

FIRST ARTICLE REQUIREMENTS			1. DATE
(AFMCI 64-110, AFMCI 23-102 and FAR Part 9, Sub Part 9.3) (Additional Instructions on Page 3)			20020412
2. P/R/MIPR NUMBER	3. PART NUMBER 35-23797-508	4. NSN 5340009548087FG	
5. FIRST ARTICLE QUANTITY THE FIRST ARTICLE IS <u>2</u> UNIT(S) OF LOT/ITEM <u>pre-production</u> AND WILL BE: <input checked="" type="checkbox"/> PART OF PRODUCTION QUANTITY <input type="checkbox"/> IN ADDITION TO PRODUCTION QUANTITY			
6. ARTICLES <input type="checkbox"/> WILL <input checked="" type="checkbox"/> WILL NOT SERVE AS A MANUFACTURING STANDARD		7. LONG LEAD TIME ITEMS <input checked="" type="checkbox"/> REQUIRED <input type="checkbox"/> 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 <input type="checkbox"/> 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		F. FIRST ARTICLE DELIVERY:	
A. <input type="checkbox"/> CONTRACTOR TESTING <input checked="" type="checkbox"/> GOVERNMENT TESTING Performance or other characteristics which the First Articles must meet are <u>35-23797, MATERIAL/PROCESS</u>		(1) Due within <u>180</u> calendar days from date contract.	
B. The detailed technical requirements for First Article approval tests are contained in <u>35-23797, and form fit check on NEXT HIGHER ASSY</u> <i>(Cite Spec and Para number)</i>		(2) Notify <u>30</u> calendar days prior to shipment.	
C. <input type="checkbox"/> 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.		(3) Delivered to government at <u>see remarks in block 12</u>	
D. Contractor's notification to ACO and _____ <i>(Requesting Activity)</i> of test time and location due _____ days prior to start of testing.		<i>(Set Forth Consignee and Address)</i> (4) Government written notice of approval/disapproval within <u>90</u> days after receipt of first article package.	
E. <input type="checkbox"/> 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.		G. Estimated cost of government testing/inspection evaluation. \$ <u>\$3,000.00</u>	
10. DISPOSITION OF FIRST ARTICLES			
<input type="checkbox"/> Approved First Articles will be forwarded to _____		<input type="checkbox"/> Disapproved First Articles will be returned to the contractor/ <input checked="" type="checkbox"/> will be retained by <u>DDOO-SFC</u> pending disposition instructions from the contractor	
<input type="checkbox"/> _____ <i>(Insert quantity)</i> . First Articles will be expended in testing. Residual components of disapproved First Articles <input type="checkbox"/> will be returned to the contractor/ <input type="checkbox"/> will be retained by _____ pending disposition instructions from the contractor.		<input type="checkbox"/> On purchase requests designated as direct shipments the following disposition will apply. (NOTE: Always applicable on Foreign Military Sales (FMS)).	
<input checked="" type="checkbox"/> 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.		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.	
		<input type="checkbox"/> Other Disposition: _____	

TICLA / MARK FRASCA / 30 APR 02

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 12 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

FIRST ARTICLE TEST IS REQUIRED TO VERIFY CONTRACTOR CAPABILITY TO SUCCESSFULLY MANUFACTURE REMAINING PRODUCTION QUANTITY

FIRST ARTICLE EXHIBITS ARE TO BE SHIPPED TO:

**DDOO-SFC (FIRST ARTICLES)
BLDG 18, DOOR 4 (EXT 97902)
8080 PERIMETER ROAD
TINKER AFB, OK 73145-8000
DODAAC: FY 2033**

**MARK FOR: FIRST ARTICLES
ATTN: DDOO-SFC
DO NOT POST, NON-ACCOUNTABLE
DO NOT PUT INTO SUPPLY**

ENSURE THE WORDS "FIRST ARTICLES" ARE MARKED ON THE OUTSIDE OF THE BOX IN LARGE RED CONSPICUOUS LETTERS

13. COGNIZANT ENG ORGANIZATION RESPONSIBLE FOR CONDUCTING AND/OR APPROVING TEST (Name, Organization, Phone)
YEN QUACH/LHRH/736-5401

