

14153 QAP-CSI005761845
DTD 18 MAY 09

DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION

NSN: 5310-00-576-1845
P/N 60-6550

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

FIRST ARTICLE REQUIREMENTS		1. DATE
<i>(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)</i>		26 MAY 2009
2. PR/MIPR NUMBER	3. CAGE / REFERENCE NUMBER	4. NSN
	81205 / 60-6550	5310005761845SX
5. FIRST ARTICLE QUANTITY		
THE FIRST ARTICLE IS <u>1</u> UNIT(S) OF LOT/ITEM <u>EA</u>		
AND WILL BE: <input type="checkbox"/> PART OF PRODUCTION QUANTITY <input checked="" type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY		
6. ARTICLES		7. LONG LEAD TIME ITEMS
<input type="checkbox"/> WILL <input checked="" type="checkbox"/> WILL NOT SERVE AS A MANUFACTURING STANDARD		<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. <input type="checkbox"/> CONTRACTOR TESTING <input checked="" type="checkbox"/> GOVERNMENT TESTING		
Performance or other characteristics which the First Articles must meet are <u>conformance with all drawings, specifications, and engineering data requirements.</u>		
B. The detailed technical requirements for First Article approval tests are contained in <u>the specifications included in this contract.</u> <i>(Cite Spec and Para number)</i>		
C. <input type="checkbox"/> TEST PLAN REQUIRED Number of days for government approval/disapproval _____ days.		
D. Contractor's notification to ACO and <u>N/A</u> <i>(Requesting Activity)</i> of test time and location due _____ days prior to start of testing.		
E. <input type="checkbox"/> TEST REPORT REQUIRED (1) Forwarded to _____ _____ _____		
(2) Government written notice of approval/disapproval due _____ days after receipt of contractor's report.		
F. FIRST ARTICLE DELIVERY		
(1) Due within <u>365</u> calendar days from date contract.		
(2) Notify <u>30</u> calendar days prior to shipment.		
(3) Delivered to government at <u>OO-ALC/309 MXSG/MXRILV</u> <u>Bldg 849 Attn: Non-Accountable Bay</u> <u>Transportation Office</u> <u>Hill Air Force Base, UT 84056-5713</u> <i>(Set Forth Consignee and Address)</i>		
(4) Government written notice of approval/disapproval within <u>120</u> days after receipt of first article package.		

G. Estimated cost of government testing/inspection evaluation.

\$1,000.0000

10. DISPOSITION OF FIRST ARTICLES

- Approved First Articles will be forwarded to
Supply
- _____ (insert quantity) First Articles will be expended in testing. Residual components of disapproved First Articles
 - will be returned to the contractor
 - will be retained by _____
pending disposition instructions from the contractor.
- First Articles will be installed on aircraft/equipment to determine proper fit/function. Approved article will remain on the aircraft/equipment and will not be forwarded to USAF Supply, but will be considered part of the contract quantity.
- Disapproved First Articles
 - will be returned to the contractor
 - will be retained by OO-ALC/309 MXSG
pending disposition instructions from the contractor.
- On purchase requests designated as direct shipments the following disposition will apply. (NOTE: Always applicable on Foreign Military Sales (FMS)).
 - a. Approved First Articles will be returned to the contractor for shipment with production item.
 - b. Disposition of disapproved First Articles will remain the same as marked above.
- Other Disposition:

11. CONDITION(S) FOR WAIVER OF FIRST ARTICLE APPROVAL

- a. Offerors who have previously furnished production quantities of the same or similar article to the prime contractor for delivery to the
 - Government, DoD, Air Force.
- b. Offerors currently in production of the same or similar article for a Government, DoD,
 Air Force contract and who have received First Article approval under the existing contract.
- c. Offerors who have previously furnished production quantities of the same or similar articles to the
 - Government, DoD,
 - Air Force, provided articles thus furnished, have exhibited satisfactory performance in service in the opinion of the Air Force.
- d. Provided not more than 36 months have elapsed since completion of the contract.
- e. First Article testing will not be waived.
- f. See Remarks in block 12 below.

