

14153 QAP-CSI010180840
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**DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION**

**NSN: 5310-01-018-0840
P/N: 66-13401-3**

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 20060605
2. P/R/MIPR NUMBER	3. PART NUMBER 66-13401-3	4. NSN 5306-01-018-0840LE
5. FIRST ARTICLE QUANTITY THE FIRST ARTICLE IS <u>1</u> UNIT(S) OF LOT/ITEM <u>1</u>		
AND WILL BE: <input type="checkbox"/> PART OF PRODUCTION QUANTITY <input checked="" 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 "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 and specifications in the contract</u> . B. The detailed technical requirements for First Article approval tests are contained in <u>all drawings and specifications in the contract</u> <i>(Cite Spec and Para number)</i> C. <input type="checkbox"/> 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 _____ <i>(Requesting Activity)</i> of test time and location due _____ days prior to start of testing. E. <input type="checkbox"/> 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: (1) Due within _____ calendar days from date contract. (2) Notify <u>15</u> calendar days prior to shipment. (3) Delivery to government at <u>OO-ALC/MXRILV</u> <u>ATTN: Non Acct Bay, Transportation Officer</u> <u>Bldg 849, Hill AFB UT 84056-5731</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. <u>\$1000.00</u>
10. DISPOSITION OF FIRST ARTICLES <input checked="" type="checkbox"/> Approved First Articles will be forwarded to <u>Supply</u> <input type="checkbox"/> _____ <i>(insert quantity)</i> First Articles will be expended in testing. Residual components of disapproved First Articles <input type="checkbox"/> will be Returned to the contractor/ <input type="checkbox"/> will be retained by _____ pending disposition instructions from The contractor. <input type="checkbox"/> 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.		<input type="checkbox"/> Disapproved first articles will be returned to the contractor/ <input checked="" type="checkbox"/> will be retained by <u>OO-ALC/MXRILV</u> pending disposition instructions from the contractor <input type="checkbox"/> 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. <input type="checkbox"/> Other Disposition: _____

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 20060605
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<p>11. CONDITION(S) FOR WAIVER OF FIRST ARTICLE APPROVAL</p> <p>a. <input checked="" type="checkbox"/> Offerors who have previously furnished production quantities of the same or similar article to the prime contractor for delivery to the _____ Government, _____ DoD, <input checked="" type="checkbox"/> Air Force.</p> <p>b. <input checked="" type="checkbox"/> Offerors currently in production of the same or similar article for a _____ Government, _____ DoD, <input checked="" type="checkbox"/> Air Force contract and who have received First Article approval under the existing contract.</p> <p>c. <input checked="" type="checkbox"/> Offerors who have previously furnished production quantities of the same or similar articles for a _____ Government, _____ DoD, <input checked="" type="checkbox"/> Air Force provided articles thus furnished have exhibited satisfactory performance in service, in the opinion of the Air Force.</p> <p>d. <input checked="" type="checkbox"/> Provided not more than <u>0</u> months have elapsed since completion of the contract.</p> <p>e. <input type="checkbox"/> First Article testing will not be waived.</p> <p>f. <input checked="" type="checkbox"/> See remarks in block 12 below.</p> <p>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 RETIAN 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:</p> <p style="text-align: center;">A. PROCURING OFFICE B. CONTRACT NUMBER C. DATE OF CONTRACT D. SPECIFICATION NUMBER AND REVISION</p> <hr style="width: 100%;"/>		
<p>12. REMARKS</p> <p>The manufacture of this item require techniques, processes, tooling or finish(es) of such a nature that only by First Article testing and evaluation can assurance be obtained that a contractor has the capability of producing the item in accordance with the instructions and data supplied or specified.</p> <p>Vendor will only be allowed one attempt to receive full or conditional approval. Failure to receive approval of First Article inspection will result in termination of the contact, and subsequent removal of the vendor as an approved source (if the item is AMSC coded C).</p>		
<p>13. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING AND/OR APPROVING TEST (Name, Organization, Phone)</p> <p><u>Bryan Terry, 84CSUG/GBCLE, (801) 775-6387</u></p>		<p>14. PR INITIATOR (Name, Organization, Phone)</p> <p>_____</p>

REV:	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")
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NOTE: MILITARY SPECIFICATIONS /STANDARDS WILL NOT BE FURNISHED IN THE BID SET.

