

14153 QAP-CSI012276084  
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**DEFENSE SUPPLY CENTER PHILADELPHIA  
QUALITY ASSURANCE PROVISION**

**NSN: 5306-01-227-6084  
P/N: 858928-01**

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

|  |                             |  |
|--|-----------------------------|--|
| <b>FIRST ARTICLE REQUIREMENTS</b><br><i>(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)</i>  |                             | 1. DATE<br>19 AUG 2008   |
| 2. PR/MIPR NUMBER  | 3. PART NUMBER<br>858928-01 | 4. NSN<br>5306012276084LE  |
| 5. FIRST ARTICLE QUANTITY<br>THE FIRST ARTICLE IS <u>1</u> UNIT(S) OF LOT/ITEM <u>EA</u><br>AND WILL BE: PART OF PRODUCTION QUANTITY <input type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY <input checked="" type="checkbox"/>   |                             |  |
| 6. ARTICLES<br>WILL <input checked="" type="checkbox"/> WILL NOT <input type="checkbox"/> SERVE AS A MANUFACTURING   |                             | 7. LONG LEAD TIME ITEMS<br><input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED<br><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><br><input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED<br><br>"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<br>A. CONTRACTOR TESTING<br><input checked="" type="checkbox"/> GOVERNMENT TESTING<br>Performance or other characteristics which the First Articles must meet are<br><u>conformance with all drawings, specifications, and engineering data requirements.</u><br>B. The detailed technical requirements for First Article approval tests are contained in<br><u>the specifications included in this contract.</u><br><i>(Cite Spec and Para number)</i><br>C. TEST PLAN REQUIRED<br>(1) DD Form 1423 ELIN<br>_____<br>(2) Delivery due _____ calendar days from date of contract.<br>(3) Number of days for government approval/disapproval _____ days.<br>D. Contractor's notification to ACO and<br><u>N/A</u><br><i>(Requesting Activity)</i><br>of test time and location due _____ days prior to start of testing.<br>E. TEST REPORT REQUIRED<br>(1) DD Form 1423 ELIN<br>_____<br>(2) Due _____ calendar days from date of contract.<br>(3) Forwarded to<br>_____<br>_____<br>_____<br>(4) Government written notice of approval/disapproval due _____ days after receipt of contractor's report.<br>F. FIRST ARTICLE DELIVERY |                             |  |



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    19 AUG 2008  
Cognizant Engineering Organization: Landing Gear  
Name: Adam Hamblin  
Organization: 417 SCMS/GUEB  
Phone: DSN 775-6387

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<br>(ATTACHMENT "A") |  |
| NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.                              |   |  |
| 1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF:<br>BOLT, ACTUATOR, MAIN GEAR      KC-135 |   |  |
| 2. PART NUMBER:<br>858928-01   | 3. NATIONAL STOCK NUMBER:<br>5306-01-227-6084 LE  |  |

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. MATERIAL USE 4340 STEEL MATERIAL PER SAE AMS 6414 IN LIEU OF AMS 6414.
6. ALTERNATE MATERIAL 4130 BAR PER SAE AMS-S-6758 IN LIEU OF MIL-S-6758.
7. DIMENSIONING AND TOLERANCING PER ASME Y14.5 IN LIEU OF Y14.5.
8. UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130. 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-MIL. 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.
9. TO MEET DRAWING REQUIREMENTS PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 AND MIL-STD-1907. 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.
10. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875.
11. ON PARTS HEAT TREATED TO 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.
12. SHOT PEEN PER SAE AMS 2430N IN LIEU OF MIL-S-13165.
13. FINISH ASSEMBLY PER THE FOLLOWING:  
A. 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.

|                              |                                 |                       |
|------------------------------|---------------------------------|-----------------------|
| PREPARED BY:<br>ADAM HAMBLIN | OFFICE SYMBOL:<br>417 SCMS/GUEB | DATE:<br>23-JULY-2008 |
|------------------------------|---------------------------------|-----------------------|

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|--|---|--|
| REV:   | ENGINEERING DATA REQUIREMENTS<br>(ATTACHMENT "A") |  |
| NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.                              |   |  |
| 1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF:<br>BOLT, ACTUATOR, MAIN GEAR      KC-135 |   |  |
| 2. PART NUMBER:<br>858928-01   | 3. NATIONAL STOCK NUMBER:<br>5306-01-227-6084 LE  |  |

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

14. SCREW THREAD SPECIFICATIONS PER SAE AS 8879 IN LIEU OF MIL-S-8879.

15. PER DRAWING REQUIREMENTS CADMIUM PLATE PER MIL-STD-870 TYPE II CLASS 2.

16. PER DRAWING REQUIREMENTS CHROME PLATE CLASS 3 TYPE I OR II PER MIL-STD-1501.

17. PER DRAWING REQUIREMENTS TEMPER ETCH INSPECT PER MIL-STD-867.

18. INTERPRET DRAWING IN ACCORDANCE WITH Y14.100, Y14.24, Y14.34M, AND Y14.35M.

19. 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.

