

AXILLON WORK INSTRUCTION

Approved Special Processors List (ASPL)

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REVISION RECORD SHEET

Version	Date	Description	Approval Status
--	15 Jun 1992	Original Issue.	Approved
A	01 Aug 1997	Complete Revision.	Approved
B	31 Jan 2000	Replace Title Page and Page 9.	Approved
C	18 Feb 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6, Revised Pgs. 6, 7, 10 & 11.	Approved
D	06 Apr 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pg. 10.	Approved
E	24 Aug 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11.	Approved
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G	15 May 2003	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 6, 8 & 9.	Approved
H	04 Oct 2004	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11.	Approved
I	17 Jan 2006	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11 & 12.	Approved
J	02 Apr 2008	Complete Revision.	Approved
K	10 Aug 2009	Added Approved Suppliers. Complete reformat. Name change.	Approved
L	12 Jul 2012	Added Exotic Hear Treat, National Technical Systems, Burrell Enterprises, Missouri Metals & Aerospace Defense Coatings.	Approved
M	16 Jan 2013	Added SunGlo as Approved Plater.	Approved
N	26 Jul 2013	Amended Section 2.0.	Approved
O	03 Oct 2013	Rename Procedure, Add Section 5.0 and renumber subsequent sections, Update Section 1.0, 2.0 & 4.0.	Approved
P	04 Mar 2014	Removed SunGlo as Approved Plater (Pg. 8).	Approved
Q	15 Sep 2014	Added Dynamic Paint Solutions (Pg. 7). Updated Boeing Approved Processors List.	Approved
R	10 Dec 2014	Expanded Dynamic Paint Solutions Processes (Pg. 8).	Approved
S	14 May 2015	Updated name change for Dixie Plating Inc. to Freedom Metal Finishing (Pg. 7).	Approved

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T	03 Jan 2017	Added Special Processors (& Sub-Tier Special Processors) to the list. Heat Treat: Hi TecMetal Group (HTG) Testing: Voss Ind. & Orbit Ind., Inc. Updated Section 2.0 "Applicability" to include applicability to Prime and Government Contracts.	Approved
U	10 Feb 2017	Added scope of approval for Voss Industries (FPI), Added Anoplate Corporation Approval for Anodizing (CP).	Approved
V	26 Jul 2017	Remove Protect from Sikorsky and LMCO Approved Vendor due to Sikorsky QA Alert.	Approved
W	14 Dec 2017	Document name changed to Approved Special Processors List (ASPL). Added approval of Everett Plating, Inc. (EPI) to Anodizing (CP). Added Dan's Certified Welding, Inc. Approval to Fusion Welding (WLD).	Approved
X	18 Jan 2018	Added additional scopes of approval for Everett Plating (AC7108/12 Passivation).	Approved
Y	14 Aug 2018	Added additional scope of approval for Everett Plating (AC7108/11, Conversion Coating, MIL-DTL-5541 & MIL-C-5541) 18-125.	Approved
26	12 Apr 2022	Reformat and new identification applied for GBMS alignment. QA-202-P is now a WI of QA-P-SP2 making QA-202-P obsolete. Add "Coatings" to Plating Table (Pg. 10), Add Churchill Corporation to Plating/Coatings Approval (Pg. 11) and to Heat Treating Approvals (Pg. 11).	Approved
27	07 Jul 2022	Adjust formatting; Remove QA-P-SP2 reference and replaced with MPRC-10; Added Radius Aerospace to Heat Treatment.	Approved
28	10 Feb 2023	Added Hixson Metal Finishing to Plating and Coatings under Section 6.0.	Approved
29	05 March 2024	Update Section 6 to Add Nadcap expectations.	Approved

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1.0 PURPOSE

This procedure defines Axillon Aerospace ("Axillon") Rockmart's Special Processes and provides for the establishment and maintenance of sub-tier vendor special process and service system to control processes that have a significant impact on the success or failure of products and subassemblies produced by Axillon Rockmart.

2.0 SCOPE

This procedure is applicable to all identified Axillon Rockmart Special Processors and any Supplier or Sub-tier Supplier who provides a product or service where the output cannot be verified by subsequent monitoring or measurement and, as a consequence, deficiencies become apparent only after the product is in use or the service has been delivered.

