

Subcontract Specification Revision Level

Zenix Aerospace Jet Products

Spec	Rev	Title
Boeing		
BAC001PREF	Y	Preface
BAC5000	BB	Sealing, General
	PSD 1-11	
	PSD 1-12	
	PSD 1-13	
	PSD 1-14	
	PSD 1-15	
	PSD 1-16	
	PSD 1-17	
	PSD 1-18	
	PSD 1-19	
	PSD 1-20	
	PSD 1-21	
	PSD 1-22	
	PSD 1-23	
	PSD 1-24	
	PSD 1-25	
	PSD 1-26	
	PSD 6-278	Optional
	PSD 6-281	Mandatory
	PSD 6-285	Optional
	PSD 6-286	Optional
	PSD 6-294	Optional
	PSD 8-22	Mandatory
	PSD 9-21	Mandatory
	PSD 9-61	Mandatory
BAC5000-1	B	
BAC5004	R	
	PSD 1-4	
	PSD 6-118	Mandatory
	PSD 6-130	Mandatory
	PSD 6-131	Mandatory
	PSD 6-139	Mandatory
BAC5004-1	U	
	PSD 6-88	Mandatory
	PSD 6-89	Mandatory
	PSD 8-20	Mandatory
	PSD 8-21	Mandatory
	PSD 9-21	Mandatory
	PSD 9-31	Mandatory
	PSD 9-6	Mandatory
BAC5004-2	AM	
	PSD 1-3	
	PSD 1-4	
	PSD 1-5	
	PSD 1-6	
	PSD 1-7	
	PSD 1-8	
	PSD 6-106	Mandatory
	PSD 6-131	Mandatory
	PSD 6-160	Mandatory
	PSD 6-162	Mandatory
	PSD 6-163	Mandatory
	PSD 6-168	
	PSD 6-82	Mandatory
	PSD 9-26	
	PSD 9-31	

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BAC5004-3	J PSD 1-2 PSD 6-20 PSD 6-21 PSD 6-22 PSD 8-13 PSD 8-14 PSD 9-21 PSD 9-22 PSD 9-23	Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5008	V PSD 1-11 PSD 1-7 PSD 1-8 PSD 9-28	Application of lubricants Optional
BAC5010	AB PSD 1-10 PSD 8-33 PSD 8-34 PSD 8-36 PSD 9-51 PSD 9-53 PSD 9-54 PSD 9-56 PSD 9-57 PSD 9-59	Application of Adhesives Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5019	AA PSD 1-5 PSD 1-6 PSD 1-7 PSD 1-8 PSD 6-135 PSD 6-145	Chromic Acid Anodizing Optional Optional
BAC5022	M 1-5 9-1	Sulfuric Acid Anodic Films Mandatory
BAC5034 BAC5034-1 BAC5034-2 BAC5034-3	T PSD 1-10 PSD 1-7 PSD 1-8 PSD 1-9 M PSD 1-1 PSD 1-2 J PSD 1-1 PSD 1-2 PSD 1-3 PSD 1-4 E PSD 1-1 PSD 1-2	
BAC5047	M PSD 6-104 PSD 6-106 PSD 6-107 PSD 6-108 PSD 6-109 PSD 6-110 PSD 9-2	Fluid Tight Fastener Installation Mandatory Mandatory Mandatory Mandatory Mandatory Optional Mandatory

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BAC5047-1	F PSD 6-25 PSD 6-27 PSD 6-36 PSD 6-43 PSD 6-45 PSD 6-46	Fluid Tight Fastener Installation Mandatory Optional Mandatory Mandatory Mandatory Optional
BAC5049	K PSD 6-19 PSD 6-21 PSD 6-22 PSD 6-23 PSD 6-25 PSD 6-26 PSD 6-27 PSD 6-28	Dimpling and Countersinking Mandatory Optional Mandatory Optional Mandatory Mandatory Mandatory Mandatory
BAC5058	D PSD 6-5 PSD 6-6 PSD 6-7 PSD 6-8 PSD 6-9	Riveting Titanium Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5300 BAC5300-1 BAC5300-2	N PSD 9-22 K PSD 1-1 PSD 1-2 PSD 6-1 PSD 9-1 PSD 9-2 K PSD 6-1 PSD 6-2 PSD 8-2 PSD 8-4	Forming, Straightening and Fitting Metal Parts Mandatory Surface and Edge Integrity of Metal Parts Optional Mandatory Metal Part Forming, Straightening and Fitting Optional Optional Mandatory Mandatory
BAC5307	AH PSD 1-11 PSD 1-12 PSD 1-14 PSD 1-17 PSD 1-18 PSD 1-19 PSD 1-20 PSD 1-21 PSD 6-289 PSD 6-316 PSD 9-108 PSD 9-117 PSD 9-82 PSD 9-99	Part Marking Optional Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5423	Y PSD 6-155	Penetrant Methods of Inspection Mandatory
BAC5424	U PSD 6-40 PSD 8-22 PSD 9-10 PSD 9-12 PSD 9-9	Magnetic Partical Inspection Optional Mandatory Mandatory Mandatory Mandatory

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BAC5435	AA PSD 1-10 PSD 1-5 PSD 6-62 PSD 6-74 PSD 6-75 PSD 9-11 PSD 9-16 PSD 9-18 PSD 9-19 PSD 9-6 PSD 9-8	Bearing Installation and Retention Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5436	J PSD 1-10 PSD 1-7 PSD 1-8 PSD 1-9 PSD 6-72 PSD 6-74 PSD 9-2	Etch Inspection of Machined Steel Optional Optional Mandatory
BAC5439 BAC5439-1	J PSD 6-23 PSD 9-3 PSD 9-4 PSD 9-5 A PSD 6-1	Mandatory Optional Mandatory Mandatory Mandatory
BAC5440	L PSD 6-46 PSD 6-51 PSD 9-5	Hole Preparation Machining Optional Optional Mandatory
BAC5492	T PSD 1-4 PSD 1-5 PSD 9-19	Machining and Cutting Titanium Optional Optional
BAC5601	Y	Obsolete see BAC 5617, 5618, or 5619
BAC5602	AH PSD 1-6 PSD 1-7 PSD 1-8 PSD 1-9 PSD 6-182 PSD 6-184 PSD 6-203	Heat Treatment of Aluminum Alloys Optional Optional Mandatory
BAC5613	V QPL PSD 6-57 PSD 6-58 PSD 6-59 PSD 8-6 PSD 9-15 PSD 9-31 PSD 9-32	Heat Treatment of Titanium and Titanium Alloys Optional Mandatory Mandatory Optional Optional Mandatory Mandatory
BAC5616	L DCNPSO-025915_01	Heat Treatment of Nickel and Cobalt Alloys

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BAC5617	W PSD 8-19 PSD 8-21 PSD 8-22 PSD 8-23 PSD 9-12 PSD 9-13 PSD 9-14	Heat Treatment of Alloy Steels Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory
BAC5619	L PSD 1-5 PSD 1-6 PSD 9-15 PSD 9-16 PSD 9-17	Heat Treatment of Corrosion Resistant Steel Mandatory Optional Mandatory
BAC5621	M PSD 8-6	Temperature Control for Processing Materials
BAC5625	H PSD 1-3 PSD 1-4 PSD 1-5 PSD 6-68 PSD 6-69 PSD 6-70 PSD 6-71 PSD 9-1	Surface Treatment for Ferrous Alloys Optional Optional Mandatory Mandatory Mandatory
BAC5626	C PSD 9-11 PSD 9-16 PSD 9-27 PSD 9-28 PSD 9-30 PSD 9-31	Colored Chemical Conversion Coatings Aluminum
BAC5632	BAC5632 G PSD 1-3	Boric Acid-Sulfuric Acid Anodizing
BAC5650	G PSD 6-4 PSD 6-5 PSD 8-2	Hardness Testing N/A N/A N/A
BAC5651	D	Eddy Current Electrical Conductivity Inspection
BAC5703	K PSD 1-2 PSD 6-8 PSD 9-23 PSD 9-25	Criteria for Limited Contamination Areas Mandatory Mandatory Mandatory
BAC5706	N PSD 6-13 PSD 9-4	Application of Organic Finishes
BAC5709	Y QPL PSD 1-6 PSD 1-7 PSD 1-8	Hard Chromium Plating
BAC5710	AG	Application of Special Purpose Coatings
BAC5716	H	Preparation Color Anodic Films

