

14153 QAP-CSI003291614  
DTD 31 DEC 08

**DEFENSE SUPPLY CENTER PHILADELPHIA  
QUALITY ASSURANCE PROVISION**

**NSN: 5306-00-329-1614  
P/N: 68A450625-2001**

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

<b>FIRST ARTICLE REQUIREMENTS</b> <i>(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)</i>			1. DATE 12 DEC 2008
2. PR/MIPR NUMBER	3. PART NUMBER 68A450625-2001	4. NSN 5306003291614SX	
5. FIRST ARTICLE QUANTITY THE FIRST ARTICLE IS <u>1</u> UNIT(S) OF LOT/ITEM <u>EA</u> AND WILL BE: PART OF PRODUCTION QUANTITY <input type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY <input checked="" type="checkbox"/>			
6. ARTICLES WILL <input checked="" type="checkbox"/> WILL NOT <input type="checkbox"/> SERVE AS A MANUFACTURING		7. LONG LEAD TIME ITEMS <input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED <i>(See FAR 52.209-3 OR -4, alternate II)</i>	
8. SPECIAL REQUIREMENT/PRODUCTION FACILITIES <i>(See FAR 52.209-3 OR -4 Alternate I)</i> <input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED  "The First Article offered must be manufactured at the facilities in which that item is to be produced under the contract, or if the First Article is a component not manufactured by the contractor, such component must be manufactured at the facilities in which the component is to be produced for the contract. A certification to this effect must accompany each First Article which is offered."			
9. TEST/INSPECTION REQUIREMENTS			
A. CONTRACTOR TESTING <input type="checkbox"/> GOVERNMENT TESTING <input checked="" type="checkbox"/> Performance or other characteristics which the First Articles must meet are <u>conformance with all dwgs and specs in the contract.</u>			
B. The detailed technical requirements for First Article approval tests are contained in <u>all the drawings and specifications in the contract.</u> <i>(Cite Spec and Para number)</i>			
C. TEST PLAN REQUIRED			
(1) DD Form 1423 ELIN _____			
(2) Delivery due _____ calendar days from date of contract.			
(3) Number of days for government approval/disapproval _____ days.			
D. Contractor's notification to ACO and <u>OO-ALC/MADLV</u> <i>(Requesting Activity)</i> of test time and location due <u>30</u> days prior to start of testing.			
E. TEST REPORT REQUIRED			
(1) DD Form 1423 ELIN _____			
(2) Due _____ calendar days from date of contract.			
(3) Forwarded to _____ _____ _____			
(4) Government written notice of approval/disapproval due _____ days after receipt of contractor's report.			
F. FIRST ARTICLE DELIVERY			



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      12 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")	
NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF: BOLT, UPPER STEERING ATTACH NLG                      F-15		
2. PART NUMBER: 68A450625-2001	3. NATIONAL STOCK NUMBER: 5306-00-329-1614 LE	

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 RETAINS ALL RIGHTS TO REVIEW AND ACCEPT MATERIAL REVIEW BOARD (MRB) 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 MANUALS, SPECIFICATIONS AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO 417 SCMS/GUEB.

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

8. SURFACE ROUGHNESS PER ASME B46.1 IN LIEU OF PS20018.

9. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF PS15033.

10. ON PARTS HEAT TREATED TO 180 KSI AND ABOVE, ANY SURFACES GROUND/MACHINED AFTER HEAT TREAT WILL BE INSPECTED FOR BURNS PER MIL-STD-867. NO MORE THAN THREE SUCCESSIVE INSPECTIONS SHALL BE PERFORMED WITHOUT A WAIVER FROM 417 SCMS/GUEB. 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. MARKING AND IDENTIFICATION SHALL BE PER MIL-STD-130 IN LIEU OF PS16001. BOTH PART NUMBER AND SERIAL NUMBER SHALL BE MARKED ON THE PART IN THE LOCATION SHOWN ON THE DRAWING. 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 HEIGHT OF EACH ALPHANUMERIC CHARACTER SHALL BE A MAXIMUM OF .125 INCHES. THE METHOD OF MARKING 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.

14. THREADS PER SAE AS 8879 IN LIEU OF MIL-S-7742.

PREPARED BY: MIKE BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 12 DEC 2008
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REV:	<b>ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")</b>	
<i>NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.</i>		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF: BOLT, UPPER STEERING ATTACH NLG                      F-15		
2. PART NUMBER: 68A450625-2001	3. NATIONAL STOCK NUMBER: 5306-00-329-1614 LE	

15. SHOT PEEN PER SAE AMS 2430 IN LIEU OF PS14023. SHOT PEENING INTENSITY, COVERAGE, AND SHOT SIZE SHALL BE AS SPECIFIED BY THE DRAWING. EXCEPT FOR THE THREADS, 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). FOR THE THREADS, GLASS BEAD PEEN, INTENSITY OF .004 - .008A.

16. CADMIUM PLATE PER MIL-STD-870 TYPE II CLASS 2 IN LIEU OF VACUUM CADMIUM PLATE PER PS13145.

17. FINISH PER THE FOLLOWING IN LIEU OF NOTE 18:

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 IN LIEU OF MIL-P-23377.