The sources listed are approved to perform only those Special Processes or tests specifically identified in this document. Certain "Prime" contracts may dictate the Suppliers (or Sub-tier Suppliers) who are approved, and the minimum qualifications for approval, to conduct special processes within the scope of their contract. Unless otherwise noted in the "Customer Approval" column of this ASL, no approval is granted, nor applied, unless they are specifically listed in the Supplier's ASL or Axillon has expressed written consent from the "Prime" supplier for that Supplier or Sub-tier Supplier.

3.0 RESPONSIBILITIES AND AUTHORITY

3.1 PROCUREMENT

- Responsible for updating supplier databases, ERP systems and Axillon Rockmart Approved Supplier List in accordance with purchase order requirements and the requirements outlined herein.

3.2 QUALITY

- Quality Engineering** – Responsible for reviewing customer and regulatory requirements for Special Process Approval authorization.
- Quality Systems** – Responsible for the verification of conformance and, upon verification, updating the Approved Special Processors and Process tables within this document.

4.0 DEFINITIONS AND ABBREVIATIONS

- Special Process:** any production or service process which generates products or services which cannot be measured, monitored or verified prior to delivery and use.
- Special Services:** services performed by laboratories for providing accurate verifiable reports concerning metallurgy, rubber properties, chemical properties, qualification, destructive and non-destructive testing and calibration.
- Approved Supplier List:** a register of the suppliers that are approved to supply Axillon for production materials and services, as defined by Axillon Rockmart's Quality Management System. The ASL will maintain scope of approval, quality certifications and supplier details.

5.0 AXILLON ROCKMART IDENTIFIED SPECIAL PROCESSES

Axillon has reviewed its production processes to determine if any production or service provision is used where the resulting output cannot be verified by subsequent monitoring or measurement and, as a consequence, deficiencies become apparent only after the product is in use or the service has been delivered.

Processes that are identified as Special Processes will be validated at point of identification and periodically re-validated to ensure that the process is achieving planned results. Re-validation will include, but is not limited to:

- Review of defined criteria for approval of the process
- Approval of equipment and qualification of personnel working within the process
- Use of specific methods and procedures for the process
- Review of records pertaining to the process

The following matrix identifies the Special Processes reviewed by Axillon Rockmart and their applicability to the requirements of this procedure.

AXILLON SPECIAL PROCESS MATRIX				
KEY:	SP	ST	N/A	
	Identified Axillon Special Process	Special Processes Performed by Sub-Tier Suppliers	Special Processes Not Applicable to Axillon	
SPECIAL PROCESS	SP	ST	N/A	
Chemical Processing (CP)				
Anodizing			X	
Chemical Milling				X
Chemical Cleaning				X
Conversion / Phosphate Coating			X	
Etching			X	
Laboratory Evaluation				X
Paint / Dry Film Coatings	X		X	
Plating			X	
Stripping				X
Surface Prep Prior To Metal Bond And Surface Treatment / Passivation				X
Coatings (CT)				
Thermal Spray				X
Vapor Deposition				X
Diffusion Coating Process				X
Stripping of Coated Parts				X
Coatings Evaluation				X
Plating of Coated Parts and Heat Treating of Coated Parts				X
Composites (COMP)				
Prepeg / Adhesive Bonding	X			
Resin Film Infusion				X
Metal Bonding	X			
Core Processing and Liquid Resin Processing				X

