

FIRST ARTICLE REQUIREMENTS

(AFMCI 64-110, AFMCI 23-102 AND FAR Part 9, Sub Part 9.3) (Additional instructions on page 3)

1. DATE
8 Mar 04

2. PR/MIPR NUMBER

3. PART NUMBER

4042333

4. NSN

2840-00-516-7764

5. FIRST ARTICLE QUANTITY

THE FIRST ARTICLE IS 3 UNIT(S) OF LOT/ITEM 1

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

6. ARTICLES

WILL WILL NOT SERVE AS MANUFACTURING STANDARD

7. LONG LEAD TIME ITEMS

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)*

REQUIRED NOT REQUIRED

"The First Article offered must be manufactured at the facilities in which that item is to be produced under 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 GOVERNMENT TESTING

Performance or other characteristics which the First Articles must meet are identified in drawing 4042333 and specifications identified therein.

B. The detailed technical requirements for First Article approval tests are contained in Block 12 of this form and LPE-QAR-003.

(Cite Spec and Para number)

C. TEST PLAN REQUIRED

- (1) DD Form 1423 ELIN A001
- (2) Delivery due 30 calendar days from date of contract.
- (3) Number of days for government approval/disapproval 45 days.

D. Contractor's notification to ACO and PCO *(Requesting Activity)* of test time and location due 10 days prior to start of testing.

E. TEST REPORT REQUIRED

- (1) DD Form 1423 ELIN A002
- (2) Due 120 calendar days from date of contract.
- (3) Forward to PCO and OC-ALC/ENRS, 3001 Staff Dr., Suite 2074, Tinker AFB, OK 73145-3036 Attn: FA Monitor
~~DoAAC: FA 8111~~
- (4) Government written notice of approval/disapproval due 60 days after receipt of contractor's report.

F. FIRST ARTICLE DELIVERY:

- (1) Due within _____ calendar days from date of contract.
- (2) Notify _____ calendar days prior to shipment.
- (3) Delivered to government at _____

(Set Forth Consignee and Address)

(4) Government written notice of approval/disapproval within _____ days after receipt of first article package.

G. Estimated cost of government testing/inspection evaluation.

\$ _____

10. DISPOSITION OF FIRST ARTICLES

Approved First Articles will be forwarded to Air Force 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 _____ 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: See Block 12 of this Form.

ENRS/ALC/ENRS/3001

2. PR/MIPR NUMBER	3. PART NUMBER 4042333	4. NSN 2840-00-516-7764
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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 X Government, X DoD, X 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 article to the X Government, X DoD, X Air Force, provided articles thus furnished, have exhibited satisfactory performance in service in the opinion on 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 THE DECISION. The buyer must solicit dual prices *that is, both with and without requirement for first article approval* AND MUST FURNISH THE COGNIZANT ENGINEER 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

9.B. First article test requirements shall be per LPF-QAR-003 and the following:

- a. All three first articles shall be inspected in accordance with the requirements of paragraphs 3.1, 3.2, 3.3, 3.4, and 3.5 of LPF-QAR-003.
- b. After completion of inspections per 9.B.a above, one article shall be destructively tested/evaluated in accordance with the requirements of paragraph 3.6 of LPF-QAR-003.

10. Disposition of first Articles:

- a. Approved first article(s) will be retained at the contractor's facility for reconditioning (if necessary) with final acceptance the same as for production items. If a first article is expended in testing, approval of first article will constitute acceptance.
- b. Disapproved first article(s) shall be retained at the contractor's facility, unless specified otherwise by the PCO.

11. The cognizant Government engineering authority shall be the final authority for determining if a contractor meets the conditions of waiver identified in 11.a or 11.c.

First article testing is waived if the offeror is the prime contractor, Pratt & Whitney.

This is a critical part used in the F100 series turbine engine. Poor quality parts will have an adverse effect on mission capability and system safety. For this reason, First Article Testing is required to insure first time manufacturers or manufacturers that have not produced the item within three years manufacture parts in accordance with the drawing and specification requirements.

13. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING AND/OR APPROVING TEST (Name, Organization, Phone)

Jolly C. Sartor Jr., OC-ALC/LPFRB, (405) 734-8786

14. PR INITIATOR (Name, Organization, Phone)



**LPF-QAR- 003
LPFR QUALITY ASSURANCE
REQUIREMENTS
FOR
FIRST ARTICLE TEST PLANS & REPORTS**



1. This document provides guidelines for the preparation of first article test plans/test reports for F100 engine parts where referenced within the first article data of a contract.
2. **FIRST ARTICLE QUANTITY.** The quantity of first articles shall be per the contract. The quantity of articles allowed for destructive testing, in accordance with the contract, shall be tested per the first article procedure in its entirety, to include the destructive testing. The remaining articles shall only be tested per the nondestructive portions of the procedure.
3. **TESTING REQUIREMENTS.**
 - 3.1. Testing shall consist of, but shall not be limited to, the verification of the following.
 - 3.1.1. Dimensional conformance including finish requirements.
 - 3.1.2. Conformance to non-destructive inspection requirements (FPI, Ultra-sonic, Eddy Current, X-ray, visual)
 - 3.1.3. Conformance of material properties to include mechanical, metallurgical and chemical.
 - 3.1.4. Conformance to other required processes, specifications, and standards listed on the drawing including sub-tier specifications and standards, special requirements as described in the engineering instructions (EI), quality plans, etc.
 - 3.2. First articles shall be serialized. Serial Numbers are to be identified prior to commencement of testing unless otherwise specified.
 - 3.3. Dimensional Inspection.
 - 3.3.1. All dimensions, as listed on the assembly drawing and detail drawings, to include drawing notes, shall be measured where possible on all first articles 100% (no sampling allowed).
 - 3.3.2. A tabular format shall be used with drawing dimension, tolerance, measurement, and instrument/gage/tooling/serial number used.
 - 3.3.3. All tooling and gaging used for inspection and acceptance/rejection of first articles shall have calibrations from a laboratory traceable to NIST and in

accordance with ISO 10012-1 (formerly MIL-STD-45662), listed in a (tooling & gaging table) table, table shall include nomenclature, serial number, calibration frequency, next calibration date, range, least increment, and accuracy. Listing shall also include alignment tools and constraint fixtures.

3.3.4. Inspection results shall be presented in a table showing the feature measured, dimension and tolerance, actual reading and gage serial number used.

3.4. Nondestructive Inspections (NDI), including Fluorescent Penetrant Inspections (FPI), Ultrasonic Testing (UT), Eddy Current (EC), Radiographic Testing (x-ray), and visual inspections, shall comply with LPR-QPR-018 and meet the following:

3.4.1. All first articles shall receive 100% of the inspections identified on the QAD. Sampling shall not be allowed.

3.4.2. NDI shall be per the applicable specification(s).

3.4.3. Sources used shall be Pratt & Whitney approved per the OC-ALC/LPFR letter granting source approval to the contractor.

3.4.4. NDI results shall be presented in a table showing the feature inspected, acceptance/rejection criteria used, results and gage/master serial number used. In cases where photographic standards within a VIS specification are applied to an NDI, the inspection report shall include a copy.

3.4.5. Inspection Masters/Transfer Masters shall have current calibrations. A copy of the calibration(s) shall be included into the report.

3.4.6. Level III or Level II inspectors, as applicable, shall be required. A copy of the inspector's certification(s) shall be included into the report.

3.5. Visual Inspections shall include:

3.5.1. Specific visual inspections per a Pratt & Whitney Visual Inspection Standard (VIS) document shall be called out of the applicable VIS and cited as specific inspections.

3.5.2. Visual inspection results shall be presented in a table showing the feature inspected, acceptance/rejection criteria used, results, and gage/master serial number used (as applicable).

3.5.3. In cases where photographic standards within the VIS are used, the inspection report shall include a copy.

3.6. Material properties testing shall include mechanical properties, metallurgical properties, and chemical composition tests, as applicable, per the material specifications and the following:

3.6.1. Composition, heat treat condition, and other characteristics/properties, as listed in the technical requirements section, acceptance section, and/or quality sections of the specification(s) so as to verify that the materials and processes are sound, clean, and free of imperfections detrimental to the performance of the part or assemblies.

3.6.2. In some cases a material suppliers certification will not be sufficient and the Contractor shall have redundant testing performed.

3.6.3. Metallurgical microanalysis, as applicable, for raw materials, welds, brazings, and coatings shall be conducted. Results shall include the complete laboratory report including photomicrographs.

3.6.4. Mechanical testing, as applicable, per manufacturing specifications and the drawing(s).

3.6.5. In cases where the applicable specifications require test reports, these shall accompany the First Article Test Report (FATR).