14. PR INITIATOR (Name, Organization, Phone)

AMC/AMSC SCREENING ANALYSIS WORKSHEET

PRIORITY CATEGORY

POTENTIAL REQUIREMENT IDENT. DATE

* HISTORY *

PAGE 1 OF 2

8

25MAR02

SECTION A ITEM IDENTIFICATION AND INFORMATION

1. NSN 5342009548087FG	2. NOUN TERMINAL PIN ASSEMB	3. END ITEM B52H	4. PCC	5. ERRC N
6. INI 24MAY02	7. QTY 100	8. UNIT COST \$1,556.42	9. IDENTIFYING NUMBER (PART NO.) R/N: 35-23797-508	
10. BP/SMC/MPC/FY 9 / / / 2		11. PR. YRS 10	12. EST ANNUAL BUY VALUE \$155,642.00	13. PR/MIPR VALUE \$155,642.00
14. COMM OFF-THE-SHELF ITEM (Y/N/U): N	15. FORM 1 TYPE ITEM (Y/N/U): N	16. NUC. CERT. END ITEM (Y/N/U): U	17. HARD CRIT. IND (Y/N/U): N	
NEXT HIGHER ASSEMBLY				
18. NSN:	19. NOUN:	20. R/N:	21. CAGE:	

SECTION B SUMMARY OF SCREENING ACTION

1. STAT C	2. DIV N	3. CTIC	4. ACQUISITION IDENTIFYING NUMBER R/N: 35-23797-508	5. REV	6. CQR/I&A 0
7A. DESIGN DIS: N	7B. SPEC CNTRL: N	7C. SRC CNTRL: N	7D. MIL/IND/CONTR PERF SPEC: N		
8. ST/STE REQ (Y/N/U): Y	9. ST/STE AVAIL (Y/N/U): U	10. DATA COMPLETE (Y/N/U): Y	11. LIMITED RIGHTS (Y/N/U): N	12. AAC Z	
13. AMC/AMSC 1G	14. DCC C3	15. EXP DT 0507	16. PRV AMC/S/DT 1G / 0590	17. NBR DRWGS REVD 0	
18. AMC COMPLETION DT: 16APR02	19. MM RECMD AMC/AMSC: 1G				
20. DATE BEGAN	IM 25MAR02	EQ/SP 25MAR02	CR TECH 02APR02	CR ENGR	MM ENGR 05APR02
21. DATE COMPLETED	25MAR02	01APR02	16APR02		12APR02
22. CODE/PHONE NR NAME	XXX / 46612 MORRIS LIN	RE / 63775 WILKERSON	AOS / 64210 WHALEN, BRI	/	8GI / 65401 QUACH YEN
23. ORGANIZATION	LGNS	LHRH	TILDCC		LHRH

SECTION C ECONOMIC EVALUATION

EST SAVING/LOSS OVER FUTURE PROG (ABV x A x PROG YRS) - B =	A. SAV FACTOR % 0	B. \$ COST OF BREAKOUT \$0.00
--	----------------------	----------------------------------

SECTION D PROCUREMENT SUPPORT REQUIRED

1. FIRST ARTICLE TEST (Y/N): Y	2. TECHNICAL DATA PACKAGE (Y/N): Y
3. EXPORT CONTROL (Y/N): Y	4. PRODUCTION SAMPLE REQ (Y/N): N
5. MLO/ARTWORK (M/S/B/N): N	6. SAMPLE FURN (Y/N): N
7. ENGR NOTES (Y/N): Y	
8. PR RETURN REASON CODE:	9. PR NUMBER:

SECTION E APPROVED SOURCES

DESIGN ACTIVITY INFORMATION			SUPPLIER INFORMATION		
CAGE	REFERENCE NUMBER	RNC	CAGE	CONTRACTOR'S NAME	TYPE
082918	35-23797-508	32	034336	L&S MACHINE CO INC	
082918	35-23797-508	32	07F311	MONROE MACHINED PRODUCTS INC	
082918	35-23797-508	32	082918	BOEING DEFENSE & SPACE GROUP	P

AMC/AMSC SCREENING ANALYSIS WORKSHEET

* HISTORY *

(CONTINUING SHEET)