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Conventional Machining as a Special Process (CMSP)			
Hole Making			X
Turning			X
Grinding			X
Broaching			X
Milling			X
Edge Treatment			X
Elastomer Seals			
O-Ring			X
Plate Seals / Rubber Bonded to Substrates			X
Molded Shapes			X
Compression Seals			X
Compounding			X
Electronics (ETG)			
Printed Boards			X
Circuit Card Assemblies			X
Cable Harness Assemblies			X
Fluid Distribution Systems (Fluid)			
Hose Manufacturing			X
Fittings and Other Machined Components			X
Couplings			X
Hose Assembly			X
Value Added Hose Assembly Distributors			X
Titanium Tubing Manufacturers			X
Heat Treating (HT)			
Metal Systems			X
Heat Treating Process		X	
Heat Treating Equipment			X
Brazing			X
Hot Forming			X
Materials Testing Laboratories (MTL)			
ISO/IEC 17025 Equivalency (AC7006)			X
Chemical Analysis			X
Mechanical Testing			X
Metallography (Micro & Macro)			X
Hardness Corrosion			X
Micro-Hardness			X
Differential Thermal Analysis			X
Fastener Testing			X
Specimen Heat Treating			X
Test Specimen Preparation			X
Non-Metallic Materials Manufacturing (NMMM)			
Raw Material Manufacturing of Resin, Prepeg and Adhesive Film			X
Nonconventional Machining & Surface Enhancement (NMSE)			
Electrochemical Machining (ECM)			X
Electrochemical Grinding (ECG)			X

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Electrical Discharge Machining (EDM)			X
Laser Beam Machining (LBM)			X
Shot Peening			X
Non-Metallic Materials Testing (NMMT)			
Mechanical Testing, Physical Testing, Chemical Testing, Thermal Testing and Flammability Testing For Class A: Composite and Class B: Adhesive / Adhesive Primers.			X
Non-Destructive Testing (NDT)			
Magnetic Particle			X
Liquid Penetrant		X	
Ultrasonic		X	
Radiography (Not a customer requirement, only used as internal inspection method)		X	
Eddy Current		X	
Digital Radiography (DDA)			X
Sealants (SLT)			
Polysulfide			X
Polythioether			X
Silicones			X
Polyurethanes (Controlled by Nadcap Certification)	X		
Adhesive Promoters			X
Welding (WLD)			
Diffusion Welding			X
Electron Beam Welding			X
Flash Welding			X
Friction / Inertia Welding			X
Fusion Welding (Including Foundry In-Process / Casting Repair)			X
Laser Welding			X
Percussion Stud Welding			X
Resistance Welding		X	
Torch / Induction Brazing			X
Welder / Welding Operator Qualification			X
Metallographic Evaluation Of Welds			X

NOTE: Special Processes that have been determined to be Not Applicable (N/A) to Axillon may still be used but:

- Are verified by subsequent monitoring and measurement,
- Are purchased products controlled by the Supplier and requirements defined in MPRC-10 Supplier Quality Requirements Document (SQRD),
- Are services not provided,
- Are not a service provided as part of a customer requirement but are only used as an inspection point in the production process.

6.0 AXILLON ROCKMART APPROVED SUPPLIER SPECIAL PROCESSES

Supplier / Sub-tier purchase orders for materials and services that affect or become part of the end item product and those requiring the vendor to use a special processor and/or service

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directly or indirectly shall be identified on each purchase order by the use of QA-SP2-G-01 Purchase Order Supplement, Code 79. Sub-tier Vendors listed in the below list of Approved Processors may be 2nd – tier Vendors and therefore not on Axillon Rockmart’s Approved Supplier Listing. Control of such special processors will be handled by Axillon Rockmart’s Direct Suppliers.

Axillon Customer Approved Special Processors shall be used in place of those listed below, in this procedure, if required by the Axillon Customer contract. It is the expectation that only Nadcap Approved Special Processors will be used for all identified special processes when a processor is not required by the Axillon list.

