14153 **QAP-CSI012498556**
DTD 7 NOV 08

DEFENSE SUPPLY CENTER PHILADELPHIA
QUALITY ASSURANCE PROVISION

NSN: 5306-01-249-8556
P/N: 68A450777-2003

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: 15 OCT 2008

2. PR/MIPR NUMBER	3. PART NUMBER	4. NSN
	68A450777-2003	5306012498556SX

5. FIRST ARTICLE QUANTITY

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

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

6. ARTICLES

WILL [X] WILL NOT SERVE AS A MANUFACTURING

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 SPECIFICATIONS AND DRAWINGS IN THE CONTRACT.

B. The detailed technical requirements for First Article approval tests are contained in

ALL SPECIFICATIONS AND DRAWINGS IN THE CONTRACT.

(Cite Spec and Para number)

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

N/A

(Requesting Activity)

of test time and location due _____ 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 365 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) Governement written notice of approval/disapproval within 120 days after receipt of first article package.

G. Estimated cost of government testing/inspection evaluation.

$1,000.00

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 309 MXSG/MXRILV
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] Offers 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] Offers 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] Offers 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 Christensen, Tonya M DATE 15 OCT 2008
Cognizant Engineering Organization:
Name: TONYA M. CHRISTENSEN
Organization: 417 SCMS/GUEB
Phone: DESN 586-0083

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")

NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.

1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF:

BOLT, ACTUATOR ATTACH – NOSE LANDING GEAR (F-15)

2. PART NUMBER:	3. NATIONAL STOCK NUMBER:
68A450777-2003	5306-01-249-8556SX

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. SECTION AND ETCH FOR GRAIN FLOW, USE SAE AMS 6400 IN LIEU OF PS23006 AND SAE AMS-F-7190.

8. HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF PS15296.

9. 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.

10. STRESS RELIEVE AFTER GRINDING PER SAE AMS 2759 AND SAE AMS 2759/11 IN LIEU OF PS15063.

11. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF PS21201. 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.

12. UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130 IN LIEU OF PS16001. 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 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. MARKINGS FOR BOTH THE MRI AND HRI SHALL BE TO SAE AS9132. THE LOCATION OF THE UID SHALL BE THE SAME LOCATION AS IDENTIFIED ON THE DRAWING. 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 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.

PREPARED BY:	OFFICE SYMBOL:	DATE:
TONYA M. CHRISTENSEN	417 SCMS/GUEB	20081015

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, ACTUATOR ATTACH – NOSE LANDING GEAR (F-15)

2. PART NUMBER:	3. NATIONAL STOCK NUMBER:
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13. THREADS/MODIFIED FORM ROOT RADIUS PER SAE AS 8879 IN LIEU OF MIL-S-8879.

14. LOW EMBRITTLEMENT CADMIUM PLATE PER MIL-STD-870, IN LIEU OF PS13144.

15. CHROMIUM PLATE PER MIL-STD-1501, TYPE II, CLASS 2 IN LIEU OF PS13102.

16. FINISH ASSEMBLY PER THE FOLLOWING IN LIEU OF PS13646:

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.

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

17. SHOT PEEN PER SAE AMS 2430 IN LIEU OF PS14023. SHOT NUMBER PER SAE J444 IN LIEU OF MMS-224.

18. TEMPER ETCH PER MIL-STD-867 IN LIEU OF PS21205.

19. MATERIAL PER SAE AMS 6419 IN LIEU OF MIL-S-8844. ALTERNATE MATERIAL PER SAE AMS 6414 IN LIEU OF MIL-S—8844.

20. SURFACE ROUGHNESS PER ASME B46.1IN LIEU OF PS23041 AND PS20018.

21. DIMENSIONING AND TOLERANCING PER ASME Y-14.5 IN LIEU OF ANSI Y14.5-1966.

22. THE FOLLOWINGS SPECIFICATIONS ARE NOT REQUIRED FOR MANUFACTURE AND WILL NOT BE PROVIDED: 68A900000 AND 40M114.

23. SUBJECT COMPONENT HAS BEEN DESIGNATED AS A CRITICAL SAFETY ITEM (CSI):

CSI HEAT TREAT PER SAE AMS-H-6875
CSI MATERIAL PER SAE AMS 6419/ALT MATERIAL PER SAE AMS 6414
CSI GRIND PER MIL-STD-866
CSI INSPECT FOR ABUSIVE GRINDING PER MIL-STD-867
CSI SHOT PEEN PER SAE AMS 2430
CSI CADMIUM PLATE PER MIL-STD-870
CSI CHROMIUM PLATE PER SAE MIL-STD-1501
CSI SAFETY CRITICAL THREADS PER SAE AS 8879

PREPARED BY:	OFFICE SYMBOL:	DATE:
TONYA M. CHRISTENSEN	417 SCMS/GUEB	20081015

REVISION: 2

ENGINEERING DATA LIST

HISTORY

DATE:	DATA TECH:	ORGANIZATION/OFFICE SYMBOL:	END ITEM:	PAGE
15 OCT 2008	Villagomez, Vincent M	418 SCMS / GULABB	F-15	1 OF 1

CAGE:	MANUFACTURER NAME:	REFERENCE NUMBER:	NOUN:	NSN:
76301	MCDONNELL DOUGLAS CORPORATION A WHO	68A450777-2003	BOLT,SHOULDER	5306012498556SX

LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS
L	76301	68A450777	C		S		BOLT, ACTUATOR ATTACH - NOSE LANDING GEAR	NAME: Villagomez, Vincent M DATE: 15 OCT 2008 W/ PARTS LIST REV C.
L	98747	HILL AFB FORM 462			X		ENGINEERING DATA REQUIREMENTS (ATTACHMENT A)	

STANDARD ENGINEERING TEXT

FURNISHED METHOD CODE LEGEND:

C - CLASSIFIED DOCUMENT.
S - FURNISHED WITH SOLICITATION.
M - STABLE BASE DRAWING REQUIRED; FURNISHED WITH CONTRACT AWARD.

X - DATA SUPPLIED (NOT IN JEDMICS).
R - FURNISHED BY PCO UPON REQUEST.
P - PARTIAL DOCUMENT FURNISHED.
V - VENDOR DRAWING; (NOT PROVIDED).

G - GOV'T DOCUMENT.
O - OTHERS, CONTRACTOR MUST ACQUIRE.
A - DATA NOT AVAILABLE.