



Customer Specification Approvals

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Effectivity: 18-FEB-2026

Bell Textron, Inc. (Bell Helicopter)					
Process	Qualification Type	Qualification No.	Category Code	Category Description	Comment
Lab Testing	BPS	4139	LJ	Lab Intergranular Corrosion Testing (ASTM G 110, Ref Qps-104)	-
Heat Treat	BPS	4139	XA2	Heat Treatment of Aluminum Alloy Thicker Than .100 Inch (Include Forgings & XA1)	-
Heat Treat	BPS	4139	XA3	Heat Treatment of All Aluminum Alloy Series Less Than .100 Inch Other Than 2024 (Include XA1, XA2)	-
Heat Treat	BPS	4139	XA4	Heat Treatment of all Aluminum Alloy Series Less Than .100 In, include 2024 Not Less Than .036 In (Include XA1, XA2, XA3)	-
Heat Treat	BPS	4139	XA5	Heat Treatment Aluminum Alloy 2024 Less Than .036 Inch (Hand/Special Quench) - (Includes XA1, XA2, XA3, XA4)	-
Heat Treat	BPS	4139	XA6	Heat Treatment of Aluminum Alloy, Cold Stabilization	-
Heat Treat Verification	BPS	4453	IH1	Inspection, Conductivity, of Wrought Aluminum Alloy Sheet, Bar, Plate, Forgings & Extrusions (HT)	-
Heat Treat Verification	BPS	4453	IH2	Inspection, Conductivity, Of 2024-T3, T4, T42 Bare and Primed Aluminum Alloy Tubing for Heat Treat	-
Heat Treat Verification	BPS	4467	IO	Hardness Testing	-

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	-



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Bombardier			
Process	Specification	Description	Comment
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

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	-



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Government/Military			
Process	Specification	Description	Comment
Prime & Paint	MIL-C-22750	Prime/Paint	-
	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			

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



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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	-

Raytheon			
Process	Specification	Description	Comment
PAINT	MIL-DTL-18264	Finishes, Organic, Weapons System Application and Control Of	-
PAINT	RPR17003	Requirements for Epoxy Coating Systems, for Aluminum, Magnesium, Copper, Nickel	-
PAINT	RPR17005	Requirements for Polyurethane Coating Systems, for Aluminum, Magnesium, Copper, Nickel, and Stainless Steel Surface	-