

14153 QAP-CSI005532130  
DTD 6 JAN 09

**DEFENSE SUPPLY CENTER PHILADELPHIA  
QUALITY ASSURANCE PROVISION**

**NSN: 5315-00-553-2130**

**P/N: 68A450645-2001**

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 15 DEC 2008
2. PR/MIPR NUMBER	3. PART NUMBER 68A450645-2001	4. NSN 5315005532130SX
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

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12. REMARKS

NAME                      Blommer, Michael J                      DATE                      15 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:	<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: PIN, HOLLOW-LOWER STEERING ATTACH. NLG      F-15		
2. PART NUMBER: 68A450645-2001	3. NATIONAL STOCK NUMBER: 5315-00-553-2130	

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.

8. HEAT TREAT TO MEET ALL DRAWING REQUIREMENTS PER SAE AMS-H-6875 IN LIEU OF PS15033.

9. 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.

10. STRESS RELIEVE PER SAE AMS-2759 AND 2759/11 IN LIEU OF PS 15063.

11. 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.

12. MARKING AND IDENTIFICATION SHALL BE PER MIL-STD-130 IN LIEU OF PS16001. MARKING SHALL INCLUDE BOTH PART NUMBER AND 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 MARKING SHALL BE APPLIED TO A SUPPLEMENTAL BAG OR OTHER PACKAGE THAT ENCLOSES THE INDIVIDUAL ITEM.

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

14. FINISH PER THE FOLLOWING IN LIEU OF NOTE 16:

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.

PREPARED BY: MIKE BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 15 DEC 2008
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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, HOLLOW-LOWER STEERING ATTACH. NLG      F-15		
2. PART NUMBER: 68A450645-2001	3. NATIONAL STOCK NUMBER: 5315-00-553-2130	

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. 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).

16. MANUFACTURE FROM 4340 STEEL PER SAE AMS 6484 IN LIEU OF MIL-S-5000.

17. THE FOLLOWING ARE NOT REQUIRED FOR MANUFACTURE OF THIS ITEM AND WILL NOT BE PROVIDED: 40M114, 68A9000000, AND CPC 1850A100.

PREPARED BY: MIKE BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 15 DEC 2008
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AMC/AMSC SCREENING ANALYSIS WORKSHEET REPORT					PRIORITY CATEGORY		
					02		
ITEM IDENTIFICATION AND INFORMATION							
NSN 5315005532130SX		NOUN PIN		END ITEM F-15		PCC	ERRC N
QUANTITY 1	UNIT COST \$150.6800	IDENTIFYING NUMBER (Part No) R/N 68A450645-2001			CAGE 76301	TOP DWG REV NO.	
EST ANNUAL BUY VALUE \$150.68				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 25 NOV 2011		PRV AMC/AMSC /	PRV AMC/AMSC EXP DT		
AMC COMPLETION DT 15 DEC 2008				ENGINEER AMC/AMSC 2 / C			
USER TYPE	DATE/TIME IN	DATE/TIME OUT	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE	
Engineer	15 DEC 2008 / 1546	15 DEC 2008 / 1751	Blommer, Michael J	417 SCMS / GUBB	801-777-6338	777-6338	
Screening Technician	20 NOV 2008 / 1956	15 DEC 2008 / 1546	Dalton, Thomas T	418 SCMS / GULABA	801-586-0915	586-0915	
Screening Technician Workload Manager	20 NOV 2008 / 1956	20 NOV 2008 / 1956	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	68A450645-2001	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
V	13002	68A450645-2001	GOODRICH CORPORATION	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915
V	2B834	68A450645-2001	ESSNER MANUFACTURING L.P.	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915
V	6Z056	68A450645-2001	CM MANUFACTURING INC.	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915
D	76301	68A450645-2001	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								
<p>1. THIS IS A PIN USED ON THE LOWER ATTACHMENT POINT OF THE NLG OF THE F-15 AIRCRAFT.</p> <p>2. THIS PART REQUIRES ENGINEERING SOURCE APPROVAL BY THE DESIGN CONTROL ACTIVITY IN ORDER TO MAINTAIN THE QUALITY OF THE PART. THE STRUCTURAL AND FUNCTIONAL INTEGRITY OF THIS ITEM CAN BE AFFECTED BY INDIVIDUAL MANUFACTURERS PROCESSES AND TECHNIQUES.</p> <p>3. TO ENSURE CONTINUED PRODUCT INTEGRITY OF THE ITEM; PROCUREMENT IS RESTRICTED TO SOURCE(S) LISTED IN THE SUPPLIER INFORMATION SECTION OF THIS DOCUMENT. THESE SOURCES ARE KNOWN TO HAVE THE REQUIRED EXPRIENCE AND CAPABILITY.</p>								
ACTION TAKEN/BEING TAKEN TO IMPROVE COMPETITIVE STATUS								
4. THEREFORE, NEW SOURCES DESIRING TO BECOME APPROVED SOURCES MAY DO SO IAW THE SOURCE QUALIFICATION STATEMENT (REQUIREMENTS) AND SOURCES APPROVED BY THE COGNIZANT SYSTEM ENGINEER.								
REMARKS								
NAME Dalton, Thomas T DATE 25 NOV 2008								
SOURCE QUALIFICATION REQUIREMENTS AVAILABLE, CODE D.								
A REQUEST FOR CATALOGING CHANGE WAS SUBMITTED ON 29 NOV 2008 TO CORRECT THE MMAC AND MOE CODES.								
MISCELLANEOUS INFORMATION								
BUY HISTORY (Last 5 Buys)								
AWARD DATE	CONTRACT NUMBER	UNIT PRICE	SUPPLIER CAGE	SUPPLIER REFERENCE NUMBER	AMC/ AMSC	AMOC	PLT	TERM IND
07 JUN 1976	F3365776C0464	\$46.1300	76301	68A450645-2001	/		0999	
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

ENGINEERING DATA LIST										*HISTORY*	
REVISION: 3		DATA TECH: Dalton, Thomas T		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABA		END ITEM: F-15		PAGE 1 OF 2			
CAGE: 76301		MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION A WHO		REFERENCE NUMBER: 68A450645-2001		NOUN: PIN		NSN: 5315005532130SX			
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS	NAME:	DATE:	
L	76301	68A450645	A		S		PIN, HOLLOW-LOWER STEERING ATTACH, NLG		Dalton, Thomas T W/PARTS LIST	15 DEC 2008	
L	76301	PS25041	U		S		MACHINED PARTS, ACCEPTANCE CRITERIA				
L	76301	PS20018	F		S		SURFACE FINISH REQUIREMENTS FOR ROUND HOLES		Dalton, Thomas T W/ AM'S I, A-159	15 DEC 2008	
L	98747	418 SCMS/GULABB			X		ENGR DATA RQMTS (ATTACH A)				
STANDARD ENGINEERING TEXT											

ENGINEERING DATA LIST			*HISTORY*	
REVISION: 3	DATA TECH: Dalton, Thomas T	ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABA	END ITEM: F-15	PAGE 2 OF 2
DATE: 15 DEC 2008	MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION A WHO	REFERENCE NUMBER: 68A450645-2001	NOUN: PIN	NSN: 5315005532130SX
CAGE: 76301	<p>FURNISHED METHOD CODE LEGEND:</p> <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 - GOVT DOCUMENT.  O - OTHERS, CONTRACTOR  MUST ACQUIRE.  A - DATA NOT  AVAILABLE.</p>			