

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 Special Process (Table 1).
- c Non-Destructive Testing (Table 1)
- d Inspection

Table 1: Special Process Suppliers for Collins

Special Process	Supplier	Facility Location
Heat treating	Bodycote Thermal Processing Burbank Steel Treating Inc. Continental Heat Treating Inc.	All NADCAP certified facilities* Burbank, CA Santa Fe Springs, CA
Passivation	Aero Chrome Active Magnetic Inspection	Van Nuys, CA Sun Valley, CA
Electro polish	Aero Chrome Active Magnetic Inspection Electrolurgy	Van Nuys, CA Sun Valley, CA
Fluorescent Penetrant and/or Magnetic Particle Inspection	B-G Detection Service Aero Chrome Active Magnetic Inspection	Burbank, CA Van Nuys, CA Sun Valley, CA

Table 2: Special Process Suppliers for Lockheed Martin

Special Process	Supplier	Facility Location
Heat treating	Bodycote Thermal Processing Burbank Steel Treating Inc. Continental Heat Treating Inc.	All NADCAP certified facilities* Burbank, CA Santa Fe Springs, CA
Passivation	Aero Chrome	Van Nuys, CA
Electro polish	Aero Chrome Electrolurgy	Van Nuys, CA Irvine, CA
Fluorescent Penetrant and/or Magnetic Particle Inspection	B-G Detection Service Aero Chrome	Burbank, CA Van Nuys, CA

NO ALTERNATE OR ADDITIONAL SUPPLIER MAY BE USED WITHOUT PRIOR WRITTEN

CUSTOMER APPROVAL

* Once a specific facility is selected, no changes can be made without prior 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, and REQUIREMENTS OF QEI02-07, COLLINS' ASQR-01, HSM19, HSM236, AND APPENDIX P 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 forms 1, 2, and 3 requirements, and HSM236 as applicable.

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**

2.0 **PROCESS CONTROL.**

2.1 **Meggitt (North Hollywood), Inc. and sub-tier 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 QEI02-07 APPLY. REFER TO ATTACHED FLY SHEET # QA04-104."

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 (see QEI02-07 Para. 7.0, sub-para. 9).

2.2.2 **Minor** changes may be approved **concurrently** with fabrication and processing (see QEI02-07 Para. 7.0, sub-para. 9).

2.2.3 **Insignificant** changes do not require approval. Document only (see QEI02-07 Para. 07, sub-para. 9).

2.2.4 When change is submitted to Collins; Meggitt (NoHo) must provide Collins both the current requirements and proposed change, reason for change, and implementation date/serial number effectivity.

2.2.5 All the parts shipment to Collins must be withheld pending Collins acceptance of minor change.

Table 3: Change Classification (Ref. QE102-07 Para. 4.0; Sub-para's 3, 4, and 5).

Major	Minor	Insignificant
-Design Specification -Method of material removal -Facility Relocation; including relocation of process equipment within a given facility -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 the Meggitt (NoHo) record retention system.** Clearly identify the location as D5-program related.
- 3.2 **Retain all D5 program hardware records until a year 2085.** At that time, request for records disposition shall be submitted to customer/contractor six (6) months prior to disposing the documents/records.