PAGE 2 OF 2

NSN : 5342009548087FG AMC/AMSC : IG : IM DATE BEGAN : 25MAR02

SECTION F SCREENING EVALUATION/REMARKS

1. JUSTIFICATION FOR SUFFIX CODE OTHER THAN G :

2. ACTION TAKEN/BEING TAKEN TO IMPROVE COMPETITIVE STATUS :

ITEM IS COMPETITIVE.
BRIAN WHEALEN TILDC 7364210

3. REMARKS :

SECTION G MISCELLANEOUS INFORMATION

1. PROCUREMENT HISTORY (LAST 5 BUYS) : STD PRICE \$1,556.42

AWARD DATE	CLIN QTY	UNIT PRICE	SUPPLIERS CAGE	AMC/AMSC	AMOC	NO SOL	BIDS RCY

2. VALUE ANALYSIS DATA

ECON PROD QTY	PROJ BUY QTY	ANLYS DATE	DIR LAB HOURS	DIR MAT COSTS	IND COST & PROFIT	TARGET PRICE	SRC REV

REMARKS :

3. POTENTIAL SOURCES

DESIGN ACTIVITY INFORMATION				SUPPLIER INFORMATION		
CAGE	REFERENCE NUMBER	RNC	CAGE	CONTRACTOR'S NAME		Orig/ Eval

REVISION:

ENGINEERING DATA LIST

* HISTORY *

DATE	03APR02	DATA TECH	AOS	ORGN SYMBOL	TLDCC	PR NR	APPLICATION	PAGE	OF
CAGE	82918	MANUFACTURER NAME	BOEING DEFENSE & SPACE GROUP	REFERENCE NR	35-23797-508	NOUN	TERMINAL PIN ASSEMB	NSN	5342009548087EG
CAGE	DRAWING NUMBER	REV	NR SHEETS	NR CARDS	FURN CODE	DIST CODE	NOUN	REMARKS	
82918	35-23797	/ L	0000	0000	S		KIT BUSHING & PIN INSTALLATION		
81205	35-24036	/ A	0000	0000	S		DETAILS-SHIM & RUBBER STRIP		
81205	39-22594	/	0000	0000	S		WASHER		
81205	35-26052	/ A	0000	0000	S		PIN		
81205	35-1794	/ F	0000	0000	S		PIN		
81205	39-1650	/ A	0000	0000	S		BOLT		
81205	39-1651	/ A	0000	0000	S		NUT		
81205	39-1652	/ B	0000	0000	S		CAP		
81205	BAC 5010	/ W	0000	0000	R		APPLICATION OF ADHESIVKS		
81205	BAC 5009	/ P	0000	0000	R		BOLT & NUT INSTALLATION		
81205	BAC 5307	/ M	0000	0000	R		PART MARK		
81205	BAC 5440	/ J	0000	0000	R		HOLE PREPARATION MACHINING STEEL		
81205	BAC 5765	/ T	0000	0000	R		CLEANING ALUMINUM		
81205	BMS-5-25 & QPL	/ C	0000	0000	R		CEMENT EPOXY		
00000	AIA/NAS NASM7838	/	0000	0000	O		BOLT, INTERNAL WRENCHING	USE AIA/NAS NASM7838 IN LIEU OF MIL-B-7838.	
00000	AIA/NAS NASM20002	/	0000	0000	O		WASHER, COUNTERSUNK	USE AIA/NAS NASM20002 IN LIEU OF MS 20002.	
00000	AIA/NAS NASM20012	/	0000	0000	O		BOLTS, INTERNAL WRENCHING	USE AIA/NAS NASM20012 IN LIEU OF MS 20012.	
00000	AIA/NAS NASM21245	/	0000	0000	O		NUT, SELF LOCKING	USE AIA/NAS NASM21245-L10 IN LIEU OF NAS1022A10.	
00000	AIA/NAS NASM20995	/	0000	0000	O		WIRE, SAFETY OR LOCK	USE AIA/NAS NASM20995 IN LIEU OF MS20995.	
00000	AMS 6349	/ B	0000	0000	O		STEEL, BARS	USE AMS 6349, AMS 6382 IN LIEU OF MIL-S-5626.	
00000	AMS 6382	/ M	0000	0000	O		STEEL, BARS		
00000	AMS-H-6875	/ A	0000	0000	O		HEAT TREATMENT	USE AMS-H-6875 IN LIEU OF BAC 5601 OR BAC 5617.	
00000	AMS-S-5000	/	0000	0000	O		STEEL, CHROME, NICKEL	USE AMS-S-5000 IN LIEU OF MIL-S-5000.	
00000	AMS-S-13165	/	0000	0000	O		SHOT PEENING OF METAL	USE AMS-S-13165 IN LIEU OF BAC 5730.	
00000	AMS-QQ-A-200	/ A	0000	0000	O		ALUM ALLOY	USE 7178-T6 PER AMS-QQ-A-200 AND AMS-QQ-A-200/13 IN LIEU OF MIL-A-9186.	
00000	AMS-QQ-A-200/11	/	0000	0000	O		ALUM ALLOY		
00000	AMS-QQ-A-200/13	/ A	0000	0000	O		ALUM ALLOY		
00000	AMS-QQ-A-250	/	0000	0000	O		ALUM & ALUM ALLOY	USE 7075-T6 ALUM ALLOY SHEET PER AMS-QQ-A-250, AMS-QQ-A-250/12 IN LIEU OF	
00000	AMS-QQ-A-250/12	/	0000	0000	O		ALUM ALLOY	QQ-A-283.	

