THE CONTRACTOR NAMED ON THE CONTRACT, DATE OF MANUFACTURE IN THE FORMAT MMY, AND A UNIQUE 4-DIGIT NUMBER STARTING WITH 0001 IN NUMERICAL ORDER OF MANUFACTURE. THE SERIAL NUMBER SHALL APPEAR AS "SN 9874701040001". THE SERIAL NUMBER SHALL BE MARKED ON THE PART IN THE LOCATION IDENTIFIED BY THE DRAWING. THE HEIGHT OF EACH ALPHANUMERIC CHARACTER IN THE SERIAL NUMBER SHALL BE A MAXIMUM OF .125 INCHES. THE METHOD OF MARKING FOR THE SERIAL NUMBER SHALL BE LIMITED TO ELECTRO-CHEMICAL ETCHING, DOT PEEN, VIBRO PEEN, OR MICRO-MILL. THE DEPTH OF EACH MARK SHALL BE FROM .003 - .005 INCHES UNLESS OTHERWISE SPECIFIED ON THE ORIGINAL DRAWING. THE FULL DETAILED UID MARKING REQUIREMENTS, INCLUDING THE HRI AND MRI, SHALL BE APPLIED TO A SUPPLEMENTAL BAG OR OTHER PACKAGE THAT ENCLOSES THE INDIVIDUAL ITEM. THE MRI MARK SHALL CONTAIN HRI EQUIVALENT INFORMATION IN BOTH 2D MATRIX FORM AND IN HUMAN READABLE FORM.

14. CHROMIUM PLATE PER MIL-STD-1501 TYPE II CLASS 2 IN LIEU OF PS13102. THE MAXIMUM ALLOWABLE DELAY FOR THE 4 HOUR BAKE BETWEEN CHROMIUM PLATE AND CADMIUM PLATE OPERATIONS AS REFERENCED IN MIL-STD-1501 SHALL BE 4 HOURS.

15. FINISH ASSEMBLY PER THE FOLLOWING IN LIEU OF NOTE 22 (TO BE APPLIED IN THE LOCATIONS IDENTIFIED BY FLAG NOTE 22):

A. APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582 TYPE I CLASS C2 OR N. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377 TYPE I CLASS C2 OR N (MIL-P-23377).

B. APPLY TWO TOPCOATS POLYURETHANE PER MIL-PRF-85285 TYPE I CLASS H COLOR NUMBER 17925 (WHITE) PER FED-STD-595 (MIL-C-83286 COLOR NUMBER 17875).

PREPARED BY: MICHAEL BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20081216
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REV:	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")	
NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF: PIN, JURY BRACE, ATTACHMENT - NOSE LANDING GEAR		
2. PART NUMBER: 68A450649-2001	3. NATIONAL STOCK NUMBER: 5315-00-312-1138SX	

16. SHOT PEEN PER SAE AMS 2430 IN LIEU OF PS 14023. SHOT PEEN INTENSITY, COVERAGE, AND SHOT SIZE SHALL BE AS SPECIFIED ON THE DRAWING. USE HARD STEEL SHOT IN THE RANGE 55-65 HRC (PER SAE AMS 2431/2 OR 2431/8), OR CERAMIC SHOT WITH A HARDNESS COMPARABLE TO 57-63 HRC (PER SAE AMS 2431/7).

17. CADMIUM PLATE PER MIL-STD-870 TYPE II CLASS 2 IN LIEU OF PS13144.

18. USE 300M STEEL MATERIAL PER SAE AMS 6419 IN LIEU OF AMS 6419.

19. 68A900000 AND CPC1850A100 ARE NOT REQUIRED FOR MANUFACTURE AND WILL NOT BE PROVIDED.

20. THE FOLLOWING FEATURES AND PROCESSES ARE SAFETY CRITICAL. THE PROCESSES REFERENCED MUST COMPLY STRICTLY WITH THE SPECIFICATIONS REQUIRED BY CONTRACT.

DRAWING 68A450649PL

SHEET 1:

ADD CSI TO NOTES 12, 13, 15, 16, AND 20

SHEET 2:

ADD CSI TO NOTES 23 AND 24

CSI MATERIAL 300M PER AMS 6419

PREPARED BY: MICHAEL BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20081216
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ENGINEERING DATA LIST										*HISTORY*	
REVISION: 2		DATA TECH: Cope, Charles R		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABB		END ITEM: F-15		PAGE 1 OF 2			
CAGE: 76301		MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION A WHO		REFERENCE NUMBER: 68A450649-2001		NOUN: PIN, JURY BRACE		NSN: 5315003121138SX			
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS	NAME: W/PARTS LIST & EO 030747	DATE:	
L	76301	68A450649	A		S		PIN, JURY BRACE ATTACHMENT - NLG		Cope, Charles R	29 DEC 2008	
L	98747	HILL AFB FORM 462			X		ENGR DATA RQMTS (ATTACHMENT A)				
L	76301	PS23041	U		S		MACHINED PARTS ACCEPTANCE CRITERIA		Cope, Charles R	29 DEC 2008	
L	76301	PS20018	F		S		SURFACE FINISH FOR ROUND HOLES		Cope, Charles R	29 DEC 2008	
STANDARD ENGINEERING TEXT											