PLATING / COATINGS		
COMPANY	PROCESS	CUSTOMER APPROVALS
Aerospace Defense Coatings Macon, GA 31216	Anodize Per 18-125	Boeing NGC Sikorsky
Aerodynamic Plating Gardena, CA 90249	Anodize Per 18-125	LMCO
Aid Corporation Clayton, GA 30525	Alodine Per 18-125	NGC Sikorsky
Akron Anodizing & Coating Co. Akron, OH 44310	Anodize Per 18-125 Alodine Per 18-125	
Allen Aircraft Products Ravenna, OH 44266	Anodize Per 18-125 Alodine Per 18-125	Boeing LMCO
Anoplate Corporation Syracuse, NY 13204	Anodizing Per MIL-A-8625, Type IC	Sikorsky: SS8483 Type IC (Notes H & T) SS9213, SS8752
Baycote Metal Finishing Mishawaka, IN 46544	Sulfuric Acid Anodize Type II, CLI, Per 18-125	
Beringer Plating, Inc. Akron, OH 44310	Cadmium Plate Per QQ-P-416, Class 3, Type 1	
Coating Technology Oldsmar, FL 34677	Anodize Per MIL-A-8625 Chemical Conversion Per MIL-C-5541	LMCO
Commercial Anodizing Co. Willoughby, OH 44094	Passivate Per QQ-P-35 Anodize Per MIL-A-8625 Alodine Per 18-125	Sikorsky (SS8483)
Deming Industries Coeur D’alene, ID 83814	Anodize Per MIL-A-8625	
Dixie Industrial Finishing Tucker, GA 30085	Passivate Per QQ-P-35 Cadmium Plate Per QQ-P-416	
Dynamic Paint Solutions Eastman, GA 31023	Chemical Conversion Coatings – Aluminum Anodize Per MIL-A-8625 Flourescent Penetrant Per SS8806 Mag Particle Per MIL-I-6868 Salt Spray Per ASTM B117 Eddy Current Per ASTM B244-79	Boeing, LMCO, Sikorsky, NGC, Parker Aero, Bell,
Electrolab, Inc. Tampa, FL 33614	Anodize Per Mil-A-8625F Passivate Per QQ-P-35 Chemical Film Per MIL-C-5541E	LMCO

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Everett Plating, Inc. (EPI) Magnolia, AR 71753	Anodize Per 18-125 & MIL-A-8625 Passivation Per AC7120/12 (18-125) Conversion Coating Per AC7108/11 (MIL-DTL-5541 & MIL-C-5541) (18-125)	
Florida Plating, Inc St. Petersburg, FL 33714	Anodize Per 18-125 Alodine Per 18-125 Cadmium Plate Per QQ-P-416	
Freedom Metal Finishing Clearwater, FL 33520	Anodize Per 18-125 Alodine Per 18-125	LMCO Sikorsky
Har-Conn Chrome Columbus, GA 31907	Anodize Per 18-125 Alodine Per 18-125 Passivate Per QQ-P-35 Cadmium Plate Per QQ-P-416	Boeing LMCO
Hixson Metal Finishing Newport Beach, CA 92663	Anodize Per AC7108/08	
LA Aluminum Casting Company Hayden, ID 83835	Alodine Per 18-125	
Lake City Plating Company Ashtabula, OH 44004	Cadmium Plate Per QQ-P-416	
Lancaster Electro Plating, Inc. Lancaster, OH 43130	Passivate Per QQ-P-35 Cadmium Plate Per QQ-P-416	
Metal Analysis, Inc. Huntington Park, CA 90255	Metallurgical Various	
Mission Plating Los Angeles, CA 90031	Chromate Per MIL-C-17711	
Norco Metal Finishing Knoxville, TN 37920	Anodize Per 18-125 Alodine Per 18-125	LMCO
Novation, Inc. Spokane, WA 99206	Anodize Per 18-125	
Pioneer Metal Finishing Corp Monroe, MI 48162	Anodize Per MIL-A-8625	LMCO
Plainville Electro Plating Plainville, CT 06062	Anodize Per 18-125 Alodine Per 18-125 Cadmium Plate Per QQ-P-416	Boeing
Poly-Metal Finishing, Inc. Springfield, MA 01108	Anodize Per 18-125 Alodine Per 18-125 Cadmium Plate Per QQ-P-416	Boeing LMCO NGC Sikorsky
Precision Hard Chrome Co, Inc. Canton, OH 44706	Anodize Per 18-125 Passivate Per QQ-P-35 Chrome Per QQ-C-320 Copper Per MIL-C-14550	
Pro-Tech Vonore, TN 37885	Anodize Per 18-125 Alodine Per 18-125 Passivate Per QQ-P-35	NGC
Selfridge Plating Harrison Township, MI 48045	Anodize Per 18-125	Boeing LMCO Sikorsky

