

FLYSHEET QA04-104
D5 PROGRAM, SPECIAL REQUIREMENTS

*This attachment was prepared to communicate Special Requirements of the Trident D5 Program
Please read the information contained in the following pages before proceeding with the required operations.*

1.0 PROCUREMENT.

1.1 **Order only from the D5-approved suppliers.** Supplier approval is granted through supplier survey and review of manufacturing travelers if applicable. Verify supplier approval status. Suppliers requiring customer approval include but not limited to the following:

- a Procured Hardware
- b Outsourced machining
- c Special Process (Table 1).
- d Non-Destructive Testing (Table 1)
- e Inspection

Table 1: Special Process Suppliers

| Special Process | Supplier | Facility Location |
|---|------------------------------|-------------------|
| Heat treating | Quality Heat Treating | Burbank, CA |
| Passivation | California Technical Plating | San Fernando, CA |
| Electro polish | California Technical Plating | San Fernando, CA |
| Thread Grinding | Angeli Machine Co. | Burbank, CA |
| Fluorescent Penetrant and/or Magnetic Particle Inspection | B-G Detection Service | Burbank, CA |

NO ALTERNATE OR ADDITIONAL SUPPLIER MAY BE USED WITHOUT PRIOR WRITTEN CUSTOMER APPROVAL

1.2 **Flow down D5 program requirements to sub-contractors.** Annotate all Purchase Orders with this or equivalent statement.

“D5 PROGRAM – FROZEN PROCESS REQUIREMENTS OF QE102-07 APPLY. REFER TO ATTACHED D5 PROGRAM SPECIAL REQUIREMENTS FLY SHEET QA04-104”

1.3 **Notify customer organization of any supplier changes** (ownership, location, facility, etc.) prior to producing D-5 program hardware.

1.4 **Submit a First Article Inspection report with each lot.** Randomly select and identify (tag) a unit for First Article inspection. Use the current revision of AS9102 form 3 requirements as a guideline.

1.5 **No partial shipments are allowed.** Deliver only single production lot per purchase order item. Multiple shipments on single PO will be rejected.

1.6 **No mixed material lots are allowed.** Shipments not of one lot of material will be rejected

1.7 **The supplier shall comply with the requirements of DFAR 252.225.7014, Alternate 1 “Preference for Domestic Specialty Metals”.** Material Test Report shall indicate the country where material was melted

2.0 PROCESS CONTROL.

2.1 **Whittaker Controls and subtier suppliers will annotate all manufacturing travelers with these or equivalent statements:**

"UNDER CUSTOMER CONFIGURATION CONTROL, CHANGES MUST BE SUBMITTED TO CUSTOMER BEFORE RELEASE"

"D5 PROGRAM - FROZEN PROCESS REQUIREMENTS OF QEI 2-7 APPLY. REFER TO ATTACHED FLY SHEET # QA4-104."

2.2 All processes require detailed written procedures and become **"Frozen"** after acceptance of the first lot of production hardware.

2.2.1 **Major** changes require **customer** approval **prior** to fabrication and processing.

2.2.2 **Minor** changes may be approved **concurrently** with fabrication and processing.

2.2.3 Insignificant changes do not require approval. Document only.

Table 2: Change Classification

| Major | Minor | Insignificant |
|--|---|---|
| -Design Specification -Method of material removal -Facility Relocation -Specialized Test -Equipment/procedures -Functional tooling, fixtures -Special process, NDT -Deletion of Inspection operations - Change of Supplier | -Gages from dedicated to standard with equal capability -In-process dimension or tolerance -Cleaning -Manual machining to CNC -Allowed substitutions to processes and Equipment | -Standard gages -Minor tooling -Adding notes and cautions -Adding inspections -Work center/equipment to similar. -Rework to print -Typographical errors -Feeds and speeds (measurable output) - Replacement, rework, repair of tooling. |

2.3 **Weld repairs are not allowed** unless otherwise specified by engineering drawing.

2.4 **Traceability to mixed lots is NOT allowed**, including manufacturing and raw material lots.

2.5 **Personnel performing certifiable NDT or SPECIAL PROCESS** skill must perform the skill at least once every six months. Demonstration of proficiency for certifiable skill is required if lapse is greater than six month. No written exam or eye test is required. Hardware of specification number in which skill is performed need not be specific to the D5 Program.

3.0 RECORDS

3.1 **Store all records in distinct location.** Clearly identify the location as D5-program related.

3.2 **Retain all D5 program hardware records until a year 2020.** At that time, notify customer/contractor and obtain authorization prior to disposing the documents/records.