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

18. FOR MATERIAL USE 4340 STEEL PER SAE AMS 6484 IN LIEU OF MIL-S-5000.

19. 68A900000 AND 40M114 ARE NOT REQUIRED FOR MANUFACTURE AND WILL NOT BE PROVIDED.

PREPARED BY: MIKE BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 12 DEC 2008
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REVISION: 2

**ENGINEERING DATA LIST**

\*HISTORY\*

DATE:	DATA TECH:	ORGANIZATION/OFFICE SYMBOL:	END ITEM:	PAGE
12 DEC 2008	Gonsor, Thomas P	418 SCMS / CULABB	F-15	1 OF 1

CAGE:	MANUFACTURER NAME:	REFERENCE NUMBER:	NSN:
76301	MCDONNELL DOUGLAS CORPORATION A WHO	68A450625-2001	5306003291614SX

LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS	DATE:
L	76301	68A450625	B		S		BOLT, UPPER STEERING ATTACH, NLG	NAME: Gonsor, Thomas P W/PARTS LIST	12 DEC 2008
L	76301	PS23041	U		S		MACHINED PARTS ROMTS, ACCEPTANCE CRITERIA		
L	98747	HILL AFB FORM 462			X		ENGINEERING DATA REQUIREMENTS (ATTACHMENT A)		

STANDARD ENGINEERING TEXT

FURNISHED METHOD CODE LEGEND:

C - CLASSIFIED DOCUMENT.  
S - FURNISHED WITH SOLICITATION.  
M - STABLE BASE DRAWING REQUIRED;  
FURNISHED WITH CONTRACT AWARD.

X - DATA SUPPLIED (NOT IN JEDMICS).  
R - FURNISHED BY PCO UPON REQUEST.  
P - PARTIAL DOCUMENT FURNISHED.  
V - VENDOR DRAWING;  
(NOT PROVIDED).

G - GOVT DOCUMENT.  
O - OTHERS, CONTRACTOR  
MUST ACQUIRE.  
A - DATA NOT  
AVAILABLE.

AMC/AMSC SCREENING ANALYSIS WORKSHEET REPORT					PRIORITY CATEGORY		
					02		
ITEM IDENTIFICATION AND INFORMATION							
NSN 5306003291614SX		NOUN BOLT, INTERNALLY REL		END ITEM F-15		PCC	ERRC N
QUANTITY 1	UNIT COST \$65.0800	IDENTIFYING NUMBER (Part No) R/N 68A450625-2001			CAGE 76301	TOP DWG REV NO.	
EST ANNUAL BUY VALUE \$65.08				COMM OFF-THE-SHELF ITEM YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN			
NUC. CERT. END ITEM YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN			HARD CRIT. IND YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> 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 / G		AMC/AMSC EXP DT 12 NOV 2013		PRV AMC/AMSC /	PRV AMC/AMSC EXP DT		
AMC COMPLETION DT 12 DEC 2008				ENGINEER AMC/AMSC 2 / G			
USER TYPE	DATE/TIME IN	DATE/TIME OUT	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE	
Engineer	14 NOV 2008 / 1953	12 DEC 2008 / 1950	Blommer, Michael J	417 SCMS / GUEB	801-777-6338	777-6338	
Screening Technician	06 NOV 2008 / 2121	14 NOV 2008 / 1953	Dalton, Thomas T	418 SCMS / GULABA	801-586-0915	586-0915	
Screening Technician Workload Manager	06 NOV 2008 / 2120	06 NOV 2008 / 2121	Siegel, Richard W	418 SCMS / GULABB	801-777-3509	777-3509	
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	68A450625-2001	MCDONNELL DOUGLAS CORPORATION	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915
SUPPLIER INFORMATION							

SUPPLIER INFORMATION								
SOURCE TYPE	CAGE	REFERENCE NUMBER	CONTRACTOR NAME	RNCC / RNVC	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE
D	76301	68A450625-2001	MCDONNELL DOUGLAS CORPORATION	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915
SCREENING/EVALUATION/REMARKS								
JUSTIFICATION FOR SUFFIX CODE OTHER THAN G								
ACTION TAKEN/BEING TAKEN TO IMPROVE COMPETITIVE STATUS								
REMARKS NAME Dalton, Thomas T                      DATE 12 NOV 2008 A CATALOGING REQUEST CHANGE WAS SENT TO MIKE BLOMMER TO CHANGE THE MMAC CODE FROM SX TO LE AND THE MOE CODE FROM FXGI TO FUGG.								
MISCELLANEOUS INFORMATION								
BUY HISTORY ( <i>Last 5 Buys</i> )								
AWARD DATE	CONTRACT NUMBER	UNIT PRICE	SUPPLIER CAGE	SUPPLIER REFERENCE NUMBER	AMC/AMSC	AMOC	PLT	TERM IND
06 JUN 1977	F4160877M6512	\$40.2500	13002	68A450625-2001	/	3	0171	
POTENTIAL SOURCES								
DESIGN ACTIVITY INFORMATION								
SOURCE TYPE	CAGE	REFERENCE NUMBER	CONTRACTOR NAME	RNCC / RNVC	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE
SUPPLIER INFORMATION								
SOURCE TYPE	CAGE	REFERENCE NUMBER	CONTRACTOR NAME	RNCC / RNVC	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE