

14153 **QAP-CSI010744038**
DTD 19 NOV 08

DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION

NSN: 5315-01-074-4038
P/N: 2006625-9

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 05 NOV 2008
2. PR/MIPR NUMBER	3. PART NUMBER 2006625-9	4. NSN 5315010744038LE
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 checked="" type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY		
6. ARTICLES WILL <input checked="" type="checkbox"/> WILL NOT SERVE AS A MANUFACTURING	7. LONG LEAD TIME ITEMS <input checked="" type="checkbox"/> REQUIRED 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 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 checked="" type="checkbox"/> GOVERNMENT TESTING Performance or other characteristics which the First Articles must meet are <u>Conformance to 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. 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</u> <i>(Requesting Activity)</i> of test time and location due <u>15</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		

(1) Due within 300 calendar days from date contract.

(2) Notify 15 calendar days prior to shipment.

(3) Delivered to government at

OO-ALC/309 MXSG/MXRILV

Bldg 849 Attn: Non-Accountable Bay

Transportation Office

Hill Air Force Base, UT 84056-5713

(Set Forth Consignee and Address)

(4) Government written notice of approval/disapproval within 120 days after receipt of first article package.

G. Estimated cost of government testing/inspection evaluation.

\$300.0000

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. Offers 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. Offers 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. Offers 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 _____ 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 Butterfield, Jared

DATE 05 NOV 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. 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 CONDUCTING AND/OR APPROVING TEST (*Name, Organization, Phone*)

14. PR INITIATOR (*Name, Organization, Phone*)

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: PIN, TRUNNION – SHOCK STRUT, NLG		
2. PART NUMBER: 2006625-9	3. NATIONAL STOCK NUMBER: 5315-01-074-4038LE	

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 ANSI Y14.5-1973.

8. SURFACE ROUGHNESS PER ASME B46.1 IN LIEU OF ASA B46.1-1962.

9. MARKING AND IDENTIFICATION PER MIL-STD-130 IN LIEU OF TM1040. THE UID SHALL CONTAIN HUMAN-READABLE INFORMATION (HRI) AND MACHINE-READABLE INFORMATION (MRI) MARKINGS. QUALITY AND TECHNICAL REQUIREMENTS FOR BOTH THE MRI AND HRI SHALL BE IN ACCORDANCE WITH SAE AS9132. THE METHOD OF MARKING FOR THE HRI SHALL BE LIMITED TO 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 HRI MARK 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 APPEAR AS "SN 9874701040001". THE HEIGHT OF EACH ALPHANUMERIC CHARACTER IN THE HRI SHALL BE A MAXIMUM OF .125 INCHES. THE LOCATION OF THE HRI SHALL IS IDENTIFIED ON THE DRAWING.

10. 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 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 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.

11. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875 AND MM4995, TO 220-240 KSI.

12. 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. GRINDING WILL BE PER MIL-STD-866 IN LIEU OF MM5759.

13. SHOT PEEN PER SAE AMS 2430 AND DRAWING REQUIREMENTS IN LIEU OF MIL-S-13165. USE HARD STEEL SHOT IN THE RANGE OF 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).

14. USE 4330 MATERIAL SPECIFICATION SAE AMS 6411 IN LIEU OF AMS 6411.

15. CADMIUM PLATE PER MIL-STD-870, TYPE II, CLASS 1 IN LIEU OF MM5542 OR MM4951.

16. 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.

17. CHROMIUM PLATE PER MIL-STD-1501 TYPE 2, CLASS 2 IN LIEU OF QQ-C-320.

PREPARED BY: JARED BUTTERFIELD	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 2008 NOV 10
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18. 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.

19. USE MIL-PRF-16173 GRADE 3 IN LIEU OF MM5752 CORROSION CONTROL.

20. USE MIL-L-23398, TYPE I IN LIEU OF MM1920.

THE FOLLOWING FEATURES AND PROCESSES ARE SAFETY CRITICAL. ASSOCIATED TOLERANCES, LOCATIONS, PERPENDICULARITIES, CONCENTRICITY'S, ETC. OF THE REFERENCED FEATURES ARE ALSO SAFETY CRITICAL. THE PROCESSES REFERENCED MUST COMPLY STRICTLY WITH THE SPECIFICATIONS REQUIRED BY CONTRACT.

DRAWING 2006625
ADD CSI TO NOTES 1, 2, 4, 5, 7, 19

DISTRIBUTION STATEMENT D
DISTRIBUTION AUTHORIZED TO DOD AND US DOD CONTRACTORS ONLY (CRITICAL TECHNOLOGY). OTHER REQUESTS FOR THIS DOCUMENT SHALL BE REFERRED TO 417 SCMS/GUEB.

PREPARED BY: JARED BUTTERFIELD	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 2008 NOV 10
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ENGINEERING DATA LIST										*HISTORY*	
REVISION: 2		DATA TECH: Maxwell, Stephen B		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABB		END ITEM: F-16		PAGE: 1 OF 1			
CAGE: 17576		MANUFACTURER NAME: GOODRICH CORP		REFERENCE NUMBER: 2006625-9		NOUN: PIN, TRUNNION, LANDIN		NSN: 5315010744038LE			
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS			
L	17576	2006625	E		S		PIN, TRUNNION				
STANDARD ENGINEERING TEXT											
<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>											