TECHNICAL DATA PACKAGE - ENGINEERING NOTES (ENS)

PAGE 1
OF 6 PAGES

NATIONAL STOCK NUMBER
1560-00-954-8087FG

PART NUMBER
35-23797-508

- 1) PART MARK PER MIL-STD-130 METHOD PER BAC 5307.
- 2) FINISH CODE F2.20 DEFINED: ANODIZE ACCORDING TO SAE AMS-A-8625, TYPE I, CLASS 1.
- 3) FINISH CODE F12.11 DEFINED: APPLY MIL-PRF-23377, TYPE I TO A 0.0006 INCH MINIMUM DRY FILM THICKNESS, ACCORDING TO MIL-F-18264.
- 4) FINISH CODE F1.28 DEFINED: CADMIUM PLATE ACCORDING TO SAE AMS-QQ-P-416, TYPE II, CLASS 2. BAKE AFTER PLATING AS REQUIRED. APPLY MIL-PRF-23377G, TYPE I PRIMER TO A DRY FILM THICKNESS OF 0.0003 TO 0.0005 INCH ACCORDING TO THE MANUFACTURERS APPLICATION INSTRUCTIONS AND MIL-F-18264.
- 5) FINISH CODE F1.10 DEFINED: APPLY NO FINISH, EXCEPT THAT TEMPORARY PROTECTION MAY BE APPLIED FOR HANDLING, TRANSPORTATION AND STORAGE.
- 6) FINISH CODE F2.30 DEFINED: CHEMICAL TREAT TO MEET THE REQUIREMENTS OF MIL-C-5541 CLASS 1A OR ANODIZE TO MEET THE REQUIREMENTS MIL-A-8625, TYPE I, CLASS I. APPLY MIL-PRF-23377, TYPE I TO A DRY FILM THICKNESS OF 0.0003 TO 0.0005 INCH ACCORDING TO MIL-F-18264.
- 7) FINISH CODE F6.10 DEFINED: APPLY NO FINISH.
- 8) FINISH CODE F1.1923 DEFINED: CADMIUM PLATE TO MEET THE REQUIREMENTS AMS-QQ-P-416, TYPE II, CLASS 2. BAKE 3 HOURS MINIMUM AT 375° ± 25° F.
- 9) FINISH CODE F1.20 DEFINED: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2.
- 10) DELETE REFERENCE TO D3-4960.
- 11) DELETE REFERENCE TO BAC 5018.
- 12) ALL PARTS TO BE MADE NEW, NO REWORKED PARTS ALLOWED.
- 13) ASTM D 709 TYPE II GRADE CE OR LE IS A PREFERRED OPTION TO MIL-I-24768/14 OR MIL-I-24768/13.
- 14) SYMBOL B DEFINED: MAXIMUM DEPTH OF DECARBONIZATION IS NOT TO EXCEED 0.003 INCH.
- 15) USE ASTM E 1444 IN LIEU OF BAC 5424, AND ANY ADDITIONAL REQUIREMENTS IDENTIFIED IN ENGINEERING INSTRUCTIONS NOTE 23. THE ACCEPT/REJECT CRITERIA ARE DOCUMENTED IN ENGINEERING INSTRUCTIONS NOTE 24.
- 16) MAJOR CHARACTERISTICS:
 - A. 16 FINISH
 - B. CLASS 3A THREADS
 - C. 32 FINISH
.5660
 - D. .5645 .5630 DIMENSION
 - E. CLASS 3B THREADS
 - F. GRAIN DIRECTION
 - G. DIMENSION "A", "B", "C", "D"

TECHNICAL DATA PACKAGE - ENGINEERING NOTES (ENs)

PAGE 2

OF 6 PAGES

NATIONAL STOCK NUMBER
5342-00-954-8087FG

PART NUMBER
35-23797-508

- 17) USE 3/4-16 UNJF-3A OR 3/4-16UNJF-3B PER MIL-S-8879 IN LIEU OF 3/4-16UNF-3A OR 3/4-16UNF-3B PER MIL-S-7742.
- 18) USE ASTM E 1444 IN LIEU OF MIL-I-6868, AND ANY ADDITIONAL REQUIREMENTS IDENTIFIED IN ENGINEERING INSTRUCTIONS NOTE 23. THE ACCEPT/REJECT CRITERIA ARE DOCUMENTED IN ENGINEERING INSTRUCTIONS NOTE 25.
- 19) DELETE REFERENCE TO GENERAL ELECTRIC SURFACE ROUGHNESS SCALES.
- 20) OPTIONAL MATERIAL: 7075-T6 PER AMS-QQ-A-200 AND AMS-QQ-A-200/11.
- 21) USE ASTM E 1417 IN LIEU OF BAC 5423, ANY ADDITIONAL REQUIREMENTS ARE IDENTIFIED IN ENGINEERING INSTRUCTION NOTE 22. THE ACCEPT/REJECT CRITERIA ARE STATED IN ENGINEERING INSTRUCTION NOTE 22.
- 22) FLOURESCENT PENETRANT INSPECTION USE ASTM E 1417, WITH THE FOLLOWING REQUIREMENTS:
- I. MATERIALS USED WITHIN A SYSTEM (FAMILY) SHALL BE FROM THE SAME MANUFACTURE AND MANUFACTURER'S FAMILY, AND QUALIFIED TOGETHER IN THE CURRENT QPL-SAE-AMS-2644.
- II. INSPECTION TO BE ACCOMPLISHED USING, TYPE I, MINIMUM SENSITIVITY LEVEL 3, METHOD A,B,OR D PROCESS, AND FORM SEE BELOW.
- FOR METHOD A - USE FORM A OR D DEVELOPER
FOR METHOD B OR D - USE FORM B OR D DEVELOPER
- CAUTION:** IF FORM D DEVELOPER IS USED, CARE SHALL BE USED IN APPLICATION TO PREVENT BUILD-UP OF DEVELOPER ON THE SURFACE.
- III. ACCEPT/REJECT CRITERIA PER MIL-STD-1907 GRADE C.
- 23) USE ASTM E 1444 WITH THESE ADDITIONAL REQUIREMENTS
- A. THE CONCENTRATION OF PARTICLES IN THE TEST BATH SHALL BE AS SPECIFIED IN THE WRITTEN PROCEDURE BUT IN NO CASE OUTSIDE THE RANGE OF 0.15 TO 0.25 IN A 100ml BATH SAMPLE FOR FLOURESCENT PARTICLES AND 1.5 TO 2.4 FOR NON-FLOURESCENT PARTICLES. FLOURESCENT PARTICLES AND NONFLOURESCENT PARTICLES SHALL NOT BE USED TOGETHER.
- B. THE INSPECTION PROCESS IS TO BE FLOURESCENT, WET CONTINUOUS, DIRECT CURRENT.