4. SUBMITTAL.

4.1. The First Article Test Plan (FATP) shall be delivered to the Contracting Officer in accordance with the schedule as listed in the contract, or Form DD1423. The FATP shall provide a detailed description of specific testing instructions to be used. Generalized instructions will not be acceptable.

4.2. The First Article Test Report (FATR) shall be delivered to the Contracting Officer in accordance with the schedule as listed in the contract, or Form DD1423. All laboratory test results, including those resultant from testing conducted at the contractor's facility and including sub-vendor testing, shall be provided with the FATR in their complete form as provided by the testing laboratory(ies).

5. DISPOSITION OF PARTS.

5.1. When required by the contract, the remnants from destructive testing shall be delivered with the First Article Test Report.

5.2. When required by the contract and following the completion of non-destructive testing, one article shall be delivered to the Contracting Officer and packaged in accordance with contract requirements. Marking on the package shall be

UNSERVICEABLE - Condition Code "R". Deliver this part with the First Article Test Report. The other(s) shall be handled in accordance with the contract.

6. GENERAL REQUIREMENTS.

6.1. All First Articles and all Production Articles shall be fabricated from material whose metallurgical state is in compliance with the drawing requirements, as well as all sub-tier specifications and standards referenced therein.

6.2. All First Articles and all Production Articles shall be new manufactured under this contract. No items manufactured under previous contracts shall be delivered without approval.

6.3. The subcontractors previously identified by the contractor as sources to be employed, to include laboratory testing, shall be the only sources used. If the contractor wishes to employ a subcontractor other than previously identified, they shall substantiate that the new source is OEM approved for the specific testing required. A change in the address of a source shall be construed as a change of source. Employment of alternate sources shall only be authorized by OC-ALC/LPFR.

Engineering Instructions shall take precedence over all other technical instructions.



GRIZELDA LOY-KRAFT, Chief
F100 Engineering Source Approval
Fighter Propulsion Division
Propulsion Directorate

QUALIFICATION REQUIREMENTS
FOR MANUFACTURE OF F100 ENGINE PARTS

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I. HARDWARE DESCRIPTION

- A. Nomenclature:
Support-Assy of, Augmentor Spray Manifold
- B. Function:
Provides the support for the augmentor sprayrings in the F100 engine.
- C. Material Composition:
AMS 5706 and 5544 Nickel alloy

II. REFERENCE DOCUMENTS

- LPF-QAR-004** - General Quality Assurance Requirements for F100 Engine Components.
- LPF-QPR-004** - LPFR Quality Plan Requirements for Welded Assemblies.

III. JUSTIFICATION FOR QUALIFICATION REQUIREMENTS

Ref.: FAR Subpart 9.2, AFMCFAR Subpart 5309.2

The following paragraphs provide the justification for qualification requirements for this part.

A. Criticality of Part:

This is a Critical Application Item (CAI) used on the F-15 and F-16 aircraft primary propulsion system, the Pratt & Whitney F100 engine. Failure of this part can result in secondary damage to the engine and subsequent mission abort.

B. Complexity of Part:

This part requires special manufacturing processes and techniques. These processes are specified on the drawing, however, they are not common knowledge among all vendors. Therefore, a vendor's capability to perform the processes must be demonstrated.

C. Government Risk:

The following paragraphs document the reasons why the risk to the government of buying this part from an unqualified source is compound.

1. The probability of an unqualified source producing an unsatisfactory part is high.
2. The probability of an unqualified source failing to produce within schedule is high.
3. A high potential exists for an unqualified source to underestimate the manufacturing difficulty and miss critical delivery schedules.

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FOR MANUFACTURE OF F100 ENGINE PARTS

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4. Untimely delivery critically impacts end item overhaul/repair schedules. Failure to deliver on schedule may result in additional high cost emergency procurements.
 5. An inferior part can cause extensive damage to the end item resulting in a high cost of repair.
- D. There are no costs incurred by an offeror for qualification testing and testing evaluation under the requirements of paragraphs VI.A or VI.B. However, the offeror's development of a Source Approval Request (SAR) package to be submitted for Government evaluation may cost as much as \$2500. In addition, the cost incurred by offerors for Government evaluation of their SAR submitted under the requirements of paragraphs VI.A or VI.B may be as much as \$1,200. This cost may be borne by the Government if it is in the best interest of the Government to qualify alternate sources.