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REVISION: 2			ENGINEERING DATA LIST		*HISTORY*	
DATE: 29 DEC 2008	DATA TECH: Cope, Charles R	ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABB	END ITEM: F-15	PAGE 2 OF 2		
CAGE: 76301	MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION A WHO	REFERENCE NUMBER: 68A450649-2001	NOUN: PINJURY BRACE	NSN: 5315003121138SX		
FURNISHED METHOD CODE LEGEND:			<p>C - CLASSIFIED DOCUMENT. S - FURNISHED WITH SOLICITATION. M - STABLE BASE DRAWING REQUIRED; FURNISHED WITH CONTRACT AWARD.</p>			
			<p>X - DATA SUPPLIED (NOT IN JEDMICS). R - FURNISHED BY PCO UPON REQUEST. P - PARTIAL DOCUMENT FURNISHED. V - VENDOR DRAWING; (NOT PROVIDED).</p>			
			<p>G - GOV'T DOCUMENT. O - OTHERS, CONTRACTOR MUST ACQUIRE. A - DATA NOT AVAILABLE.</p>			

AMC/AMSC SCREENING ANALYSIS WORKSHEET REPORT					PRIORITY CATEGORY			
					02			
ITEM IDENTIFICATION AND INFORMATION								
NSN 5315003121138SX		NOUN PIN,JURY BRACE			END ITEM F-15		PCC	BRRC N
QUANTITY	UNIT COST	IDENTIFYING NUMBER (Part No)			CAGE	TOP DWG REV NO.		
1	\$296.3300	R/N 68A450649-2001			76301			
EST ANNUAL BUY VALUE \$296.33				COMM OFF-THE-SHELF ITEM YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN				
NUC. CERT. END ITEM YES <input checked="" type="checkbox"/> NO UNKNOWN			HARD CRIT. IND YES <input checked="" type="checkbox"/> NO UNKNOWN					
NEXT HIGHER ASSEMBLY								
NSN		NOUN			R/N		CAGE	
SUMMARY OF SCREENING ACTION								
DESIGN DISCLOSURE <input checked="" type="checkbox"/>		SPEC CONTROL		SOURCE CONTROL		MIL/IND/CONTR PERF SPEC		
ST/STE REQUIRED YES <input checked="" type="checkbox"/> NO UNKNOWN		ST/STE AVAILABLE YES <input checked="" type="checkbox"/> NO UNKNOWN		DATA COMPLETE <input checked="" type="checkbox"/> YES NO UNKNOWN		DATA RIGHTS LIMITED YES <input checked="" type="checkbox"/> NO UNKNOWN		AAC D
AMC/AMSC 2 / C		AMC/AMSC EXP DT 16 DEC 2011		PRV AMC/AMSC /		PRV AMC/AMSC EXP DT		
AMC COMPLETION DT 22 DEC 2008				ENGINEER AMC/AMSC 2 / C				
USER TYPE	DATE/TIME IN	DATE/TIME OUT	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE		
Engineer	16 DEC 2008 / 2058	22 DEC 2008 / 1428	Blommer, Michael J	417 SCMS / GUBB	801-777-6338	777-6338		
Screening Technician	03 DEC 2008 / 1847	16 DEC 2008 / 2058	Cope, Charles R	418 SCMS / GULABB	801-777-6611	777-6611		
Screening Technician Workload Manager	03 DEC 2008 / 1844	03 DEC 2008 / 1847	Hyatt, Joan E	418 SCMS / GULABB	801-777-3544	777-3544		
PROCUREMENT SUPPORT REQUIRED								
FIRST ARTICLE TEST <input checked="" type="checkbox"/> YES NO			ENGINEERING DATA LIST REQ <input checked="" type="checkbox"/> YES NO			EXPORT CONTROLLED <input checked="" type="checkbox"/> YES NO		
PRODUCTION SAMPLE REQ YES <input checked="" type="checkbox"/> NO		MLO/ARTWORK Not required			PROD SAMPLE FURN YES <input checked="" type="checkbox"/> NO		ENGR NOTES <input checked="" type="checkbox"/> YES NO	
APPROVED SOURCES								
DESIGN ACTIVITY INFORMATION								
CAGE	REFERENCE NUMBER	CONTRACTOR NAME	RNCC / RNVC	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE	
76301	68A450649-2001	MCDONNELL DOUGLAS CORPORATION	3 / 2	Cope, Charles R	418 SCMS / GULABB	801-777-6611	777-6611	

SUPPLIER INFORMATION