NATIONAL STOCK NUMBER
5342-00-954-8087FG

PART NUMBER
35-23797-508

24) ACCEPT/REJECT CRITERIA FOR MAGNETIC PARTICLE INSPECTION FOR FERROUS ALLOYS (NON-CRES) OF 180 KSI TO 260 KSI

A. INDICATIONS OF MATERIAL DISCONTINUITIES CAUSED BY OR REVEALED BY ANY PROCESSING STEP ARE NOT ACCEPTABLE. EXAMPLES OF DISCONTINUITIES ARE: CRACKS, LAPS, COLD SHUTS, LEAMINATIONS, SEAMS, TEARS, BLOWHOLES, FLAKES FORGING BURSTS, INTRUDED SCALE, LINEAR POROSITY, PIPES, CORROSION, PITS CRAZING, GALLING. EXAMPLES OF PROCESSING STEPS INCLUDE: CASTING, FORGING FORMING, GRINDING, HEAT TREATMENT, PLATING, WELDING, MACHINING, AND STRAIGHTENING.

B. INDICATIONS OF ANY LENGTH THAT EXTEND OVER OR INTO AN EDGE, CHAMFER CORNER, RADIUS, FILLET OR HOLE ARE CAUSE FOR REJECTION.

C. PARTS EXHIBITING ARC MARCS ARE NOT ACCEPTABLE.

D. ANY INDICATIONS DUE TO INCLUSIONS AND ALLOY OR METALLIC PHASE SEGREGATION EXCEEDING THE FOLLOWING LENGTH LIMITS ARE NOT ACCEPTABLE:

THREADED AREA	SURFACE .20 INCH
	SUBSURFACE .30 INCH
OTHER AREAS	SURFACE .40 INCH
	SUBSURFACE .60 INCH

E. ADJACENT OR INLINE INDICATIONS ¼ INCH OR LESS APART ARE CONSIDERED AS ONE INDICATION WITH A LENGTH EQUAL TO THE SUM OF THE INDIVIDUAL LENGTHS PLUS ½ THE TOTAL INTERVENING DISTANCE.

25) ACCEPT/REJECT CRITERIA OF MAGNETIC PARTICLE INSPECTION FOR FERROUS ALLOYS (NON-CRES) OF LESS THAN 180 KSI

A. INDICATIONS OF MATERIAL DISCONTINUITIES ARE, CRACKS, LAPS, COLD SHUTS MANIMATIONS, SEAMS, TEARS, BLOWHOLES, FLAKES, FORGING BURSTS, INTRUDED SCALE, LINEAR PROSITY, PIPES, CORROSION PITS, CRAZING, GALLING. EXAMPLES OF PROCESSING STEPS INCLUDE: FORGING, FORMING, GRINDING, HEAT TREATMENT PLATING, WELDING, MACHINING AND STRAIGHTENING.

B. INDICATIONS OF ANY LENGTH THAT EXTENDS OVER OR INTO AN EDGE, CHAMFER CORNER, RADIUS, FILLET OR HOLE ARE CAUSE FOR REJECTION.

C. PARTS EXHIBITING ARC MARKS ARE NOT ACCEPTABLE.

D. THE AGGREGATE LENGTH OF INDICATIONS CAUSED BY INCLUSIONS AND ALLOY OR METALLIC PHASE SEGREGATIONS SHALL NOT EXCEED 1.5 INCHES IN ANY 3 X 3 INCH AREA.

26) DELETE REFERENCE TO WORD "BOEING" ON FORGING.

TECHNICAL DATA PACKAGE - ENGINEERING NOTES (ENs)

PAGE 4

OF 6 PAGES

NATIONAL STOCK NUMBER
1560-00-954-8087FG

PART NUMBER
35-23797-508

27. WHEN CHECKED BELOW OR LISTED IN THESE NOTES, DEFINITIONS APPLICABLE TO THIS PRODUCT ARE OR HAVE:

(A) ENGINEERING CRITICAL IN APPLICATION: An item which requires special manufacturing process, controls, and testing of material or end items. Because of its use or application, failure to maintain the highest reliability of such an item could be catastrophic resulting in loss of life or serious injury, loss of a weapon system or extensive secondary damage, with direct impact on the capability to respond to a national emergency or to achieve wartime sustainability.

(B) COMPLEX: Items having quality characteristics not wholly visible (hidden characteristics), in the end product for which contractual conformance must be established progressively through precise measurements, tests or controls applied during purchasing, manufacturing, performance, assembly and functional operation either as an individual item or in conjunction with other items [FAR SUBPART 46.203(b)].