20. 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.

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|------------------------------|---------------------------------|-----------------------|
| PREPARED BY:<br>ADAM HAMBLIN | OFFICE SYMBOL:<br>417 SCMS/GUEB | DATE:<br>23-JULY-2008 |
|------------------------------|---------------------------------|-----------------------|

| AMC/AMSC SCREENING ANALYSIS<br>WORKSHEET REPORT  |                     |   |  |  | PRIORITY CATEGORY   |  |
|--|---------------------|---|--|--|---|--|
|  |                     |   |  |  | 02  |  |
| ITEM IDENTIFICATION AND INFORMATION  |                     |   |  |  |   |  |
| NSN<br>5306012276084LE   |                     | NOUN<br>BOLT,ACTUATOR   |  | END ITEM<br>K-135 "PROJECT RIGHTS GUARD                                |   | PCC<br>ERRC<br>N   |
| QUANTITY   | UNIT COST           | IDENTIFYING NUMBER (Part No)  |  | APPLIES"   |   |  |
| 1  | \$192.72            | R/N<br>858928-01  | CAGE<br>98747  | TOP DWG REV NO.  |   |  |
| EST ANNUAL BUY VALUE<br>\$192.72   |                     |   | COMM OFF-THE-SHELF ITEM<br>YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN |  |   |  |
| NUC. CERT. END ITEM<br>YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN |                     | HARD CRIT. IND<br>YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN |  |  |   |  |
| NEXT HIGHER ASSEMBLY   |                     |   |  |  |   |  |
| NSN  |                     | NOUN  |  | R/N  |   | CAGE   |
| SUMMARY OF SCREENING ACTION  |                     |   |  |  |   |  |
| DESIGN DISCLOSURE<br><input checked="" type="checkbox"/>   |                     | SPEC CONTROL  |  | SOURCE CONTROL   |   | MIL/IND/CONTR PERF SPEC  |
| ST/STE REQUIRED<br>YES <input checked="" type="checkbox"/> NO<br>UNKNOWN                           |                     | ST/STE AVAILABLE<br>YES <input checked="" type="checkbox"/> NO<br>UNKNOWN                     |  | DATA COMPLETE<br><input checked="" type="checkbox"/> YES NO<br>UNKNOWN |   | DATA RIGHTS LIMITED<br><input checked="" type="checkbox"/> YES NO<br>UNKNOWN |
| AMC/AMSC<br>1 / G  |                     | AMC/AMSC EXP DT<br>23 JUL 2013  |  | PRV AMC/AMSC<br>1 / G  |   | PRV AMC/AMSC EXP DT<br>31 OCT 1995   |
| AMC COMPLETION DT<br>29 AUG 2008   |                     |   | ENGINEER AMC/AMSC<br>1 / G   |  |   |  |
| USER TYPE  | DATE/TIME IN        | DATE/TIME OUT   | NAME   | ORGANIZATION/<br>OFFICE SYMBOL   | COMMERCIAL<br>PHONE   | DSN<br>PHONE   |
| Engineer   | 23 JUL 2008 / 1957  | 29 AUG 2008 / 1833  | Hamblin, Adam S  | 417 SCMS / GUEB  | 801-775-6387  | 775-6387   |
| Screening Technician   | 22 JUL 2008 / 2107  | 23 JUL 2008 / 1957  | Earl, Trevor L   | 418 SCMS / GULABB  | 801-775-3891  | 775-3891   |
| Screening Technician<br>Workload Manager   | 22 JUL 2008 / 2106  | 22 JUL 2008 / 2107  | Siegel, Richard W  | 418 SCMS / GULABB  | 801-777-3509  | 777-3509   |
| PROCUREMENT SUPPORT REQUIRED   |                     |   |  |  |   |  |
| FIRST ARTICLE TEST<br><input checked="" type="checkbox"/> YES NO                                   |                     | ENGINEERING DATA LIST REQ<br><input checked="" type="checkbox"/> YES NO                       |  |  | EXPORT CONTROLLED<br><input checked="" type="checkbox"/> YES NO |  |
| PRODUCTION SAMPLE REQ<br>YES <input checked="" type="checkbox"/> NO                                |                     | MLO/ARTWORK<br>Not required   |  | PROD SAMPLE FURN<br>YES <input checked="" type="checkbox"/> NO         |   | ENGR NOTES<br><input checked="" type="checkbox"/> YES NO                     |
| APPROVED SOURCES   |                     |   |  |  |   |  |
| DESIGN ACTIVITY INFORMATION  |                     |   |  |  |   |  |
| CAGE   | REFERENCE<br>NUMBER | CONTRACTOR<br>NAME  | RNCC /<br>RNVC   | NAME   | ORGANIZATION/<br>OFFICE SYMBOL                                  | COMMERCIAL<br>PHONE  |
| 98747  | 858928-01           | OGDEN AIR LOGISTICS<br>CENTER   | 3 / 2  | Earl, Trevor L   | 418 SCMS/<br>GULABB   | 801-775-3891   |
| SUPPLIER INFORMATION   |                     |   |  |  |   |  |

