

# Minutemen Precision Machine and Tool Corporation

135 Raynor Avenue, Ronkonkoma, NY 11779

Ph: 631-467-4900 Fax: 631-467-6850

MinutemenMachining.Com

## Minutemen Special Process

MSP-1001 Rev. -

WORK TO BE ACCOMPLISHED IN PERFORMANCE OF THIS PURCHASE ORDER IS DIRECTLY RELATED TO A TRIUMPH AEROSTRUCTURES-VOUGHT AIRCRAFT DIVISION PO" - AIRBUS-

Material : ABS5268B1500

Precipitation hardened stainless steel

Hardness: Rm 1655 (Rc 50)

\*\*\*\*\*These are fatigue critical components Handle with care \*\*\*\*\*

\*\*\*\*\*Not to be left unprotected between shifts.\*\*\*\*\*

\*\*\*\*\*Any damage to the metallic surface (scratches, dents etc.) shall result in the part being identified as Non-Conforming. It is prohibited to obscure such damage by repairing the paint scheme.\*\*\*\*\*

Adherence to the manufacturing specifications is vital to achieve the required level of quality for these parts. No changes are to be made without written approval from Airbus.

a. Clean & Degrease using organic solvent Per ABP 8-1294 were appropriate as required by top level specification

\*\*\*\*\* DO NOT ETCH INSPECT PRODUCTION PARTS \*\*\*\*\*

b. De-Embrittlement per ABP 6-5225 Para 5.4 200C +/- 10C (60 mins)

c. Magnetic Flaw Detect Per ABP 6-5229

d. Mask all holes from Abrasive Blast, Prime and Paint (Step omitted for parts without holes)

Note: Ensure no abrasive blast grit impacts or enters the hole bore. Overspray in the hole underhead radius and/or deburr radius is acceptable.

e. Abrasive Blast per ABP 1-2344

Note: Surface must receive 100% minimum grit blast coverage to ensure paint adhesion

f. If plugs are to be cut flush with surface of parts ensure there is no scoring of the part surface. (Step omitted for parts without holes)

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- g. Prime Per ABP 4-1123
- h. Prepare surfaces in accordance with ABP 5-1351 Method 1 if flexible finish is not applied within two hours of cure of primer.
- i. Apply Flexible finish paint Method 1 per ABP 4-2130.
- j. Remove plugs. Do NOT use metal implements to remove the plugs, as this may score the holes. Use a suitable non-metallic tool. (Step omitted for parts without holes)
- k. Inspect holes for any surface damage (Step omitted for parts without holes)
- l. Apply dewatering fluid to all holes per ABP 1-4046 (Class 1) (Step omitted for parts without holes)
- m. Dispatch inspection.