(c) COMMERCIAL: Described in commercial catalogs, drawings or industrial standards [FAR SUBPART 46.203(a), (1)].

(D) CRITICAL CHARACTERISTICS: Characteristics which, when defective, are likely to result in hazardous or unsafe conditions for individuals using, maintaining or depending upon the product, or, are likely to prevent performance of the tactical function of a major end item such as an aircraft, missile, space vehicle, engine or a major part thereof. (Derived from MIL-STD-105).

(E) MAJOR CHARACTERISTICS: Characteristics (other than critical or minor), which, when defective, are likely to result in failure or to reduce the usability of the product or a major end item for its intended purpose. (Derived from MIL-STD-105).

(F) MINOR CHARACTERISTICS: All characteristics not designated as critical or major but for which full conformity is required.

28) THIS PRODUCT HAS BEEN DETERMINED TO BE OR CONTAINS (AS CHECKED BELOW):

- Engineering critical in application.
- Critical characteristics.
- Major characteristics.
- Minor characteristics, all excepting critical and major.
- Complex.
- Available as a commercial product.

TECHNICAL DATA PACKAGE - ENGINEERING NOTES (ENS)

PAGE 5

OF 6 PAGES

NATIONAL STOCK NUMBER
1560-00-954-8087FG

PART NUMBER
35-23797-508

- 29) When materials, processes or components are to be obtained from directed sources as indicated herein or in the specifications, alternate sources may only be utilized upon prior approval by the contracting officer of this procuring activity as a deviation.

Bidders shall notify this procuring activity at the time of quotation of any drawing, specification or standard which is of more current data revision than those shown on the data listing or in these engineering notes. Determination of acceptability of the more currently dated data will be made by the responsible engineering office of this procuring activity.

Lower tier specifications listed in or referenced by first tier specifications may not be shown on the data lists or engineering notes accompanying this contract but are nonetheless required by this contract for compliance. Exceptions would occur only when such lower tier requirements have been specifically waived or substitute specifications/requirements are designated herein.

Reports, process sheets, inspection methods sheets and all other documents required by specifications imposed by this contract for contractor compliance which were previously required to be submitted to a prime design contractor shall be held at that facility for review by government personnel.

When prime design source specifications require or provide for participation by that prime source quality, manufacturing, laboratory or engineering support services, these requirements or provisions do not apply when the contract was issued by this procuring activity. For these services or direction pertaining thereto, contact the cognizant government contract administration office or this procuring activity for assistance.

The contractor is responsible for assuring that all dimensions, conditions, tests and test results identified in these engineering notes, applicable drawings, specifications and contract quality requirements are met by themselves and their suppliers. This requirement applies to all characteristics whether those characteristics have been specifically designed as being critical, major or are those minor characteristics not specifically designated as such.

NATIONAL STOCK NUMBER
1560-00-954-8087FGPART NUMBER
35-23797-508

PROCESS DATA REQUIREMENTS (APPLIES WHEN CHECKED):

Prior to beginning of manufacture, the contractor will notify the engineering office of this procuring activity of all manufacturing process and processing procedures intended for use in production of this product. Once these processes are established, no changes shall be made without prior approval of the engineering office of this procuring activity.

SERIALIZATION OF PARTS (CHECK WHEN APPLICABLE):

Serialization of each part/assembly (contract end item), is required.

STABLE BASE DRAWING (CHECK WHEN APPLICABLE):

When the use of stable base drawings are required, the following shall apply:

- A. Stabilize by allowing the stable base drawing to rest flat and unrestrained on a flat surface overnight at room temperature prior to use.
- B. Do not stretch or otherwise apply stress.
- C. Check the dimensional accuracy of the grid lines. The dimension between adjacent grid lines must be within ± 0.005 inch. The grid lines shall be measured vertically, horizontally and diagonally, to insure that the grids are within a tolerance of ± 0.005 inch. The tolerance is accumulated over the length and width of the stable base drawing.
- D. Trammel points shall be measured to within $\phi .010$
- E. When rolling stable base drawings, do not roll less than 3 inches in diameter.
- F. If the above tolerance points prove to be inaccurate, record the discrepancies immediately and notify in writing. OC-ALC/PMXOA and the Administrative Contracting Officer (ACO).