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BAC5719	AC PSD 1-10 PSD 1-11 PSD 1-12 PSD 1-4 PSD 1-5 PSD 1-6 PSD 1-7 PSD 1-8 PSD 1-9	Chemical Conversion Coatings for Aluminum and Aluminum Alloys -- -- -- -- -- -- -- -- --
BAC5730 BAC5730-1	U PSD 1-3 PSD 1-4 PSD 1-5 PSD 8-19 PSD 8-20 PSD 9-10 D PSD 6-12	Shot Peening Mandatory Optional Shot peen forming Mandatory
BAC5736	AF	Application of Chemical and Solvent Resistant Finishes
BAC5746	M QPL PSD 1-7 PSD 6-42 PSD 6-43 PSD 6-44 PSD 6-46 PSD 9-2 PSD 9-4 PSD 9-5 PSD 9-6	Nickel Plating - Electrodeposited Optional Optional Mandatory Optional Mandatory Mandatory Optional Optional
BAC5748	W PSD 1-5 PSD 1-6 PSD 1-7 PSD 8-10 PSD 8-11	Abrasive Cleaning, Deburring and Finishing Mandatory Mandatory
BAC5750	V DCNPSO- 021180_01	Solvent Cleaning of Metals Composites
BAC5751	P PSD 1-4 PSD 6-69 PSD 8-15	Cleaning Descaling and Surface Prep of Ferrous Alloys Requirement Optional
BAC5753	AB PSD 1-10 PSD 1-11 PSD 1-6 PSD 1-7 PSD 1-8 PSD 1-9 PSD 6-182 PSD 6-183 PSD 6-184 PSD 6-185 PSD 6-189 PSD 8-11 PSD 9-73	Cleaning Descaling and Surface Prep of Titanium Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory Mandatory

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BAC5756	K PSD 1-6 PSD 6-29 PSD 9-2	Application of Heat Treat Protective Coatings Optional Mandatory
BAC5758	L PSD 6-35 PSD 6-36	Cleaning and Surface Prep Nickel and Cobalt Base Alloys Optional Optional
BAC5765	AA PSD 1-8 PSD 1-9 PSD 1-10 PSD 1-11 PSD 1-12 PSD 1-13 PSD 1-14 PSD 1-15 PSD 1-16 PSD 1-17 PSD 6-217 PSD 9-13	Cleaning and Deoxidizing Aluminum Alloys -- -- -- -- -- -- -- -- -- -- Optional Optional
BAC5771	L	Stripping Inorganic Finishes
BAC5786	P	Etch Cleaning of Aluminum Alloys
BAC5811	W QPL PSD 1-7 PSD 1-8 PSD 1-9 PSD 6-34	Application of Bonded Solid Film Lubricants
BAC5814	B QPL PSD 6-1 PSD 9-1 PSD 9-4 PSD 9-6	Application of Bonded Solid Film Lubricants Optional
BAC5821	G PSD 9-8	Hard Anodizing
BAC5842	K QPL PSD 6-18 PSD 6-19 PSD 6-21 PSD 6-22 PSD 6-23 PSD 6-24 PSD 9-10 PSD 9-15 PSD 9-17 PSD 9-3	Chemical Milling Titanium Mandatory
BAC5845	V PSD 1-7 PSD 6-73 PSD 9-17 PSD 9-18 PSD 9-19	Application of Polyurethane Topcoat
BAC5849	R	Brush Plating, Anodizing and Electrochemical Etching

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BAC5851	H QPL PSD 1-6 PSD 9-2	Application of Thermal Spray Coatings
BAC5855	D PSD 1-1 PSD 6-1 PSD 6-2 PSD 6-3 PSD 8-4 PSD 9-1	Grinding and Machining of Thermal Sprayed Coatings Optional Optional Optional
BAC5861	E PSD 1-5 PSD 6-13 PSD 6-18 PSD 9-16 PSD 9-19 PSD 9-24 PSD 9-25 PSD 9-34 PSD 9-36 PSD 9-37 PSD 9-8	Application of Phosphate-Fluoride Coating to Titanium Optional Optional
BAC5882	R PSD 1-6 PSD 1-7 PSD 1-8 PSD 1-9	Application of Urethane Compatible Primer
BAC5884	E PSD 9-10 PSD 9-14 PSD 9-18 PSD 9-19	Anodizing of Aluminum Alloys
BAC5946	AD	Temper Inspection of Aluminum Alloys
BAC5962	E PSD 6-15 PSD 6-30	Qualification and Certification of Welder and Welding Operators
BAC5969	F PSD 8-2 PSD 9-3	Electrical Discharge Machining
BAC5975	R PSD 1-5 PSD 9-1 PSD 9-7	Fusion Welding of Metal
BAC5977	U	Resistance Welding of Metals
BACD2097	AA	Surface Texture (US) Customary and Metric
BACN10KE	AM QPL	Nut, Plate, Self-Locking, Floating 450F and 900F
BMS0-PREF	D	Preface
BMS1-15	J	Cellular Rubber
BMS5-45	N QPL	FUEL TANK SEALANT
BMS5-63	P QPL	Firewall Sealant Hydraulic Fluid Resistant
BMS5-126	H QPL	Adhesive Epoxy
BMS7-108	J QPL	Aluminum Alloy Forged Rings

