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**DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION**

**NSN: 5306-00-815-1675
P/N 32-45219-3**

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

FIRST ARTICLE REQUIREMENTS <i>(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)</i>			1. DATE 22 DEC 2009
2. PR/MIPR NUMBER	3. CAGE / REFERENCE NUMBER 76301 / 32-45219-3	4. NSN 5306008151675SX	
5. FIRST ARTICLE QUANTITY THE FIRST ARTICLE IS <u>1</u> UNIT(S) OF LOT/ITEM <u>EA</u> AND WILL BE: <input checked="" type="checkbox"/> PART OF PRODUCTION QUANTITY <input type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY			
6. ARTICLES <input type="checkbox"/> WILL <input checked="" type="checkbox"/> WILL NOT SERVE AS A MANUFACTURING STANDARD		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 <p style="font-size: small;">"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."</p>			
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>include conformance with all drawings, specifications, and engineering data requirements.</u> B. The detailed technical requirements for First Article approval tests are contained in <u>drawings, specifications, and engineering data requirements.</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>OO-ALC</u> <i>(Requesting Activity)</i> of test time and location due <u>30</u> 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>15</u> calendar days prior to shipment. (3) Delivered to government at <u>OO-ALC/809 MXSS/MXDEB</u> <u>Bldg 849 Attn: Non-Accountable Bay (Dear John Bay)</u> <u>Transportation Office</u> <u>Hill Air Force Base, UT 84056-5713 USA</u> <i>(Set Forth Consignee and Address)</i> (4) Government written notice of approval/disapproval within <u>90</u> days after receipt of first article package.			

G. Estimated cost of government testing/inspection evaluation.

\$500,0000

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 _____
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 Whitmer, Jeff G DATE 22 DEC 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)*

Jeff G Whitmer
417 SCMS
801-775-6072
775-6072

14. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING TEST *(Name, Organization, Phone)*

ENGINEERING DATA LIST										*HISTORY*	
REVISION: 1		DATA TECH: Ctuliiani, Sandi L		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABB		END ITEM: F-4		PAGE 1 OF 1			
CAGE: 76301		MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION		REFERENCE NUMBER: 32-45219-3		NOUN: BOLT, SHOULDER		NSN: 5306008151675SX			
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS			
L	98747	HILL AFB FORM 462			X		ENG DATA RQMTS (ATCH A)				
L	76301	32-45219	E				BOLT- SPECIAL, ROOT NLG				
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 - GOV'T DOCUMENT. O - OTHERS. CONTRACTOR MUST ACQUIRE. A - DATA NOT AVAILABLE.											

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: BOLT – SPECIAL, ROOT NLG F-4 ACFT		
2. PART NUMBER: 32-45219	3. NATIONAL STOCK NUMBER: 5306-00-815-1675 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.

- 4.1 MARK AND IDENTIFY PER MIL-STD-130 IN LIEU OF CR-0380 AND CPC 9201.
- 4.2 MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF MIL-I-6870 USE FLUORESCENT TYPE, FULL WAVE DIRECT CURRENT (FWDC), AND WET CONTINUOUS METHOD. THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA MAY BE USED AS AN ALTERNATE TO THE ORIGINAL MANUFACTURER CRITERIA: NO RELEVANT INDICATIONS ALLOWED. THE INTENT OF NO RELEVANT INDICATIONS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO DEFECTS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTIONS SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN THE AIA/NAS-410.
- 4.3 CHROMIUM PLATE PER SAE MIL-STD-1501 IN LIEU OF QQ-C-320 or PS13102.. PARTS SHALL BE SHOT PEENED IN ACCORDANCE WITH SAE AMS 2430 PRIOR TO PLATING.
- 4.4 *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.*
- 4.5 . SHOT PEEN PER SAE AMS 2430 IN LIEU OF PS 14023 PR MIL-S-13165. SHOT PEENING INTENSITY SHALL BE AS SPECIFIED BY THE DRAWING. THE SIZE OF THE SHOT SHALL BE AT THE OPTION OF THE CONTRACTOR, WITHIN THE REQUIREMENTS OF SAE AMS 2430. THE FOLLOWING CRITERIA SHOULD BE USED IN SELECTING THE SHOT MATERIAL.
 - a) FOR STEEL PARTS HEAT TREATED TO 200 KSI OR ABOVE, 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), AND
 - b) FOR NONFERROUS METALS AND STEEL PARTS HEAT TREATED TO VALUES BELOW 200 KSI, USE STANDARD HARDNESS STEEL SHOT (PER SAE AMS 2431/1, 2431/3, OR 2431/4)
- 4.6 ALTERNATE USE 4340 STEEL MATERIAL PER SAE AMS 6415 OR SAE AMS 6484 IN LIEU OF MIL-S-5000; 4140 PER AMS 6382 OR SAE AMS 6349 IN LIEU OF MIL-S-5626.
- 4.7 ROUGHNESS OF SURFACES PER ASME B46.1 IN LIEU OF MIL-STD-10.
- 4.10 THREADS PER SAE-AS-8879 IN LIEU OF MIL-S-7742.
- 4.11 HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875.
- 5. 417 SCMS/GUEB 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 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. CAD PLATE PER MIL-STD-870 IN LIEU OF CP-0100 OR CPC 8204.

PREPARED BY: Jeffrey Whitmer	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 2 DEC 2009
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