



## Customer Specification Approvals

Limited to Processes Requiring Customer Approval

Effectivity: 28-FEB-2024

Boeing				
Process	Process Code	Specification	Description	Comment
Chemical Processing	320	MIL-C-5541	Chemical Conversion Coating on Aluminum	-
Chemical Processing	320B	MIL-DTL-5541	Chemical Conversion Coating on Aluminum	-
Chemical Processing	321	BAC 5719	Chemical Conversion Coatings for Aluminum	-
Heat Treat	111	BAC 5602,	Heat Treat of Aluminum Alloys	-
Hardness Testing	806A	BAC 5650	Hardness Testing	-
Temper Inspection	806	BAC 5946	Temper Inspection of Non-ferrous Alloys	(including BAC 5651)
Testing	809	N/A	Process Solution Control	-
Testing	802	N/A	Mechanical Testing,	-
QMS	002	AS9100D	Quality Management System, Direct Contract	-

Bombardier			
Process	Specification	Description	Comment
Accelerated Curing	BAPS 138-055	Accelerated Curing of Organic Coatings	Limited to Oven #2 and #3
Assembly Operations	BAPS 157-027	Fuel Tank Sealing	Limited to Fay surface sealing, fillet sealing, injection sealing, pack sealing, gap sealing, wet installation of fasteners and aerodynamic sealing
Assembly Operations	BAPS 157-028	Pressure and Environmental Sealing	Fay surface sealing, fillet sealing, injection sealing, pack sealing, gap sealing, wet installation of fasteners and aerodynamic sealing
Assembly Operations	BAPS 150-003	Installation of Safety Devices	Limited to Cotter Pin installation
Assembly Operations	BAPS 151-001	Installation of Conventional Rivets	Limited to installation of conventional rivets
Chemical Processing	BAPS 160-010	Chromic Acid Anodizing	-
Chemical Processing	BAPS 160-020	Chemical Conversion Treatment for Aluminum Alloys	Limited to Type 1 and Type 2 with Alodine 1132 "Touch & Prep Pen " for repaired area
Chemical Processing	BAPS 180-001	Alkaline Cleaning	-
Chemical Processing	BAPS 180-032	Acid Cleaning & Deoxidizing of Aluminum Metals	-
Heat Treat	BAPS 168-007	Heat Treatment of Aluminum Alloys	-
Heat Treat Verification	BAPS 168-013	Hardness and Electrical Conductivity Testing of Metals	-
Identification	BAPS 144-005	Identification of Aircraft Parts	Limited to Dot Peen
Laboratory	BAERD GEN-018-1B	Wet Chemistry, Titration	
Laboratory	BAERD GEN-018-2A	Static Testing, Metals	
Laboratory	BAERD GEN-018-5E	Engineering Requirements for Laboratories	Captive laboratory limited to paint adhesion test per BATS 4860
Prime & Paint	BAPS 138-043	Application of Fluid Resistant Primer	Limited to 44G N 60 primer system
Prime & Paint	BAPS 138-044	Application of Fluid Resistant (Fr) Enamels and Decorative Topcoats	-
Prime & Paint	BAPS 157-026	Spray Application of BAMS 565-010 Fuel Tank Coating	Limited to Touch-up Only
Prime & Paint	BAPS 157-027	Fuel Tank Sealing	Limited to Fay surface sealing, fillet sealing, injection sealing, pack sealing, gap sealing, wet installation of fasteners and aerodynamic sealing



## Customer Specification Approvals

Limited to Processes Requiring Customer Approval

Effectivity: 28-FEB-2024

Dassault Falcon Jet			
Process	Specification	Description	Comment
Chemical Processing	FES 108-F4/F5 (MIL-DTL-5541)	Finish Specification/Alodine	-
Chemical Processing	FES 108-F3 (MIL-A-8625)	Finish specification/ Chromic Acid Anodize	Limited to Type I, Class I (Non-dyed)
Chemical Processing	FES 116	Chemical Cleaning of Metals	-
Chemical Processing	FES 116	Passivation of Stainless Steels	-
Fabrication	FES 119	Metal fabrication	-
Fabrication	FES 176	Processing of Composites	-
Heat Treat Verification	FES 159	Hardness and Conductivity Testing	-
Heat Treatments	FES 103	Heat Treat of Aluminum Alloys	-
Prime & Paint	FES-109	Application of Corrosion Preventive Compound	-

Government/Military			
Process	Specification	Description	Comment
Chemical Processing	MIL-A-8625/MIL-PRF-8625	Sulfuric Acid-Anodize	-
Chemical Processing	MIL-A-8625/MIL-PRF-8625	Chromic Acid Anodize	-
Chemical Processing	AMS-C-5541/MIL-DTL-5541	Chem Film	-
Heat Treat Verification	5PTPCG09	Hardness and Conductivity Testing	-
Heat Treat Verification	AMS 2658	Hardness and Conductivity Inspection of Wrought Aluminum Alloy Parts	-
Heat Treat Verification	ARP-1962	Training and Approval of Heat Treating Personnel	-
Heat Treat Verification	MIL-STD-152	Quality Assurance Requirements for Thermal Processing	-
Heat Treatments	AMS 2750	Pyrometry	-
Heat Treatments	AMS 2772	Heat Treatment of Aluminum Alloy Raw Materials	-
Heat Treatments	AMS-2770	Heat Treat of Aluminum Alloys	-
Prime & Paint	MIL-C-22750 MIL-C-46168 MIL-C-53039 MIL-F-18264 MIL-P-23377 MIL-P-53022 MIL-P-53030 MIL-P-85582 MIL-DTL-53072 MIL-PRF-22750 MIL-PRF-23377 MIL-PRF-85285 MIL-PRF-85582	Prime/Paint	-