1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF
BOLT, APEX TORSION LINK - MAIN GEAR (E-3A)

2. PART NUMBER
66-13401-3

3. NATIONAL STOCK NUMBER
5306-01-018-0840LE

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. THIS ITEM IS A CRITICAL APPLICATION COMPONENT. THE STRUCTURAL AND FUNCTIONAL INTEGRITY OF THIS ITEM CAN BE AFFECTED BY INDIVIDUAL MANUFACTURERS PROCESSES AND TECHNIQUES.

6. TO ENSURE CONTINUED PRODUCT INTEGRITY OF THE ITEM, PROCUREMENT IS RESTRICTED TO SOURCES LISTED IN SECTION E OF THE SCREENING ANALYSIS WORKSHEET. THESE SOURCES ARE KNOWN TO HAVE THE REQUIRED EXPERIENCE AND CAPABILITY. FAILURE OF THIS ITEM COULD RESULT IN LOSS OF AIRCRAFT AND CREW PERSONNEL.

7. THEREFORE, NEW SOURCES MUST BE APPROVED BY GBCLE SYSTEM ENGINEER PRIOR TO CONTRACT AWARD.

8. MARK AND IDENTIFY PER MIL-STD-130 IN LIEU OF BAC 5307

9. DIMENSIONS AND TOLERANCES PER ASME Y14.5 IN LIEU OF D-18462

10. SHOT PEEN PER SAE AMS-S-13165 IN LIEU OF D-18462

11. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO 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 INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN AIA/NAS NAS-410.

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

13. CHROME PLATE PER MIL-STD-1501 TYPE II CL 3 IN LIEU OF F-1846, F-1.90 AND SAE-AMS-QQ-C-320, CL 2

14. CADMIUM PLATE PER MIL-STD-870 TYPE II CL 2 IN LIEU OF SRF-161 AND SAE AMS-QQ-P-416, TYPE II, CL 2

15. FINISH PER MIL-STD-1500, TYPE II, CLASS 2 IN LIEU OF F-1181

16. PAINT PER THE FOLLOWING IN LIEU OF SRF-12.205 AND SRF-14.9813:

A. APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS C2
ALTERNATE PRIMER - ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I, CLASS 2

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

17. SPECIFICATIONS BAC 5300, BAC 5005, BAC 5009, BAC 5004, D-18462, AND D2-5000 ARE NOT REQUIRED FOR THE MANUFACTURE OF THIS PART.

"PROJECT RIGHTS GUARD"

PREPARED BY

DEBBIE TRIBETT-WOODS

SYMBOL

LGMPE

DATE

20060606

PART NUMBER 66-13401-3	NATIONAL STOCK NUMBER 5306-01-018-0840LE
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18. ****CS1*** 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.

19. ****CSI**** 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 84 CSUG/GBCLE. GRINDING SHALL BE PER MIL-STD-866.

20. DRILLING, REAMING, AND HONING TO MEET DRAWING SPECIFICATIONS, USING BEST AIRCRAFT INDUSTRY STANDARDS AND THE FOLLOWING:

A. HIGH SPEED STEEL (HSS) DRILLS SHALL BE USED TO DRILL CORROSION RESISTANT STEELS.

B. HSS REAMS WILL BE USED FOR ROUGH REAMING AND FINAL REAMING OF STEELS HEAT TREATED BELOW 200 KSI. CARBIDE OR PREMIUM GRADE HIGH-SPEED STEEL TIPPED REAMERS WILL BE USED FOR ROUGH REAMING OF STEELS HEAT TREATED ABOVE 200 KSI.

C. HONING STONES SHALL BE OF 150 TO 500 ALUMINUM OXIDE GRIT WITH A MEDIUM-HARD BOND AND PREFERABLY A MULTI-HEAD STONE.

D. DRILLING SHALL NEVER BE USED AS A FINAL MACHINING OPERATION. A MINIMUM OF 0.015 INCH ON DIAMETER SHALL BE LEFT FOR FINAL REAMING. HOLES SHALL BE FINISHED BY REAMING OR BORING. WHEN JIGS, FIXTURES, OR BUSHINGS ARE NOT USED FOR DRILLING HOLES LARGER THAN 1/4 INCH, THE HOLES WILL BE PILOTED WITH A CENTER DRILL. CHEMICAL, ELECTRICAL, OR ELECTROCHEMICAL HOLE PRODUCING METHODS SHALL NOT BE USED AS A FINAL SURFACE PRODUCING METHOD WITHOUT PRIOR APPROVAL FROM 84 CSUG/GBCLE.

E. ROUGH REAMING, THE REAMER LENGTH SHALL BE AS SHORT AS CONSISTENT WITH REQUIRED PENETRATION. FINAL REAMING, THE DIAMETRICAL CUT SHALL PRODUCE A HOLE THAT MEETS THE REQUIREMENTS OF THE ENGINEERING DRAWING.

F. HONING SHALL BE USED AS A FINAL OPERATION WHERE A SURFACE FINISH BETTER THAN 125 ROUGHNESS HEIGHT RATIO IS REQUIRED AND CANNOT BE PRODUCED BY OTHER MEANS.

21. OO-ALC/GBCLE SYSTEM 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.

22. 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 OO-ALC/GBCLE.

"PROJECT RIGHTS GUARD"

PREPARED BY DEBBIE TRIBETT-WOODS	SYMBOL LGMPE	DATE 20060606
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SOURCE QUALIFICATION STATEMENT
(PL 98-525, Section 2319)

SECTION A. ITEM IDENTIFICATION

1. STOCK NUMBER (NSN): 5306-01-018-0840LE
2. PART NUMBER (P/N): 66-13401-3
3. NOUN: Bolt Internally
4. APPLICATION: E-3A

SECTION B

JUSTIFICATION FOR ESTABLISHING QUALIFICATION REQUIREMENTS AND REASON WHY QUALIFICATION REQUIREMENTS MUST BE DEMONSTRATED PRIOR TO CONTRACT AWARD

1. Characteristics associated with the manufacturing and processing of this component could result in product functional degradations. This item performs a critical function on the aircraft and special equipment is required for its manufacture and testing. Close tolerance machining is required. Special care and attention is required but not limited to surface finish, processing, and assembly of this item. This item is particularly susceptible to process induced manufacturing flaws; therefore care must be taken to insure a potential vendor's capability prior to contract award.
2. The bidder's ability to interpret Engineering drawings and specifications and the execution of the qualification requirements specified herein are necessary to verify the structural and/or functional integrity and/or fit and form of the item being procured.
3. Failure to procure this item from a fully qualified source could result in failure of the part, degradation of aircraft mission capability, or loss of aircraft and crew.
4. Completion of the specified pre-contract award qualification requirements will assure the government that the offerer is capable of producing the item in compliance with the applicable technical specification/data and within the schedule and economic constraints of our contracts. There are sufficient technical and schedule risks, which can only be minimized by a completion of the requirements prior to contract award.

SOURCE QUALIFICATION REQUIREMENTS
(PL 98-525, SECTION 2319)