IV. JUSTIFICATION FOR QUALIFICATION PRIOR TO CONTRACT AWARD

Ref.: AFMCFAR Subpart 5309.2

The following paragraphs provide the rationale for requiring a demonstration of the qualification requirements prior to contract award.

- A. The risk of default by the contractor must be minimized as the shortest combined administrative and production lead-time is over 22 months.
- B. The technical risk must also be minimized due to the criticality of the part (Reference the section "Criticality of Part" in paragraph III.A).
- C. The manufacturing and processing techniques are critical to performance and reliability (Reference the section "Criticality of Part" in paragraph III.A).
- D. The risk to the government in determining a potential vendor's capability without an actual demonstration of that capability must be minimized. The expertise that is required to manufacture this part is not commonly available or easily obtained and therefore must be demonstrated. (Reference the section "Complexity of Part" in paragraph III.B).

V. DATA AND DOCUMENTATION REQUIREMENTS

The following paragraphs document the data that must be submitted with a request for source approval. All documentation submitted shall be the latest revision published. Documentation shall be bound (preferably a three ring binder) with a table of contents and corresponding sections tabbed.

- A. The potential Offeror must substantiate that they possess latest revision of the following data by providing a copy in the source approval package, or must provide DCMA or other government representative written verification that the potential vendor has the latest revision of the following data:

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FOR MANUFACTURE OF F100 ENGINE PARTS

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1. Drawing Number: 4042333 (Including all sub-assembly or detail drawings specified on this drawing number)
 2. Quality Assurance Data (QAD): 4042333 As applicable, include the QAD for each sub-assembly or detail part listed on the above drawing.
 3. All applicable specifications called out on the drawing, and/or assembly and detail drawings, and on the QAD (as applicable). These include:
 - a) Process Specifications
 - b) Inspection Processes
 - c) Material Specifications
- B. The potential Offeror's Quality Assurance System must meet or exceed the requirements described in the attached document LPF-QAR-004.
- C. The vendor shall supply a list of all manufacturing and inspection processes that will be performed, both in-house or by sub-vendors. The vendor shall substantiate that sources to be employed for any significant process, including themselves, with the exception of conventional metal removal processes, are currently approved by Pratt & Whitney (P&W) for the specific process required or another OEM for an equivalent process. The vendor must supply the name and address of each certified vendor to be used. In all cases where process approval is relative to an OEM process specification other than Pratt & Whitney, the vendor shall provide the complete specification and demonstrate the equivalence of the specifications.

VI. SUBSTANTIATION OF MANUFACTURING CAPABILITY

The following paragraphs document the methods to be used to substantiate a vendor's capability to manufacture this item.

- A. A vendor who has manufactured the item for the prime contractor (P&W), another engine OEM, or for other United States Department of Defense users of the same item within the last five years may be approved as a source for the part provided the vendor was responsible for all material procurement, inspection, and finishing of the end item, i.e., the prime manufacturer, P&W, or other engine OEM did not add any value to the end item. The vendor must submit evidence of the scope of work for the part indicating that they had primary responsibility for all operations necessary for the completion of the part for delivery to the customer. This evidence shall include MANUFACTURING PROCESS SHEETS.
- B. Other vendors will be considered for approval on the basis of their ability to manufacture a similar item for the prime contractor (P&W), another engine OEM, the United States Department of Defense, or a NATO country. The following conditions must be met for approval by similarity:
 1. Submit evidence of the successful manufacture and sale of the similar item, to include purchase orders and shipping documents reflecting production quantities within the last five

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FOR MANUFACTURE OF F100 ENGINE PARTS

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- years. This evidence must document that the vendor had primary responsibility for all operations necessary to produce the similar item, and that the similar item was accepted by the customer. Also include a summary of quality deficiencies experienced within the last two years of production of the similar item(s) with coordination from the Q. A. manager. The vendor shall provide SPECIFIC similarities and differences between the subject part and the similar part.
2. The vendor shall substantiate that the similar component(s) submitted will satisfy the following criteria:
 - a) Fabricated of the same alloy or an alloy from the same alloy family, e.g. Alpha Titanium's, Inconels, Austenitic Stainless Steels.
 - b) Illustrates the ability of the vendor, in conjunction with their sub-vendors, to perform all significant processes to be employed and maintain requisite tolerances and surface finish requirements.
 - c) The data must also show that the manufacturing and inspection/test processes for the similar part demonstrate the full range of difficulty required for the subject part. Included in this data shall be complete MANUFACTURING PROCESS SHEETS for the similar item.
 3. A first article requirement may be included in any contract resulting from approval based upon similarity. The estimated cost of first article testing is \$1,000.00. These tests may include material properties analysis, dimensional analysis, and possibly rig test. At least three first articles would be required with one first article requiring destructive testing.

