

High Strength Threaded Fastener Process and Certification Document

Purchase Order Number: Part Number: Quantity:

Supplier Name: Lot #:

Manufactured to the requirements of FF-S-86 or applicable ANSI/ASME B18 and related ASTM A574/A574M or ASTM F835 specification.

Manufacturer Name: Material Specification:

Plater Name: Plating Specification:

- Dimensional Requirements have been verified and conform to all applicable requirements:
- Material is certified to the correct material specification, attached
- Material chemical composition meets the requirements of the specification
- Material Physical characteristics (Hardness values) are in the allowable range specified
- Chemical and physical certification, (material must be melted in the USA or a qualifying country) Certificate of Analysis is required
- The above plating provider has been approved by BAE Systems, has been verified using the BAE Systems approved process, and written evidence of approval is available upon demand
- BAE Systems has been notified if previous plating has been removed / reworked: (check one)

- Was performed using BAE Systems approved rework process and parts subjected to plating rework have been identified using a punch mark, (x), located on the head of the fasteners, or
- Was not performed

Plating has been completed IAW ASTM B 633:

- Plating Thickness
- Plating Adhesion
- Plating Corrosion Resistance
- Plating Workmanship
- Hydrogen Embrittlement Bake @ 400 +/-25 Deg F for 24 hours within 3 hours of plating
- Magnetic Particle Test was performed per ASTM E 1444 before and after stress durability test

Date and Time parts were processed through plating process Date: Time:

- Cathodic or acid cleaning was not used
- The minimum workable current density was used in the zinc bath
- Cyanide zinc and other low efficiency baths were not used
- Zinc activation, post hydrogen embrittlement bake relief, by immersion in zinc plating bath with electric current was not used
- Acids other than weak acids per ASTM B633 were not used
- Oven Charts for Pretreatment stress relief attached Oven charts for Post Coating hydrogen embrittlement bake attached
- Stress Durability Testing Completed IAW AIA/NAS NASM-1312-5, 200 Hours, 80% of the Rated Minimum Tensile Strength, Sample IAW ASQ Z1.4-1993

Stress Durability Testing: Provider Name: Sample Size: Specification:

Type of test performed: (Check One) Tensile Testing Wedge Testing Duration of the testing was (State Duration):

Locking Patch (when required) Shall Be Per MIL-DTL-18240, Except Prevailing and Breakaway Torques Per IFI-124 (when required by dwg)

- Locking element has been applied by a QPL approved provider
- Testing of the locking element has been performed per the drawing and specification and results attached

Notes:

1. BAE Systems must approve the plating process control procedure prior to plating high strength fasteners.
2. Pre-approved plating rework procedure is required

This is to certify that all items included in this shipment have been inspected and conform in all respects to the specifications and requirements applicable to the above-referenced purchase order in accordance with all requirements; all certifications identified above are attached.

Authorized Signature: Date: