

14153 QAP-CSI011548095
DTD 18 MAY 09

**DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION**

**NSN: 5306-01-154-8095
P/N 458-56181-1**

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 18 MAY 2009
2. PR/MIPR NUMBER	3. CAGE / REFERENCE NUMBER 82918 / 458-56181-1	4. NSN 5306011548095LE
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 <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, 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.

\$1,200,0000

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 18 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: BOLT - LOWER SIDE BRACE, MAIN LANDING GEAR (KC-135)		
2. PART NUMBER: 458-56181-1	3. NATIONAL STOCK NUMBER: 5306-01-154-8095LE	

4.0 THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.

5.0 MATERIAL REVIEW BOARD

- A) 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.
- B) 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.

6.0 COMPLIANCE WITH BOEING PROCESS SPECIFICATIONS NOTED IN THE TECHNICAL DATA PACKAGE IS PREFERRED; HOWEVER, THE SUPPLIED EQUIVALENT PROCESS SPECIFICATIONS MAY BE USED IN LIEU OF THE NOTED BOEING PROCESS SPECIFICATIONS. NC PROGRAM CONTOUR MACHINING PATTERN SHALL CONFORM TO ALL DRAWING REQUIREMENTS AND PROOF PART SHALL BE INSPECTED WITH A FIRST ARTICLE AND APPROVED BY 417 SCMS/GUEB PRIOR TO INITIAL PRODUCTION IN LIEU OF BOEING ENGINEERING APPROVAL.

7.0 UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130 IN LIEU OF FLAG NOTE 4. 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 ELECTRO-CHEMICAL ETCHING, DOT PEEN, VIBRO PEEN, OR MICRO-MILL. THE DEPTH OF EACH MARK SHALL BE FROM .003 - .005 INCHES. 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 SHALL 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 BE IDENTIFIED BY FLAG NOTE 4 ON THE DRAWING. THE FULL DETAILED UID MARKING REQUIREMENTS SHALL BE APPLIED TO A TAG, SUPPLEMENTAL BAG OR OTHER PACKAGE THAT ENCLOSES THE INDIVIDUAL ITEM IN ACCORDANCE WITH DRAWING 200827953-5.

8.0 (CSI) PER FLAG NOTE 5; CHROMIUM PLATE IN ACCORDANCE WITH MIL-STD-1501 IN LIEU OF FINISH CODE F-1.846.

9.0 (CSI) PER FLAG NOTE 9; THREADS PER SAE AS8879 IN LIEU OF MIL-S-8879.

10.0 IN LIEU OF FL 8 AND 10: APPLY LIBERAL QUANTITY OF PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2 OR PER MIL-PRF-23377, TYPE I ON SURFACE BY SCRUBBING FOR A FEW SECONDS WITH CHEESE CLOTH OR EQUIVALENT. THE ENTIRE AREA MUST BE COVERED. BEFORE PRIMER DRIES, GENTLY REMOVE EXCESS WET PRIMER WITH CHEESE CLOTH OR EQUIVALENT AND LET DRY.

11.0 PER FLAG NOTE 11: GLASS BEAD PEEN PER TO MEET DRAWING REQUIREMENTS PER SAE AMS-S-13165 IN LIEU OF MIL-S-13165.

PREPARED BY: ADAM HAMBLIN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20090422
------------------------------	---------------------------------	-------------------

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: BOLT – LOWER SIDE BRACE, MAIN LANDING GEAR (KC-135)		
2. PART NUMBER: 458-56181-1	3. NATIONAL STOCK NUMBER: 5306-01-154-8095LE	

12.0 PER FLAG NOTE 13:

A) FOR FINISH CODE F-12.37: APPLY MIL-PRF-23377, TYPE I, CLASS C OR MIL-PRF-85582, TYPE I, CLASS C1 OR C2 TO A MINIMUM DRY FILM OF 0.0006 INCH IN ACCORDANCE WITH MIL-F-18264.

B) FOR FINISH CODE F-12.101: APPLY TWO TOPCOATS POLYURETHANE PER MIL-PRF-85285 TYPE I, COLOR NUMBER 17925 (WHITE) PER FED-STD-595.

13.0 PER FLAG NOTE 15: NITAL ETCH INSPECT PER MIL-STD-867 IN LIEU OF BAC 5436. NO MORE THAN THREE SUCCESSIVE INSPECTIONS SHALL BE PERFORMED WITHOUT A WAIVER FROM 515 CBSS/GBEA.

14.0 PER GENERAL NOTE 1: BREAK SHARP EDGES PER BEST AIRCRAFT INDUSTRY STANDARDS IN LIEU OF BAC5300.

15.0 (CSI) CADMIUM PLATE PER MIL-STD-870 TYPE II CLASS 2 IN LIEU OF TITANIUM CADMIUM PLATE PER FIN. CODE 1.76..

16.0 (CSI) MATERIAL: 300 M STEEL BAR PER SAE AMS 6257 OR SAE AMS 6414 IN LIEU OF MIL-S-8844, CLASS 3.

17.0 (csi) HEAT TREAT PER SAE AMS-H-6875 TO MEET DRAWING REQUIREMENTS, IN LIEU OF MIL-H-6875.

18.0 (CSI) FOR PARTS HEAT-TREATED TO 180 KSI AND ABOVE, ANY SURFACE GROUND/MACHINED AFTER HEAT TREAT SHALL BE INSPECTED FOR ABUSIVE GRINDING/MACHINING BURNS PER MIL-STD-866.

19.0 (CSI) SHOT PEEN PER AMS 2430 IN LIEU OF D458-56002.

20.0 SURFACE TEXTURE PER ASME B46.1 IN LIEU OF ANSI B46.1.

21.0 DIMENSIONING AND TOLERANCING PER ASME Y14.5 IN LIEU OF ANSI Y14.5.

22.0 DRILLING, REAMING AND HONING TO MEET DRAWINGS SPECIFICATIONS, USING BEST AIRCRAFT INDUSTRY STANDARDS.

23.0 20. THIS COMPONENT HAS BEEN DESIGNATED AS A FLIGHT SAFETY CRITICAL ITEM. CRITICAL CHARACTERISTICS ARE INDICATED WITH (CSI).

PREPARED BY: ADAM HAMBLIN	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 20090422
------------------------------	---------------------------------	-------------------