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BMS7-122	E	Vacuum Arc Remelted 4330 Modified (AMS 6411) Steel
BMS7-193	A	Nickel Base Alloy Castings
BMS7-214	U QPL	Aluminum Forgings
BMS7-240	J	15-5PH Steel Plate and Strip
BMS7-26	R	Steel Bar Forging Stock Forgings and Tubing 4340 Modified
BMS7-27	G	Steel Bar and Forging
BMS7-28	G	Inactive Use AMS 6409
BMS7-334	E QPL	Titanium Alloy Beta 21S Strip and Sheet
BMS7-34	G	4330M Sheet, Strip and Plate
BMS7-380	C QPL	Titanium 6Al-4V and Titanium 6Al-4V Modified Annealed or Creep Flattened Plate
BMS7-416	NC	NICKEL ALLOY 625 RING FORGINGS
BMS7-421	A QPL	Ti 6Al-4V Annealed and 6Al-2Sn-4Zr-2Mo SHT and PHT Bar Flash Welding Ring
BMS7-186	M	Aluminum Alloy Forgings
BMS10-11	AE QPL	Chemical and Solvent Resistant Finish Optional
BMS10-20	T QPL	Corrosion Resistant Finish for Integral Fuel Tanks
BMS10-41	Y	Superseded by BAC 5728
BMS10-6	Y	Aluminum Hard Coating
BMS10-60	AA QPL	Protective Topcoat
BMS10-67	N QPL	Thermal Spray Powders
BMS10-72	AR QPL	Exterior Decorative Paint System
BMS10-79	T QPL	Urethane Compatible Corrosion Resistant Primer
BMS10-86	T QPL	Fluoropolymer Filled Coating
BSS7006	D PSD 6-2	Identification, Classification, Storage of Welding/Brazing Filler Material Optional
BSS7015	Org	Dimensional Control of Castings
BSS7023	AU	Approval and Maintaining Manufacturing Process Control Documents
BSS7025	Org	Establishing and Maintaining Process Control Documents for Metallic Materials
BSS7039	E SSD 6-4 SSD 6-9	Liquid Penetrant Inspection
BSS7040	C PSD 8-1 PSD 8-2 PSD 9-2	Magnetic Partical Inspection
BSS7041	E	Radiologic Inspection
BSS7048	D PSD 9-2	Eddy Current "Insp Discontinuities
BSS7052	C PSD 6-2	Ultrasonic Inspection Mandatory
BSS7055	B SSD 6-4 SSD 6-5	Ultrasonic Inspection Wrought Products Optional Optional
BSS7100	R	Alternative Document Processes, Materials and Parts
BSS7206	F	Peel, Metal to Metal, Adhesive Bond
BSS7221	H	Superseded by BAC 5650
BSS7225	L	Adhesion Tape Test
BSS7286	F	Statistical Process Control of Designated Engineering Characteristics
BSS7348	A	(PSDS) Rate Testing Procedure for Chemical Removal of Metal
BSS7350	F	Rockwell Hardness Testing Procedure
BSS7351	G	Eddy Current Conductivity