VII. RESPONSIBLE ENGINEERING ORGANIZATION

The responsible organization for establishing these qualification requirements is the F100 Engine Engineering Branch, within the Fighter Propulsion Division of the Oklahoma City Air Logistics Center, Tinker Air Force Base, Oklahoma.



GRIZELDA LOY-KRAFT, Chief
F100 Engine Source Approval
Fighter Propulsion Division
Propulsion Directorate

GENERAL QUALITY ASSURANCE REQUIREMENTS
FOR
F100 ENGINE COMPONENTS

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1 APPLICATION

These requirements apply to all F100 engine parts.

2 PURPOSE

This document establishes the minimum technical requirements that prospective sources must satisfy to obtain engineering approval of their quality system. All documentation provided as evidence of compliance with requirements specified herein must be in English. Engineering source approval shall be valid for five years from the date of the OC-ALC letter notifying the contractor of engineering source approval.

3 REQUIREMENTS

3.1 The Offeror must provide a Quality Assurance Manual that accurately portrays their current quality assurance system. The Quality Assurance System must meet or exceed the requirements as described in this document. Additionally, the Quality Assurance System must satisfy one of the following:

3.1.1 Certified to ISO 9002 by the American National Standards Institute (ANSI) or the International Standards Organization (ISO) in Geneva, Switzerland, or

3.1.2 Previously certified within the last three (3) years to MIL-I-45208A plus paragraphs 3.1 through 3.5, 5.1, 5.2, 6.1, and 6.2 of MIL-Q-9858A by the DCMC or other appropriate government Quality Assurance Representative, or

3.1.3 Approved by the Original Equipment Manufacturer (OEM).

3.2 Proof of certification/approval must be provided and must be dated within the last three (3) years. The decision to approve or disapprove the Quality Assurance System shall only be made after a thorough review of the Offeror's Quality Assurance Manual by the cognizant engineering authority, OC-ALC/LPFR.

3.3 Copies of the latest document(s) which describe and govern the quality assurance system in effect at the Offeror's facility(ies). If provided within the last year and no significant changes have been incorporated this requirement may be waived. However, OC-ALC/LPFR as the cognizant engineering activity for the F100 engine reserves the right to request an additional copy in the event the previous submittal cannot be located.

3.4 P&W documentation identifying the specific conditions/restrictions (i.e., specific P/Ns, components, processes, or material this status applies to, production testing required for material release, testing the LCS supplier is authorized to perform, etc.) imposed by P&W with regard to Laboratory Control at Source (LCS) Supplier status if Offeror is a P&W-approved LCS Supplier. The fact that a sub-vendor is a P&W LCS Supplier shall not relieve the Supplier of the responsibility of conducting follow-on quality assurance surveillance to ensure that sub-vendors are providing conforming material.

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- 3.5 Evidence that the emphasis in quality assurance planning is placed upon controlling processes to preclude generation of non-conformance's and is supplemented by sufficient inspections or tests to assure effective process control.
- 3.6 Offeror procedures/specifications governing the control of significant processes proposed for use in the fabrication of the approval item for assuring that:
- 3.6.1 Only Purchaser approved sources are used for raw material, significant processes, and major sub-components and adequate consideration is given to a source's capability and performance prior to placing an order.
 - 3.6.2 The quality acceptance standards imposed in routine production acceptance both in-house and by sub-vendors are complete and approved by P&W and the test methods employed in routine production acceptance are sufficient to verify compliance with these standards.
 - 3.6.3 Fabrication performed in-house and by sub-vendors is accomplished in accordance with work instructions specified in manufacturing process sheets, schedules, and/or technical control plans which define the exact sequence of all production operations and all process variables and all critical parameters of manufacturing operations which may directly affect material structure, mechanical properties, surface finish and/or direction or lay of the cutting action. The procedure shall also assure that work instructions have been approved by the customer.
 - 3.6.4 All inspection of characteristics, which serves as the basis for final acceptance of a characteristic, including in-process inspections, are performed in accordance with work instructions specified in inspection method sheets which define all characteristics specified on the applicable P&W drawings and Quality Assurance Documents (QAD's), the classification of each characteristic, the Acceptable Quality Level (AQL) for each classification of characteristic, sample size, frequency of inspection, the specific inspection methodology to be utilized, and the required instrumentation. The procedure(s) shall also assure that all inspection method sheets have been approved by the customer.
 - 3.6.5 Specific Offeror audit procedures/guidelines which pertain to process and product audits performed both in-house and at sub-vendor facilities. These procedures shall, as a minimum assure:
 - 3.6.5.1 Strict adherence to the sequence, parameters, and all other significant process variables of manufacturing operations defined on manufacturing process sheets approved by the customer is maintained both in-house and at sub-vendors' facilities. Specific procedures for auditing and/or controlling requisite significant processes must be provided.
 - 3.6.5.2 Dedicated equipment is properly maintained and calibrated and is capable of adequately performing its intended application.
 - 3.6.5.3 General housekeeping and manufacturing practices employed do not adversely affect the quality of the end product.