STOCK NR (NSN): 5306-01-018-0840LE
NOUN: Bolt Internally

PART NUMBER (P/N): 66-13401-3
AIRCRAFT: E-3A

SECTION C

QUALIFICATION REQUIREMENTS THAT MUST BE SATISFIED TO BECOME A QUALIFIED SOURCE

1. Because of the need for uninterrupted item support to military aircraft systems and in keeping with the requirements of PL 98-525, the current acquisition need not and generally will not be delayed to provide an offerer an opportunity to qualify. Normal acquisition practices at OO-ALC should preclude the denial of opportunity to any interested offerer.
2. The offerer must provide a pre-contract award qualification article, which meets the requirements of the engineering drawings, material specifications, and process specifications. However, successful completion of the qualification testing does not guarantee any contract award. If the offeror is deemed qualified and awarded the contract, a post-contract award first article exhibit may be required to verify production capability.
3. The required materials will be procured from a qualified source and will meet the requirements of their respective specifications. The offerer will assure that the material supplier has accomplished this and will submit certified documentation of accomplishment of the above requirements to the purchaser along with the pre-contract award qualification article.
4. The qualification article shall demonstrate full compatibility and comparability with existing parts, and once submitted, will be subjected to such testing as deemed necessary by the government, to insure the article meets all dimensional, processing, and functional requirements. Such testing may result in the destruction of the article. Following completion of necessary testing and evaluation, the article, no matter what its condition, shall be returned to the contractor or disposed of at his discretion and direction, whether it was found acceptable or not.
5. Form verification: The Government's Quality Verification Center will verify compliance with dimensional data requirements. Material and process compliance will also be verified as required.
6. Fit/function verification: Existing components and Government test stands/fixtures will be utilized to verify physical interface and functional performance of articles.
7. Testing for material and process compliance
 - (a) Material analysis
 - (b) Heat treat
 - (c) Grinding
 - (d) Plating
 - (e) Finish
 - (f) Other
8. Remarks:
 - a. Organic verification capabilities exist at OO-ALC.
 - b. Test requirements outside organic capabilities will be contracted out to independent laboratories.
9. The estimated cost of government testing and evaluation is \$5000
10. Maximum time for testing of the qualification article will not exceed 30 days from receipt at testing agency.

SOURCE QUALIFICATION REQUIREMENTS
(PL 98-525, SECTION 2319)

STOCK NR (NSN): 5306-01-018-0840LE
NOUN: Bolt Internally

PART NUMBER (P/N): 66-13401-3
AIRCRAFT: E-3A

SECTION D

QUALIFICATION WAIVER REQUIREMENTS.

1. An offerer who has had previous experience in the manufacture and qualification of items, which can be correlated with this product, may apply to the design control authority at OO-ALC for a waiver of the above stated qualification requirements.

a. The qualification waiver criteria utilized by the design control authority to perform a qualification analysis are available upon request. The qualification waiver criteria may be used as a guide in preparing the offerer's written input to the design control authority.

b. The burden of proof for written inputs is on the offerer. The design control authority will not pursue authenticity verification of claims made by the offerer of product manufacturing experience with other Government or non-Government agencies. Unsubstantiated claims will not be considered in the waiver analysis process.

c. This waiver will be granted if and only if the design control authority (GBCLE) can establish the qualifications of the offerer through the evaluation of written inputs from the offerer or from previous knowledge of the offerer's capabilities or from previous experience with the offerer on similar item acquisitions. If there is any doubt about the offerer's capability, the offerer will be required to submit a pre-qualification article. There is no guarantee of qualification by similarity. GBCLE reserves the right to require a pre-qualification article of all offerers.

2. The current acquisition need not and will not be delayed in order to provide an offerer with an opportunity to meet the requirements for qualification waiver.

3. Maximum time for approval of qualification by similarity will not exceed 15 days.

SOURCE QUALIFICATION REQUIREMENTS
(PL98-525, SECTION 2319)

STOCK NR (NSN): 5306-01-018-0840LE
NOUN: Bolt Internally

PART NUMBER (P/N): 66-13401-3
AIRCRAFT: E-3A

SECTION E

MASTER SIGNATURE BLOCK:


OO-ALC/GBCLE Engineer

2006 05 23
Date


OO-ALC/GBCLE Lead Engineer

2006 05 24
Date

The Master SQS has been coordinated by CR, BC, and SBA and approved by LIK on 4 April 01. The Master SQS coordination copies are kept on file in GBCLE (Reference: SP 01-105)