

14153 QAP-CSI012641123 REV A

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**DEFENSE SUPPLY CENTER PHILADELPHIA  
QUALITY ASSURANCE PROVISION**

**NSN: 5315-01-264-1123  
P/N 2007405-25**

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>			<b>1. DATE</b> 14 JUL 2009
<b>2. PR/MIPR NUMBER</b>	<b>3. CAGE / REFERENCE NUMBER</b> 13002 / 2007405-25	<b>4. NSN</b> 5315012641123LE	
<b>5. FIRST ARTICLE QUANTITY</b> 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			
<b>6. ARTICLES</b> <input type="checkbox"/> WILL <input checked="" type="checkbox"/> WILL NOT SERVE AS A MANUFACTURING STANDARD		<b>7. LONG LEAD TIME ITEMS</b> <input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED <i>(See FAR 52.209-3 OR -4, alternate II)</i>	
<b>8. SPECIAL REQUIREMENT/PRODUCTION FACILITIES</b> <i>(See FAR 52.209-3 OR -4 Alternate I)</i> <input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> NOT REQUIRED <p style="font-size: small;">"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."</p>			
<b>9. TEST/INSPECTION REQUIREMENTS</b> 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>NA</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. <b>F. FIRST ARTICLE DELIVERY</b> (1) Due within <u>120</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>Hill Air Force Base, UT 84056-5713</u> <u>United States</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.

\$1,000.0000

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 \_\_\_\_\_ 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 Clark, Andrew R      DATE 14 JUL 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*)

Andrew R Clark  
417 SCMS  
801-775-6059  
775-6059

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: PIN, MLG DRAG BRACE            F-16		
2. PART NUMBER: 2007405-25	3. NATIONAL STOCK NUMBER: 5315-01-264-1123	

**4. MATERIAL REVIEW BOARD:**

4.1 417 SCMS/GUEB RETAINS ALL RIGHTS TO REVIEW AND ACCEPT MATERIAL REVIEW BOARD (MRB'S) DISPOSITIONS PRIOR TO SHIPMENT OF DISCREPANT ITEM. ALL DEVIATIONS, MINOR AND MAJOR, FROM THE ENGINEERING DRAWING PACKAGE SHALL BE SUBMITTED FOR MRB DISPOSITION.

4.2 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 MANUAL, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO 417 SCMS/GUEB.

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 THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.**

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

5.2 SURFACE ROUGHNESS PER ASME B46.1 IN LIEU OF ASA B46.1.

5.3 CADMIUM PLATE PER MIL-STD-870, TYPE II, CLASS 2, IN LIEU OF MM5542 AND MM4951. APPLIES TO ALL CADMIUM PLATED SURFACES.

5.4 HEAT TREAT PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875 AND MM4995.

5.5 CORROSION PROTECTION PER MIL-C-16173 CLASS II, GRADE 3, IN LIEU OF MM5752.

5.6 PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF MIL-I-6868. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO 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 INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURES DEVELOPED BY A LEVEL III AS SPECIFIED IN NAS-410.

5.7 FINISH ASSEMBLY PER THE FOLLOWING IN LIEU OF DRAWING NOTE 29 AND 32:

A. APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582 TYPE I CLASS C2 OR N USING FILL AND DRAIN METHOD. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377 TYPE I CLASS C2 OR N IN LIEU OF MIL-P-23377.

B. APPLY ONE TOPCOAT POLYURETHANE PER MIL-PRF-85285 TYPE I CLASS H COLOR NUMBER 17925 (WHITE) PER FED-STD-595 IN LIEU OF MIL-C-83286 COLOR NUMBER 17875.

5.8 USE MATERIAL 4330V MODIFIED STEEL PER SAE AMS 6411 IN LIEU OF AMS 6411.

PREPARED BY: ANDREW CLARK	OFFICE SYMBOL: 417SCMS/GUEB	DATE: 14 July 2009
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5.9 ON PARTS HEAT TREATED 180 KSI AND ABOVE, ANY SURFACES GROUND/MACHINED AFTER HEAT TREAT WILL BE INSPECTED FOR BURNS PER MIL-STD-867 IN LIEU OF MM5512. NO MORE THAN THREE SUCCESSIVE INSPECTIONS SHALL BE PERFORMED WITHOUT A WAIVER FROM 417 SCMS/GUEB. GRINDING WILL BE PER MIL-STD-866 IN LIEU OF MM5759.

5.10 CHROMIUM PLATE PER MIL-STD-1501, TYPE II, CLASS 2 IN LIEU OF QQ-C-320, CLASS 2. BASE METAL O.D. CAN BE UNDERSIZED UP TO .006 FROM DRAWINGS BASE METAL LEAST MATERIAL CONDITION TO ACCOMADATE TYPE II CHROME. BASE METAL DIMENSIONS APPLY AFTER SHOT PEEN, STOCK REMOVAL PER NOTE 6 DOES NOT APPLY TO UNDERSIZED DIAMETER, MINIMUM DIAMETER WILL NOT EXCEED .006 LESS THAN BASE METAL LEAST MATERIAL CONDITION. FINAL GROUND FINISH WILL BE RMS 32 IN LIEU OF THE DRAWINGS RMS 63.

5.11 SHOT PEEN PER SAE AMS 2430 IN LIEU OF MIL-S-13165. SHOT PEENING INTENSITY AND SHOT SIZE SHALL BE AS SPECIFIED BY THE DRAWING. FOR STEEL PARTS HEAT TREATED TO 200 KSI OR ABOVE, 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).

5.12 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.

5.13 DRY FILM APPLICATION NOT REQUIRED PER EO 06A0720.

5.14 THIS PART HAS BEEN DESIGNATED CSI (CRITICAL SAFETY ITEM), SEE EO 06A0720 FOR MATERIALS/PROCESSES THAT HAVE BEEN DETERMINED TO BE SAFETY CRITICAL.

5.15 UNIQUE IDENTIFICATION (UID) SHALL BE APPLIED TO EACH PART PER MIL-STD-130 IN LIEU OF TM1040. THE UID SHALL BE A MACHINE-READABLE INFORMATION (MRI) MARK. THE MRI SHALL BE ACCOMPLISHED BY A HUMAN-READABLE INFORMATION (HRI) MARKING WHICH IS 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. MARKINGS FOR BOTH THE MRI AND HRI SHALL BE PER SAE AS9132 WITH AN ALLOWABLE DEPTH OF .003 TO .005 INCHES POST HEAT TREAT APPLICATION. THE LOCATION OF THE HRI COMPONENT OF THE UID SHALL BE AS SPECIFIED ON DRAWING 2007405. THE METHOD OF MARKING FOR THE HRI SHALL BE DOT PEEN OR VIBROPEEN. THE METHOD OF MARKING FOR THE MRI SHALL PRINTED ON AN ADHESIVE LABEL AND APPLIED TO THE PARTS PACKAGING. THE MRI MARK SHALL CONTAIN HRI EQUIVALENT INFORMATION IN BOTH 2D MATRIX FORM AND IN HUMAN READABLE FORM.

PREPARED BY: ANDREW CLARK	OFFICE SYMBOL: 417SCMS/GUEB	DATE: 14 July 2009
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