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- 3.6.5.4 Established process controls and production acceptance plans are providing products which conform to the Purchaser requirements.
- 3.6.6 Specific Offeror procedures for assuring that certificates of test or conformance provided by sub-vendors of raw material and significant processes are complete and supported by process data and numerical test results from an OEM-approved laboratory for the requisite testing, are representative of material received, and the material is in conformance with Purchaser requirements.
- 3.6.7 Adequate records are retained for documenting sub-vendor lists, sub-vendor quality ratings, layout inspection reports, all Purchaser and OEM approvals, component traceability, and objective evidence of conformance to product, process, and quality acceptance requirements; and are available to the Purchaser upon request.
- 3.6.8 Evidence of a system for controlling non-conforming material to ensure:
- 3.6.8.1 The classification of all non-conforming characteristics in terms of critical, major, and minor is approved by the Purchaser.
 - 3.6.8.2 Final disposition of all non-conforming critical and major characteristics including rework and repair is approved by the Purchaser prior to implementation.
 - 3.6.8.3 Effective control of non-conforming material at sub-vendor facilities.

----- **END OF DOCUMENT** -----

**LPFR QUALITY PLAN REQUIREMENTS
FOR
WELDED ASSEMBLIES**

1. APPLICATION.

1.1 This plan applies to all F100 engine welded assemblies which are used in structural applications and are classified as fracture critical or durability critical parts.

2. PURPOSE.

2.1 This document establishes the minimum documentation required for a quality plan for the purpose of assuring that effective process control is maintained for the specified applications. All documentation provided as evidence of compliance with requirements specified herein shall be in English.

3. REQUIREMENTS.

3.1 **General.** The Offeror shall submit a Quality Plan specifically tailored to F100 engine applications requiring fusion and/or resistance welding. The Quality Plan shall be identified by: document number, issue date, and revision date. AWS D17.1, Specification for Fusion Welding for Aerospace Applications and MCL data shall be used for performance, procedure and personnel qualification. Where conflicts occur, the most stringent requirement shall apply.

3.2 **Purchasing.** Specific purchase order requirements to be imposed on subvendors of welding, weld filler material, heat treatment, cleaning, radiographic inspection, fluorescent penetrant inspection, and laboratory testing to control processing and production acceptance testing. The requirements shall address certification and control of weld processes, control of weld filler rod, certification of welders and NDT personnel, processing of significant process changes, maintenance of heat identification, production acceptance testing to be performed, acceptance/rejection criteria, and testing frequency.

3.3 **Overtesting.** Overtesting shall be conducted in addition to the production acceptance testing conducted by the process supplier. A detailed test plan shall be included for specific overtesting/overinspection to be conducted by or under the direction of the Offeror, on welds and heat treated material when these processes are subcontracted. In the event these processes are performed in-house the test plan shall define in-process testing and overtesting performed as quality assurance measures. More extensive overtesting shall be required on material, which is subcontracted for welding and/or heat treatment. The test plan(s) as a minimum shall include the following:

3.3.1 Identification of test specimen type (actual production article, scrapped parts, integral test piece, or separate representative test piece), description (configuration and dimensions), and heat treat condition.

3.3.2 Frequency of overtesting. For welds the plan shall specify frequency per weld process, material group and joint type.