NOTE TO BUYER: UNDER CONDITIONS A AND C ABOVE, THE COGNIZANT ENGINEERING ACTIVITY WILL DECIDE WHETHER OR NOT THE ITEM HAS EXHIBITED SATISFACTORY PERFORMANCE IN SERVICE AND PREPARE AND RETAIN SUPPORTING DOCUMENTATION TO FULLY JUSTIFY THIS DECISION. THE BUYER MUST SOLICIT DUAL PRICES (That is, both with and without requirement for first article approval) AND MUST 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 Hamblin, Adam S DATE 26 MAY 2009
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. First Article waiver approvals as well as similar item determination are solely the responsibility of the Cognizant Engineering Organization. The Cognizant Engineering Organization shall determine First Article testing requirements based on component criticality and complexity, regardless of PR value.

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

Adam S Hamblin
417 SCMS
801-775-6387
775-6387

14. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING TEST *(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: NUT TRUCK PIVOT BOLT MAIN GEAR (NUT)		
2. PART NUMBER: 60-6550	3. NATIONAL STOCK NUMBER: 5310-00-576-1845SX	

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. MATERIAL REVIEW BOARD:

6. 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.

7. 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.

8. MARKING AND IDENTIFICATION PER MIL-STD-130.

9. UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130. THE UID SHALL BE BOTH HUMAN READABLE INFORMATION (HRI) MARKINGS AND MACHINE-READABLE INFORMATION (MRI) MARKS. THE MRI SHALL BE ACCOMPANIED BY A HRI. BOTH MARKS WILL 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 HRI SHALL APPEAR AS "SN 9874701070001". THE HEIGHT OF EACH ALPHANUMERIC CHARACTER IN THE HRI SHALL BE A MAXIMUM OF .125 INCHES. MARKINGS FOR BOTH THE MRI AND HRI SHALL BE TO SAE AS 9132. THE LOCATION OF THE UID SHALL BE THE SAME LOCATION AS IDENTIFIED ON THE DRAWING. THE METHOD OF MARKING FOR HRI 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 METHOD OF MARKING FOR THE MRI SHALL BE LIMITED TO TESA BRAND SECURE 6973 BLACK UID LASER ETCHED MARKING TAPE (FOR MORE INFORMATION REFER TO WWW.TESATAPE.COM/PROFESSIONAL/INDUSTRY/APPLICATIONS/UIDDOD) AND SHALL ONLY BE PLACED ON THE TOP COAT OF THE PAINTED COMPONENTS. THE MRI MARK ON THE TESA TAPE SHALL CONTAIN HRI EQUIVALENT INFORMATION IN BOTH 2D MATRIX FORM AND IN HUMAN READABLE FORM. WHEN ITEMS CANNOT BE FULLY MARKED OR TAGGED DUE TO LACK OF MARKING SPACE OR BECAUSE MARKING OR TAGGING WOULD HAVE A DELETERIOUS EFFECT, THE FULL DETAILED UID MARKING REQUIREMENTS SHALL BE APPLIED TO A SUPPLEMENTAL BAG OR OTHER PACKAGE THAT ENCLOSES THE INDIVIDUAL ITEM.

10. SURFACE ROUGHNESS PER ASME B46.1 IN LIEU OF BACD 2097.

11. THREADS PER SAE AS 8879 (CATEGORY 2) IN LIEU OF MIL-S-7742.

12. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF BAC 5601 AND D-18462.

13. ON PARTS HEAT TREATED 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 ENGINEERING. GRINDING WILL BE PER MIL-STD-866

14. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF MIL-I-6868. 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.

15. CADMIUM PLATE PER MIL-STD-870 TYPE II CLASS 2 IN LIEU OF 1.20.

PREPARED BY: ADAM HAMBLIN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20090505
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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: NUT TRUCK PIVOT BOLT MAIN GEAR (NUT)		
2. PART NUMBER: 60-6550	3. NATIONAL STOCK NUMBER: 5310-00-576-1845SX	

16. THE FOLLOWING SPECIFICATIONS ARE NOT REQUIRED NOR WILL THEY BE PROVIDED FOR MANUFACTURE OF THIS ITEM: BAC 5300, BAC 5005, BAC 5009, BACD 2097, D-18462 AND DWG D2-5000.

PROJECT RIGHTS GUARD

PREPARED BY: ADAM HAMBLIN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20090505
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