

14153 QAP-CSI012525374  
DTD 30 DEC 08

**DEFENSE SUPPLY CENTER PHILADELPHIA  
QUALITY ASSURANCE PROVISION**

**NSN: 5315-01-252-5374  
P/N: 68A450614-2003**

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

<b>FIRST ARTICLE REQUIREMENTS</b> <i>(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)</i>			1. DATE 12 DEC 2008
2. PR/MIPR NUMBER	3. PART NUMBER 68A450614-2003	4. NSN 53150125253748X	
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		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 with all dwgs and specs in the contract.</u>			
B. The detailed technical requirements for First Article approval tests are contained in <u>all the 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/MADLV</u> <i>(Requesting Activity)</i> of test time and location due <u>30</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			



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

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12. REMARKS

NAME                      Blommer, Michael J                      DATE                      12 DEC 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.

Mike Blommer  
F-15 Landing Gear Engineer  
801/777-6338

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: PIN, TRUNNION, NLG F-15		
2. PART NUMBER: 68A450614-2003	3. NATIONAL STOCK NUMBER: 5315-01-252-5374 LE	

14. SHOT PEEN PER SAE AMS 2430 IN LIEU OF PS14023. SHOT PEENING COVERAGE, INTENSITY, AND SHOT SIZE SHALL BE AS SPECIFIED BY THE DRAWING. EXCEPT FOR THREADS, USE HARD STEEL SHOT IN THE RANGE 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). FOR THE THREADS, GLASS BEAD PEEN WITH AN INTENSITY OF .004 - .008A.

15. LOW EMBRITTLEMENT CADMIUM PLATE PER MIL-STD-870, TYPE II, CLASS 2 IN LIEU OF PS 13144.

16. CHROMIUM PLATE TO MEET ALL DRAWING REQUIREMENTS PER MIL-STD-1501, TYPE II, CLASS 2 IN LIEU OF PS13102. 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. DIMENSIONING AND TOLERANCING PER ASME Y14.5 IN LIEU OF ANSI Y14.5.

18. FOR MATERIAL USE SAE AMS 6419 IN LIEU OF AMS 6419.

19. THE FOLLOWING ARE NOT REQUIRED FOR MANUFACTURE AND WILL NOT BE PROVIDED: 40M114, CPC 1850A100, AND 68A9000000.

20. THE FOLLOWING FEATURES AND PROCESSES ARE SAFETY CRITICAL. THE PROCESSES REFERENCED MUST COMPLY STRICTLY WITH THE SPECIFICATIONS REQUIRED BY CONTRACT.

DRAWING 68A450614PL

SHEET 1:

ADD CSI TO NOTES 3, 13, 15, AND 16

SHEET 2:

ADD CSI TO NOTES 20, 21, AND 22

CSI MATERIAL 300M PER SAE AMS 6419 (2 PLACES)

PREPARED BY: MIKE BLOMMER	OFFICE SYMBOL: 417 SCMS/GUEB	DATE: 12 DEC 2008
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ENGINEERING DATA LIST										*HISTORY*	
REVISION: 3		DATA TECH: Dalton, Thomas T		ORGANIZATION/OFFICE SYMBOL: 418 SCMS / GULABA		END ITEM: F-15		PAGE 1 OF 2			
CAGE: 76301		MANUFACTURER NAME: MCDONNELL DOUGLAS CORPORATION A WHO		REFERENCE NUMBER: 68A450614-2003		NOUN: PIN,HOLLOW		NSN: 5315012525374SX			
LINE /SUB	CAGE	ENG DRAWING NUM / ACCOMP DOC NUM	REV	NR SHEETS	FURN CODE	DIST CODE	NOUN	REMARKS	NAME: Dalton, Thomas T	DATE: 16 DEC 2008	
L	76301	68A450614	D		S		PIN, TRUNNION, NLG				
L	76301	PS23041	U		S		MACHINED PARTS ACCEPTANCE CRITERIA				
L	76301	PS20018	F		S		SURFACE FINISH REQUIREMENTS FOR ROUND HOLES		NAME: Dalton, Thomas T	DATE: 16 DEC 2008	
L	98747	418 SCMS/GULABB			X		ENGR DATA RQMTS (ATTACH A)				
STANDARD ENGINEERING TEXT											

