14153 **QAP-CSI012065459**
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DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION

NSN: 5306-01-206-5459
P/N 458-56168-501

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

FIRST ARTICLE REQUIREMENTS

(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)

1. DATE
17 JUN 2009

2. PR/MIPR NUMBER

3. CAGE / REFERENCE NUMBER
81205 / 458-56168-501

4. NSN
5306012065459LE

5. FIRST ARTICLE QUANTITY

THE FIRST ARTICLE IS 1 UNIT(S) OF LOT/ITEM EA

AND WILL BE: PART OF PRODUCTION QUANTITY X IN ADDITION TO PRODUCTION QUANTITY

6. ARTICLES

WILL X WILL NOT SERVE AS A MANUFACTURING STANDARD

7. LONG LEAD TIME ITEMS

X REQUIRED NOT REQUIRED
(See FAR 52.209-3 OR -4, alternate II)

8. SPECIAL REQUIREMENT/PRODUCTION FACILITIES *(See FAR 52.209-3 OR -4 Alternate I)*

X 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

X GOVERNMENT TESTING

Performance or other characteristics which the First Articles must meet are conformance with all drawings, specifications, and engineering data requirements.

B. The detailed technical requirements for First Article approval tests are contained in the specifications included in this contract.
(Cite Spec and Para number)

C. TEST PLAN REQUIRED

Number of days for government approval/disapproval days.

D. Contractor's notification to ACO and
N/A
(Requesting Activity)
of test time and location due days prior to start of testing.

E. 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 365 calendar days from date contract.

(2) Notify 30 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) Governement written notice of approval/disapproval within 120 days after receipt of first article package.

G. Estimated cost of government testing/inspection evaluation.

$1,000.0000

10. DISPOSITION OF FIRST ARTICLES

X 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.

X Disapproved First Articles

will be returned to the contractor

X 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. X Offerors who have previously furnished production quantities of the same or similar article to the prime contractor for delivery to the

Government, DoD, X Air Force.

b. X Offerors currently in production of the same or similar article for a Government, DoD,

X Air Force contract and who have received First Article approval under the existing contract.

c. X Offerors who have previously furnished production quantities of the same or similar articles to the

Government, DoD,

X Air Force, provided articles thus furnished, have exhibited satisfactory performance in service in the opinion of the Air Force.

d. X Provided not more than 36 months have elapsed since completion of the contract.

e. First Article testing will not be waived.

f. X 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 17 JUN 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 – TRUNNION, MLG (KC-135)

2. PART NUMBER:	3. NATIONAL STOCK NUMBER:
458-56168-501	5306-01-206-5459LE

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. GENERAL APPLICABILITY:

5.1. THE DRAWINGS IDENTIFIED ON THE EDL WITH AN ASTERISK * AND (P) ARE CLAIMED PROPRIETARY AND ARE PROTECTED UNDER THE "GPLR". THIS DATA MUST BE HANDLED IAW THE SETTLEMENT AGREEMENT IN CL. CT. #309-89C.

5.2. 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.

5.3. 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.

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

6. DRAWING PL458-56168: BOLT – TRUNNION, MLG.

6.1. (CSI) MATERIAL: 300M STEEL BAR PER SAE AMS 6257 IN LIEU OF MIL-S-8844.

6.2. (CSI) HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875.

6.3. (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 IN LIEU BAC5436. NO MORE THAN THREE SUCCESSIVE INSPECTIONS SHALL BE PERFORMED WITHOUT A WAIVER FROM 417 SCMS/GUEB. GRINDING WILL BE PER MIL-STD-866.

6.4. SURFACE TEXTURE PER ASME B46.1 IN LIEU OF ANSI B46.I.

6.5. USE BEST AIRCRAFT INDUSTRY STANDARDS TO MEET DRAWING REQUIREMENTS IN LIEU OF BACS300.

6.6. USE MIL-F-7179 IN LIEU OF BAC5710.

6.7. GLASS BEAD PEEN TO MEET DRAWING REQUIREMENTS PER SAE AMS-S-13165 IN LIEU OF BAC5951.

6.8. FINISH PER THE FOLLOWING IN LIEU OF D2-5000 AND FINISH CODES F-1.846, F-1.76, F-12.37 AND F- 12.101:

A. (CSI) FOR FINISH CODE F-1.846: CHROMIUM PLATE PER MIL-STD-1501.

B. (CSI) FOR FINISH CODE F-1.76: CADMIUM PLATE TO 0.0005 INCHES MINIMUM TO MEET DRAWING REQUIREMENTS PER MIL-STD-870 TYPE II, CLASS 2.

PREPARED BY:	OFFICE SYMBOL:	DATE:
ADAM HAMBLIN	417 SCMS/GUEB	20090617

C. FOR FINISH CODE F-12.37 AND F-12.101:

1. FOR FINISH F-12.37: APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I.

2. FOR FINISH F-12.101: APPLY TWO TOPCOATS POLYURETHANE PER MIL-PRF-85285, TYPE I, COLOR NUMBER 17925 (WHITE) PER FED-STD-595. APPLY TO AREAS INDICATED BY FL 501, FL503, AND FL504 ON DRAWING 458-56168.

6.9. IN LIEU OF FL 4 AND GN 915: UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130

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 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 MMYY, 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 METHOD OF MARKING FOR THE MRI SHALL BE LIMITED TO TESASECURE 6973 PV6 MATTE BLACK UID LASER ETCHED MARKING TAPE MANUFACTURED BY TESA TAPE INC. (FOR MORE INFORMATION, REFER TO WWW.TESATAPE.COM/PROFESSIONAL/INDUSTRY/APPLICATIONS/UIDDOD). THE TESA TAPE MARKING SHALL CONTAIN HRI INFORMATION AND MRI (HRI-EQUIVALENT INFORMATION IN 2D MATRIX FORM). REFERENCE DRAWING 200827953-01 FOR SIZE AND FORMAT OF MARK. APPLY TWO TOPCOATS POLYURETHANE OVER TESA TAPE LABEL PER MIL-PRF-85285, TYPE I, CLEAR PER FED-STD-595.

THE LOCATION OF THE UID SHALL BE AS IDENTIFIED BY FL 4 ON DRAWING 458-56168. TESATAPE LABEL SHALL ONLY BE PLACED ON THE TOP COAT OF THE PAINTED COMPONENTS.

6.10. IN LIEU OF FL 8 AND FL 10: APPLY LIBERAL QUANTITY OF PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2 OR PER MIL-PRF-23377, TYPE I ON CHROMED SURFACE AND THREADS 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.

6.11. (CSI) THREADS PER SAE AS 8879 (CATEGORY 2) IN LIEU OF MIL-S-8879.

6.12. (CSI) SHOT PEEN PER SAE AMS2430 IN LIEU OF 458-56002 USING HARD SHOT Rc=55-65, SHOT RANGE .016-.033, COVERAGE 2.0, INTENSITY .012A-.018A.

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