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**DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION**

**NSN: 5307-00-837-7200
P/N: 9756C-94**

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

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 – SPACER, NOSE LANDING GEAR		
2. PART NUMBER: 9756C-94	3. NATIONAL STOCK NUMBER: 5307-00-837-7200LE	

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 THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.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) 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 ENGINEERING.

7. UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130 IN LIEU OF IM-8. 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.

8. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF MIL-I-6868 AND IT 32.1. 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.

9. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF HT-3, HT-22 AND MP-175.

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. 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. CADMIUM PLATE PER MIL-STD-870, TYPE II, CLASS 2 IN LIEU OF FP-49.

12. SHOT PEEN PER SAE AMS 2430 IN LIEU OF MA-57.

PREPARED BY: TONYA M. CHRISTENSEN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 9/23/2008
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13. MATERIAL PER SAE AMS 6425 IN LIEU OF MIL-S-7108.

14. SURFACE ROUGHNESS PER ASME B46.1 IN LIEU OF MIL-STD-10.

15. DIMENSIONING AND TOLERANCING PER ASME Y14.5 IN LIEU OF DRAWING 3-40500.

16. USE FED-STD-H28 SCREW-THREAD STANDARDS FOR FEDERAL SERVICES IN LIEU OF FH-32 AND MIL-S-7742.

17. SPECIFICATION NFS-70 IS NOT REQUIRED FOR MANUFACTURE AND WILL NOT BE PROVIDED.

18. SUBJECT COMPONENTS HAVE BEEN DESIGNATED AS A CRITICAL SAFETY ITEM (CSI). CRITICAL CHARACTERISTICS ARE DEFINED AS FOLLOWS:

- CSI HEAT TREAT PER SAE AMS-H-6875.
- CSI PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444
- CSI MATERIAL PER SAE AMS 6425
- CSI CADMIUM PLATE PER MIL-STD-870.

PREPARED BY: TONYA M. CHRISTENSEN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 9/23/2008
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ENGINEERING DATA LIST										*HISTORY*
REVISION: 2		DATA TECH: Cope, Charles R		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABB		END ITEM: T-38				PAGE 1 OF 1
CAGE: 76823		MANUFACTURER NAME: NORTHROP GRUMMAN SYSTEMS CORPORATIO		REFERENCE NUMBER: 9756C94		NOUN: STUD, SHOULDERED				NSN: 5307008377200LE
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS		
L	76823	9756C-94	AC		S		BOLT - SPACER, NLG			
L	98747	HILL AFB FORM 462			X		ENGR DATA RQMTS (ATTACHMENT A)			
STANDARD ENGINEERING TEXT										
NAME: Cope, Charles R DATE: 15 SEP 2008 ALL APPLICABLE F-5/T-38 APPENDICES HAVE BEEN REVIEWED.										
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.										