Continued Next Page



## Customer Specification Approvals

Limited to Processes Requiring Customer Approval

Effectivity: 28-FEB-2024

Gulfstream					
Process	Process Code	Description	GAMPS	Industry Specification	Comment
Anodize	88	Anodic Coating, Chromic Acid, of Aluminum & Its Alloys	GAMPS 6201	MIL-A-8625, TY 1 or 1B, CL 1	-
Chemical Cleaning	WD	Alkaline Cleaning of Ferrous & Non-Ferrous Alloys (Not Titanium & Its Alloys)	GAMPS 4105	MIL-DTL-5002	-
Chemical Film	213	Chemical Film, Chromate Conversion Coating, Low Electrical Resistance	GAMPS 6113	MIL-DTL-5541, CL 3	-
Heat Treat	Group: GAMPS 5102	Heat Treatment of Wrought Precipitation Hardenable	GAMPS 5102	All applicable per GAF14A	-
Heat Treat	Group: GAMPS 5108	Heat Treating of Aluminum Alloys	GAMPS 5108	All applicable per GAF14A	-
Machining, Conventional	MCA	Standard Machining Practice for & Control of Machined Parts in GAC Aircraft	GAMPS 2109	-	-
Machining, Conventional	AV	Fabrication of Aluminum Alloys	GAMPS 2101	-	-
Machining, Conventional	AK	Installation of Helical Coil Inserts, Threaded Screw	GAMPS 2212	-	-
Part Marking (Silk Screen)	Group: GAMPS 1105	Identification Marking of Fabricated Metallic Parts and Asse.	GAMPS 1105	All applicable per GAF14A	-
Passivation	PS	Passivation of Corrosion & Heat Resisting Alloys	GAMPS 4103	AMS 2700	-
Passivation	ZZ	Acid Cleaning of Ferrous Alloys	GAMPS 4103	MIL-DTL-5002	-
Prime & Paint	3012	Primer	GAMPS 3116 & GMS 5005	-	-
Prime & Paint	Group: GAMPS 3203	Lacquer: Acrylic, MIL-L-81352A, Application of	GAMPS 3203	All applicable per GAF14A	-
Prime & Paint	Group: GAMPS 3209	Polyurethane Enamel, Preparation and Application of	GAMPS 3209	All applicable per GAF14A	-
Prime & Paint	Group: GAMPS 3219	Touch Up of Fasteners to Match Surrounding Structure	GAMPS 3219	All applicable per GAF14A	-
Prime & Paint	Group: GAMPS 3303	Abrasion Resistant (Anti Chafe)	GAMPS 3303	All applicable per GAF14A	-
Prime & Paint	Group: GAMPS 6213	Epoxy Topcoat, High-Solids, Phosphate Ester Fluid Resistance	GAMPS 6213	All applicable per GAF14A	-
Titanium Cleaning	Group: GAMPS 4107	Cleaning and Descaling of Titanium & Titanium Alloys	GAMPS 4107	All applicable per GAF 14A	Method I Only



## Customer Specification Approvals

Limited to Processes Requiring Customer Approval

Effectivity: 28-FEB-2024

Lockheed				
Process	Process Code	Specification	Description	Comment
Chemical Processing	200S	2ZZP00001	Chromic Acid Anodize	-
Chemical Processing	200A	MIL-A-8625/MIL-PRF-8625, Type 1 and Type 1B	Chromic Acid Anodize	F-35 Type IB only F-16 Type I only
Chemical Processing	210	AMS-C-5541/MIL-DTL-5541, Type I, Class 1A and Class 3	Chem Film	-
Chemical Processing	N/A	AMS2700	Passivation	-
Chemical Processing	N/A	AMS-QQ-P-35	Passivation	-
Chemical Processing	N/A	FED-QQ-P-35	Passivation	-
Chemical Processing	N/A	ASTM A380	Passivation	-
Chemical Processing	N/A	ASTM A967	Passivation	-
Heat Treat Verification	164	5PTPCG09 Appendix A	Hardness Testing	-
Heat Treat Verification	165	5PTPCG09 Appendix B	Conductivity Testing	-
Heat Treat Verification	167	LMA-PC009	Conductivity Testing	-
Heat Treat Verification	168	LMA-PC009	Hardness Testing	-
Heat Treat Verification	160	NDTS-1500 / 1501	Hardness Testing	-
Heat Treat Verification	161	NDTS-1500 / 1502	Conductivity Testing	-
Heat Treatments	612	AMS 2750	Pyrometry	-
Heat Treatments	606	AMS-2770	Aluminum	-
Misc.	926	5PTPTT02	Fracture/Durability Critical Parts	-
Misc.	927	5PTPTT11	Mission/Safety & Selected Durability Mech. Equip	-
Misc.	928	5PTPTT12	Wind Swept Surface Parts	-
Prime & Paint	240C	LMA-PJ264	Application and Control of Organic Finishes	-

Northrup Grumman				
Process	Specification	Description	Comment	
Chemical Conversion Coating	FP-28	Chemical Film	-	
Heat Treat Verification	AMS 2658	Hardness and Conductivity Inspection of Wrought Aluminum Alloy Parts	-	
Heat Treatments	AMS 2750	Pyrometry	-	
Heat Treatments	AMS 2772	Heat Treatment of Aluminum Alloy Raw Materials	-	
Heat Treatments	AMS-2770	Heat Treat of Aluminum Alloys	-	
Heat Treatments	HT-1	Heat Treatment of Aluminum Alloys	-	
Prime & Paint	FP-153	Application of Primer	-	
Prime & Paint	FP-162	Application of Topcoat	-	
Passivation	FP-79	Passivate	-	