ENGINEERING DATA LIST			*HISTORY*	
REVISION:	3			
DATE:	DATA TECH:	ORGANIZATION/OFFICE SYMBOL:	END ITEM:	PAGE
16 DEC 2008	Dalton, Thomas T	418 SCMS / GULABA	F-15	2 OF 2
CAGE:	MANUFACTURER NAME:	REFERENCE NUMBER:	NOUN:	NSN:
76301	MCDONNELL DOUGLAS CORPORATION A WHO	68A450614-2003	PIN,HOLLOW	5315012525374SX
<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>				

AMC/AMSC SCREENING ANALYSIS WORKSHEET REPORT					PRIORITY CATEGORY		
					02		
ITEM IDENTIFICATION AND INFORMATION							
NSN 5315012525374SX		NOUN PIN,HOLLOW		END ITEM F-15		PCC	ERRC N
QUANTITY 1	UNIT COST \$307.2000	IDENTIFYING NUMBER (Part No) R/N 68A450614-2003			CAGE 76301	TOP DWG REV NO.	
EST ANNUAL BUY VALUE \$307.20				COMM OFF-THE-SHELF ITEM YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> UNKNOWN			
NUC. CERT. END ITEM YES <input checked="" type="checkbox"/> NO UNKNOWN			HARD CRIT. IND YES <input checked="" type="checkbox"/> NO UNKNOWN				
NEXT HIGHER ASSEMBLY							
NSN		NOUN		R/N		CAGE	
SUMMARY OF SCREENING ACTION							
DESIGN DISCLOSURE <input checked="" type="checkbox"/>		SPEC CONTROL		SOURCE CONTROL		MIL/IND/CONTR PERF SPEC	
ST/STE REQUIRED YES <input checked="" type="checkbox"/> NO UNKNOWN		ST/STE AVAILABLE YES <input checked="" type="checkbox"/> NO UNKNOWN		DATA COMPLETE <input checked="" type="checkbox"/> YES NO UNKNOWN		DATA RIGHTS LIMITED YES <input checked="" type="checkbox"/> NO UNKNOWN	AAC D
AMC/AMSC 2 / C		AMC/AMSC EXP DT 16 DEC 2011		PRV AMC/AMSC /	PRV AMC/AMSC EXP DT		
AMC COMPLETION DT 16 DEC 2008				ENGINEER AMC/AMSC 2 / C			
USER TYPE	DATE/TIME IN	DATE/TIME OUT	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE	
Engineer	16 DEC 2008 / 1524	16 DEC 2008 / 1655	Blommer, Michael J	417 SCMS / GUEB	801-777-6338	777-6338	
Screening Technician	16 DEC 2008 / 1430	16 DEC 2008 / 1524	Dalton, Thomas T	418 SCMS / GULABA	801-586-0915	586-0915	
Engineer	16 DEC 2008 / 1417	16 DEC 2008 / 1430	Blommer, Michael J	417 SCMS / GUEB	801-777-6338	777-6338	
Screening Technician	26 NOV 2008 / 2012	16 DEC 2008 / 1417	Dalton, Thomas T	418 SCMS / GULABA	801-586-0915	586-0915	
PROCUREMENT SUPPORT REQUIRED							
FIRST ARTICLE TEST <input checked="" type="checkbox"/> YES NO			ENGINEERING DATA LIST REQ <input checked="" type="checkbox"/> YES NO			EXPORT CONTROLLED <input checked="" type="checkbox"/> YES NO	
PRODUCTION SAMPLE REQ YES <input checked="" type="checkbox"/> NO		MLO/ARTWORK Not required		PROD SAMPLE FURN YES <input checked="" type="checkbox"/> NO		ENGR NOTES <input checked="" type="checkbox"/> YES NO	
APPROVED SOURCES							
DESIGN ACTIVITY INFORMATION							
CAGE	REFERENCE NUMBER	CONTRACTOR NAME	RNCC / RNVC	NAME	ORGANIZATION/ OFFICE SYMBOL	COMMERCIAL PHONE	DSN PHONE
76301	68A450614-2003	MCDONNELL DOUGLAS	3 / 2	Dalton, Thomas T	418 SCMS/ GULABA	801-586-0915	586-0915