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BSS7600	Y PSD 1-1 PSD 9-12 PSD 9-13	Employee Certification General
BSS7646	E PSD 6-2 PSD 6-3	Hardness Testing of Metals Optional Optional
BSS7651	B PSD 6-1 PSD 8-2	Personnel Certification Conductivity Inspection Option
BSS7675	K PSD 6-3	Visual Weld Inspection Certification
BSS7698	K PSD 1-1	Nondestructive Inspection Employee Certification
D10875	P	Inspection Procedures for Aluminum Forgings
D14426	KV Flow Chart Exhibit 1 Exhibit 2 Exhibit 3 Appendix D	Approved Process Sources Check Daily and Monthly for Up-Dates Approved Process Flow Chart Sample Flow Chart for Corrective Action Sample Corrective Action Response Requirements for Compliance to Basic Quality System Appendix D
D37522-6-2	A	Boeing Commercial Airplanes Supplier Packaging
D6-5000	BL	Special Commercial Airplane Finish Codes
D6-51991	N	QA Standard Digital Product Definition
D6-82479	I	QA Management System Requirements for Suppliers
D950 4.1.1	2019	PDT 4.1.1 DPT - Verification
D950112881	2019	4.1.1 PDT Verification
DPS 10.603	NC	Flash Welding of Rings
DPS 10.603	APEO A	Flash Welding of Rings Advance PEO Jan 1988
DPS_3.02	BP	Identification of Parts and Assemblies
PO Notes	1/1/2020	Boeing Purchase Order Notes (in Cust PO Folder)
SB19-227	6/7/2019	Supplier Packaging Revision to D37522-6 and D37522-6-2
Collins Aero		
ASGSQR-003	A	Quality Assurance for Digital Product Definition at Aerostructures Suppliers
ASQR 01	13	Supplier Quality System Requirements Change Summary and FAQ
COL-ASQR-PRO-0003	04	Aerospace Supplier Quality Requirements
FRMS170	D	Aluminum Alloy 7050 Hand Forgings
RPS13.04 SCO 002 SCO 003 SCO 004 SCO 005	B	Machining and Cutting of Titanium
RPS11.14 RPS11.14 SCO 023	R	Fusion Welding of Metals
RPS13.51	V	Chromatic Acid Anodize for Aluminum Alloys
RPS13.52	N	Brush Application of Chemical Conversion Coatings for Aluminum
RPS13.53	W	Application of Chemical Conversion Coatings to Aluminum Alloys
RPS13.55	U SCO 034 SCO 047 SCO 050 SCO 051 SCO 058	Sulfuric Acid Anodize for Aluminum Alloys
RPS13.77	G	Protective Finishes
RPS13.81	U	Application of Dry Film Lubricants
RPS13.83	F	Application of Abrasion Resistant Finishes
RPS13.84	C SCO 006 SCO 007 SCO 009 SCO 010	Application of Heat Resistant Urethane Primer
RPS13.90	N	Identification of Major Assemblies

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RPS13.97	AG SCO 062 SCO 064 SCO 065 SCO 066 SCO 069	Application of Organic Finishes and Dissimilar Metal Protection
RPS13.98	U SCO 014 SCO 015 SCO 016 SCO 018	Temporary Protection of Parts
RPS13.99	AG SCO 078 SCO 080 SCO 086	Parts Marking and Identification Parts Marking and Identification
RPS14.02	AE	Forming and Heat Treatment of Titanium and Alloys
RPS14.05	R SCO010	Forming of Aluminum Alloys
RPS14.10	T	Chemical Milling of Titanium
RPS14.12	G SCO 005	Forming of Corrosion Resistant Steel, Nickel and Cobalt Superalloys
RPS14.20	AF SCO 032 SCO 034 SCO 035	Sealing
RPS14.35	J	Thermal Cutting of Metals
RPS14.80	T	Chemical Milling Ferrous and Nickel Alloys
RPS15.00	AG SCO 009 SCO 012 SCO 013 SCO 018 SCO 020 SCO 022 SCO 031 SCO 036 SCO 040 SCO 042	Surface Prep of Heat and Corrosion Resistant Alloys
RPS15.06	G	Stripping Process for Organic Finishes
RPS15.11	N	Vapor Degreasing and Manual Solvent Cleaning
RPS15.45	AG SCO 058	Surface Preparation of Titanium
RPS15.51	G SCO 003	Abrasive Blast Cleaning
RPS15.52	K SCO 047 SCO 065 SCO 066 SCO 069	Cleaning of Aluminum
RPS15.53 SCO 002	C	Aqueous Cleaning
RPS16.01 SCO 021 SCO 022 SCO 023 SCO 024	L	Shop Fabrication Standards
RPS17.63 SCO 016 SCO 017	C	Cementing Metal, Rubber and Plastic
RPS18.06	D	Inspection of Castings and Forgings
RPS18.10 SCO 012	H	Penetrant Inspection
RPS18-11	E	Hardness and Conductivity Testing
RPS20.03 SCO 007 SCO 008	M	Bearing Installation and Retention

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RPS20.17 SCO 014 SCO 015	P	Control of critical parts
RPS20.18	A	Source and Method Control of Rolls-Royce Parts and Assemblies
RPS20.19	NC	Traceability of Rolls-Royce Parts
RPS20.20 SCO 023 SCO 024 SCO 025 SCO 026 SCO 027	P	Substitution of Materials
RPS20.50	C	Material Substitution After April 2004