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Techni-Chrome Corp Titusville, FL 32796	Anodize Per MIL-A-8625	LMCO NGC
Wisconsin Plating Works Racine, WI 53401	Alodine Per 18-125 Passivate Per MIL-STD-171	
Churchill Corporation Melrose, MA 02176	Chem Film / MIL-DTL-5541 Type 1, Class 3, Gold	

HEAT TREATMENT		
COMPANY	PROCESS	CUSTOMER APPROVALS
Al-Fe Heat Treating, Inc. Wadsworth, OH 44281	Aluminum: MIL-H-6088	Boeing NGC
Braddock Metallurgical Boynton Beach, FL 33619	Aluminum: MIL-H-6088 Steel: MIL-H-6875	Boeing NGC
Drever Southern Metal Atlanta, GA 30318	Steel: MIL-H-6875	
Exotic Metal Treating Inc. Indianapolis, IN 46203	Heat Treating	Boeing
Churchill Corporation Melrose, MA 02176	Braze / MIL-B-7883B; Heat Treat/ MIL-H-6088 to T4	
FPM Heat Treating Elk Grove, IL 60007	Aluminum: MIL-H-6088 Steel: MIL-H-6875	LMCO
Hi Tecmetal Group Ttc (HTG) Eastlake, OH 44095	Passivation, Cres A286 Precipitation, AMS5737, Links MIL-H-6875 Solution, Cres A286 Resolution & Precipitation, AMS5737	
Metro Metals Bessemer, AL 35021	Steel: MIL-H-6875	
Missouri Metals St. Louis, MO 63132	Aluminum Alloys (Excluding 7075 T73) SS8043, AMS 2770, AMS 2771, AMS 2772 Aluminum Alloys (Including 7075 T73) SS8043, SS8013, SS8810	Boeing
National Heat Treat Co. Columbus, OH 43212	Steel: MIL-H-6875	
Precision Heat Treating Brooklyn, NY 11222	Steel: MIL-H-6875	
Radius Aerospace – Phoenix Chandler, AZ 85226	AC7102 Accredited: Brazing, Hardness and/or Conductivity Testing, Pyrometry and Heat Treating (Aluminum, Nickle, Cobalt, Stainless Steel & Steel).	
Suncoast Heat Treat, Inc. Orlando, FL 32801	Aluminum: MIL-H-6088 Steel: MIL-H-6875	

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MATERIAL TESTING LABORATORIES	
COMPANY	PROCESS
Aerospace Defense Coatings Macon, GA 31216	Fluorescent Penetrant to SS8806
Aid Corporation Clayton, GA 30525	Magnetic Particle MIL-I-6868
Akron Rubber Development Lab Akron, OH 44301	Rubber & Associated Products & Raw Materials
A.M.W. Material Testing Inc. N. Amityville, NY 11701	Magnetic Particle MIL-I-6868
Anachem Laboratories Los Angeles, CA 90062	Plating Solutions Salt Spray Per ASTM B117
Applied Technical Services Inc. Marietta, GA 30066	Metallurgical, Chemical, F.T.I.R., Ultrasonic Testing
B & P Laboratories Inc. Seattle, WA 98106	Plating Solutions Salt Spray Per ASTM B117
Cincinnati Testing Laboratory, Inc. Cincinnati, OH 45202	Tensile Modules Testing Per BHTI 299-947-299
Electrolab Inc. Tampa, FL 33614	Salt Spray ASTM B117 Coating Wt. MIL-A-8025F Adhesion FED-STD-171
Federal Testing Laboratories Seattle, WA 98109	Salt Spray Per ASTM B117
Garwood Laboratories Pico Rivera, CA 90660	Acoustics & Vibration MIL-S-901 Thermal ASTM B117 Electrical MIL-STD-461
Group Research Inc. New York, NY 10013	Plating Solutions Salt Spray Per ASTM B117
Herron Testing Laboratories Cleveland, OH 44131	Plating Solutions Salt Spray Per ASTM B117
Integrated Technologies, Inc. Bothell, VA 98021	Ultrasonic Glass Transition Short Beam Shear
National Spectrographic Laboratories, Inc. Cleveland, OH 44125	Chemical & Metallurgical
National Technical Systems Boxborough MA, 01719	Test Services, Dynamic, Environmental & Emi
Orbit Industries, Inc. Cleveland, OH	Fluorescent Penetrant Testing IAW ASTM E1417, Type 1, Method A, Level 2
Pioneer Metal Finishing Corp Monroe, MI 48162	Eddy Current ASTM B244-79
Rubber Testing Services, Inc. Akron, OH 44304	Rubber & Associated Products & Raw Materials
Smithers Scientific Services, Inc. Akron, OH 44303	Rubber & Associated Products & Raw Materials
Voss Industries Cleveland, OH	Passivation, Cres A286 & 304 Per AMS2700, Type 6 Fluorescent Penetrant Inspection (FPI) ASTM-E-1417, Type 1, Method A, Level 2