3.3.3 The specific testing to be conducted on each specimen and the acceptance/rejection criteria. Overtesting and in-process inspection shall include microexamination of weld cross sections including the heat-affected zone, per MCL sections and AWS D17.1 Class B, unless otherwise specified, where conflicts occur, the most stringent shall apply.

3.3.4 Identity of the laboratory(ies) to conduct the testing. The Offeror shall substantiate that the laboratory is a P&W-approved laboratory for the specific testing required and has access to all applicable MCL sections pertaining to acceptance/ rejection standards and AWS D17.1/B2.1. Laboratories utilized for overtesting shall be autonomous from the source responsible for production acceptance testing. The plan shall also address any additional nondestructive testing, i.e, radiographic, FPI to be conducted as an overinspection by a source autonomous from the source that performed the production acceptance testing. The Offeror shall substantiate that P&W approved the laboratory and NDT source(s).

3.3.5 Identity and background of personnel responsible for reviewing the results of radiographic inspection and laboratory testing including metallography.

3.3.6 Procedures for identification of test pieces, retention of test pieces, and retention of test data.

3.4 **Audits.** Specific procedures shall be provided for performing on-site audits of sources of welding, heat treat, and radiographic inspection, and fluorescent penetrant inspection, including the Offeror, which shall as a minimum identify:

3.4.1 The specific procedures, guidelines and checklists for conducting on-site process audits of sources of cleaning, welding, heat treatment, and NDT including furnace control and the frequency at which they will be conducted. For fracture critical parts, process audit procedures shall also be provided for laboratory testing.

3.4.2 The specific procedures, guidelines and checklists for conducting on-site product and system audits of sources of welding, heat treatment, and NDT, and the frequency at which they will be performed. For fracture critical parts, the Offeror shall also identify similar procedures for laboratory testing.

3.4.3 The specific procedures identified shall also be provided with the Quality Plan unless previously provided. In the event that they have been previously provided the Offeror shall so indicate.

3.4.4 The personnel conducting the audits including their specific background and experience relative to the processes and products to be reviewed.

3.4.5 Procedures for promptly notifying OC-ALC/LPFR of major deficiencies noted during audits.

3.5 **Certification and Control of Weld Processes.** The Offeror shall provide the following procedures:

3.5.1 A Procedure Qualification Record (PQR) per AWS B2.1 and the master weld process procedures, which as a minimum include the method and materials for cleaning each material group, establishment, qualification, and control of operation sheets and weld schedules, in-process inspections for assuring process control, calibration of welding equipment, control of weld filler rod, repair of welds, and maximum number of passes allowed. The welders must be certified per AWS D17.1, to the specific materials, specific thickness, specific joint type (groove, fillet, etc.), and position. When Class A welds are specified by class or equivalent inspection criteria, the welder must be certified to Class A inspection criteria.

3.5.2 Specific procedures for training of welders.

3.5.3 Certification procedures for welders per AWS D17.1 (including recertification) and a PQR per AWS B2.1 and Welding Procedure Specification (WPS), including, for the grouping of materials and joint types for certification purposes, identification of test specimens (representative test pieces, scrapped parts, etc.), configuration of test specimens, number of passes, maximum number of qualification tests the operator is allowed to fail before becoming ineligible, the specific testing performed, and the acceptance/rejection criteria for each test.

3.5.4 Welder certification procedures shall identify the time between certifications, the organization responsible for the certification, the agency to which the certification is traceable.

3.6 NDT Quality System. The specific quality system procedures for each NDT process required in the inspection of welds on the approval item shall be provided. In cases where the required NDT process is performed by a subvendor, procedures shall be provided for assuring that an adequate NDT Quality System is maintained. The procedures as a minimum shall include:

3.6.1 Process control procedures for each NDT process.

3.6.2 Specific procedures for certifying and training NDT personnel.

3.6.3 Calibration procedures for NDT gage standards including working masters and transfer masters. These procedures shall provide assurance that working masters are properly calibrated with transfer masters which have been properly calibrated with the grand master.

3.6.4 The certification procedures shall identify the time between certifications, the organization responsible for the certification, the agency to which the certification is traceable.

3.7 Processing Nonconforming Material. Procedures shall be provided for processing nonconforming welds including repair procedures and procedures for promptly notifying OC-ALC/LPFR of major nonconformances.

3.8 Traceability. Provide specific plan for assuring the traceability of the welded assembly where serialization is required by the component drawing, to the original master heat.