| SOURCE TYPE  | CAGE            | REFERENCE NUMBER | CONTRACTOR NAME            | RNCC / RNVC               | NAME           | ORGANIZATION/ OFFICE SYMBOL | COMMERCIAL PHONE | DSN PHONE |
|--|-----------------|------------------|----------------------------|---------------------------|----------------|-----------------------------|------------------|-----------|
| V  | 81205           | 69-67265-1       | THE BOEING COMPANY         | 3 / 2                     | Earl, Trevor L | 418 SCMS/ GULABB            | 801-775-3891     | 775-3891  |
| N  | 98747           | 858928-01        | OGDEN AIR LOGISTICS CENTER | 3 / 2                     | Earl, Trevor L | 418 SCMS/ GULABB            | 801-775-3891     | 775-3891  |
| <b>SCREENING/EVALUATION/REMARKS</b>  |                 |                  |                            |                           |                |                             |                  |           |
| JUSTIFICATION FOR SUFFIX CODE OTHER THAN G   |                 |                  |                            |                           |                |                             |                  |           |
| ACTION TAKEN/BEING TAKEN TO IMPROVE COMPETITIVE STATUS   |                 |                  |                            |                           |                |                             |                  |           |
| REMARKS<br>NAME Earl, Trevor L                      DATE 23 JUL 2008<br>PROJECT RIGHTS GUARD APPLIES- THE DATA REQUIRED TO MANUFACTURE THIS ITEM IS CLAIMED TO BE PROPRIETARY TO BOEING. THE RIGHT OF THE GOVERNMENT TO USE THE DATA TO PURCHASE THIS PART FROM ADDITIONAL SOURCES HAS BEEN ESTABLISHED UNDER THE "RIGHTS GUARD DATA" BASIC ORDERING AGREEMENT F34601-92-D-1120, TO PROVIDE DOD PROCURING AGENCIES THE USE OF DATA FOR COMPETITIVE RE-PROCUREMENT OF REPLENISHMENT SPARES. |                 |                  |                            |                           |                |                             |                  |           |
| <b>MISCELLANEOUS INFORMATION</b>   |                 |                  |                            |                           |                |                             |                  |           |
| BUY HISTORY ( <i>Last 5 Buys</i> )   |                 |                  |                            |                           |                |                             |                  |           |
| AWARD DATE   | CONTRACT NUMBER | UNIT PRICE       | SUPPLIER CAGE              | SUPPLIER REFERENCE NUMBER | AMC/ AMSC      | AMOC                        | PLT              | TERM IND  |
|  |                 |                  |                            |                           |                |                             |                  |           |
| POTENTIAL SOURCES  |                 |                  |                            |                           |                |                             |                  |           |
| DESIGN ACTIVITY INFORMATION  |                 |                  |                            |                           |                |                             |                  |           |
| SOURCE TYPE  | CAGE            | REFERENCE NUMBER | CONTRACTOR NAME            | RNCC / RNVC               | NAME           | ORGANIZATION/ OFFICE SYMBOL | COMMERCIAL PHONE | DSN PHONE |
|  |                 |                  |                            |                           |                |                             |                  |           |
| SUPPLIER INFORMATION   |                 |                  |                            |                           |                |                             |                  |           |
| SOURCE TYPE  | CAGE            | REFERENCE NUMBER | CONTRACTOR NAME            | RNCC / RNVC               | NAME           | ORGANIZATION/ OFFICE SYMBOL | COMMERCIAL PHONE | DSN PHONE |
|  |                 |                  |                            |                           |                |                             |                  |           |