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CALIBRATION SERVICES	
COMPANY	CALIBRATION
Alpha Technology Akron, OH 44305	Rehometer (ISO 9001:2015)
Applied Technical Services Marietta, GA 30066	ISO 10012 ISO/IEC 17025:2017
Brookfield Engineering Laboratories Stoughton, MA 02072	Brookfield Viscometers
Brown & Sharpe Precision / Hexagon Charlotte, NC 28269	CMM Measuring Equipment
Certified Measurements, Inc. Centerville, GA 31028	Instruments, Weights (ISO 10012)
ETA of America Marietta, GA 30067	Instruments
Faro Technologies Wixom, MI 48393	3D Imaging Calibration (ISO/IEC 17025:2017)
GA Dept. of Agriculture Forest Park, GA 30050	Weights & Measures (ISO 10012)
Hach Company Loveland, CO 80539	Air Particle Tester (ISO/IEC 17025:2017)
Industrial Scales of GA Mableton, GA 30059	Scales (ISO 10012)
Instron Canton, MA 02062	Instron (ISO/IEC 17025:2017)
Lumasense Technologies Santa Clara, CA 95054	Temperature & Gas Equipment (ISO 9001:2015)
Scientific Atlanta Norcross, GA 30093	Standards, Hardness Testers , Tensile Testers, Surface Plates, MIL-STD-45662
Southern Gauge Erin, TN 37061	Gauges (ISO 10012)
Scale Systems Inc. Norcross, GA 30093	Scales (ISO/IEC 17025:2017)
TA Instruments New Castle, DE 19720	DMA Calibration (ISO 9001:2015)
VIRTEK – Gerber Technology	VIRTEK Scanners
3-D Metrology Solutions, LLC Villa Rica, GA 30180	Scanning/Data Collection; Create Cad Models

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WELDING		
COMPANY	PROCESS	CUSTOMER APPROVALS
Burrell Enterprises Kennesaw, GA 30152	Resistance Welding – AMS-W-6858A & SS8685 Fusion Welding – AMS-STD-2219 & AWS D17.1	
Bay Tech Industries Tampa, FL 33626	MIL-STD-1595A	Boeing NGC
Dan's Certified Welding, Inc. Downey, CA 90242	Fusion Welding – PS22250	Boeing NGC c/o Boeing

7.0 RECORDS

The control of Axillon procedures shall ensure documents & records are maintained per Axillon Rockmart's QA-MQA20-P-117 Document & Record Control procedure.

8.0 IMPORTANT NOTES

Axillon Special Processes shall remain approved until such time they no longer meet the requirements of this procedure.

Vendors/Suppliers outlined in this ASPL procedure are approved for performance of the Special Processes or Services and shall remain approved until the approval is revoked by Axillon.

9.0 REFERENCED DOCUMENTS

- ISO 9001 – Quality Management Systems (QMS) Requirements
- ISO/IEC 17025 – Competence Of Testing & Calibration Laboratories Requirements
- ISO 10012 – Measurement Management System Requirements
- MPRC-10 – Supplier Quality Requirement Document
- QA-SP2-G-01 –Purchase Order Supplement Codes
- QA-SP2-G-02 – LMCO Purchase Order Supplement Codes
- QA-MQA20-P-117 – Document & Records Control

10.0 APPENDICES

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