

Summary of Changes

095871 Contract Deliverable Requirements (CDR)

Rev 19

This serves as notification that our BAE Systems Contract Deliverable Requirements (CDR) has been updated. Please note that the changes below are listed with the older version first, then the new revision is below it, unless otherwise noted. Please see the following changes/additions/deletions:

Legend:

- Addition
- Change
- Deletion

007A Welding Combat Vehicles Inspection Criteria

- Form 090475 shall be submitted and approved with accompanying 091460 First Submission Weld Roadmap as applicable prior to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item.
- All visual weld inspection must be conducted by either of the following 3 inspector certification platforms, and completed and documented on 100% of all welds.
 - An American Welding Society certified CWI, SCWI
 - A qualified CWB level 2 or 3 through the Canadian Welding Bureau as determined through the Canadian Standards Association.
 - A Government CWI or TARDEC Quality Assurance CWI approved welding inspector certification program.
- All visual weld inspection on armor steel and quenched and tempered steel must be held for 48 hours prior to final inspection.
- Where NDT is required per print, all welded armor steel and low alloy steels 100 KSI tensile strength or greater shall be held a minimum of 48 hours prior to NDT inspection, this is for welded material.
- Welding fixtures to be designed per ASME Y14.43

007A Welding Combat Vehicles Inspection Criteria

Visual Testing (VT) SHALL be completed and documented on 100% of all welds. The Certificate of Conformance Weld Certification Form 090475 SHALL be submitted with **all shipments**. For the **first shipment**, the First Submission Weld Roadmap Form 091460 SHALL also be included with the Certificate of Conformance Weld Certification Form. Documentation shall be submitted and approved **PRIOR** to shipment of the item in accordance with the Data Submission Instructions located in the Supplier Quality Assurance Manual (SQAM) paragraph 8.12 for this item.

All Visual Testing (VT) SHALL be conducted by one of the following certification platforms:

- An American Welding Society Certified Welding Inspector (CWI) and/or Senior Certified Welding Inspector (SCWI)
- A qualified CWB Level 2 or 3 through the Canadian Welding Bureau, as determined through the Canadian Standards Association.
- Other certifications, as defined by the applicable Weld Code and/or Specification

All Visual Testing (VT) on armor steel and/or quenched and tempered steel SHALL be held for 48 hours PRIOR to final inspection. When NDT is required per the drawing, all welded high strength steels including, but not limited to, armor steel and low alloy steels 90 KSI (620MPa) in tensile strength or greater SHALL be held a minimum of 48 hours PRIOR to NDT inspection.

030E High Strength Fasteners for Naval Products

The following is a Legacy Weapons Systems requirement for all High Strength Fasteners

THIS IS A HIGH STRENGTH FASTENER. ALL HIGH STRENGTH FASTENERS (HSF) OF THIS TYPE ARE REQUIRED TO MEET THE FOLLOWING REQUIREMENTS: ANY OF THE HSF ITEMS NOT MEETING THE BELOW REQUIREMENTS IS CAUSE FOR REJECTION, WITHOUT EXCEPTION.

******NOTE: ALL OF THE LISTED CDR REQUIREMENTS MUST BE APPROVED PRIOR TO DELIVERY. NO EXCEPTIONS. ANY DELIVERY WITHOUT APPROVAL WILL BE REJECTED AND RETURNED TO SUPPLIER******

HIGH STRENGTH FASTENER SPECIAL REQUIREMENTS

High strength fasteners (HSF) currently can only be zinc or zinc/nickel plated to (96-11402, only when the drawing states this requirement) and must be plated at Nico plating (Minneapolis, MN).

All other HSF: The following applies:

- Plating for all HSF must be completed by:

NICO PRODUCTS
2929 1ST AVENUE SOUTH
MINNEAPOLIS, MN 55408
(PH) 612-822-2185

When placing these on order with Nico Products, the PO to Nico Products must state that these are for BAE Systems, Weapons Systems, and that these instructions must be flowed down to Nico Products.

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HIGH STRENGTH FASTENER SPECIAL REQUIREMENTS

High strength fasteners (HSF) currently can only be zinc or zinc/nickel plated to (96-11402, only when the drawing states this requirement) and must be plated at Nico plating (Minneapolis, MN) and purchased from E & A Products.

All other HSF: The following applies:

- Procurement of all HSF must be through:

E & A PRODUCTS CO INC
11885 Brockton Lane
MAPLE GROVE, MN 55369

- Plating for all HSF must be completed by:

NICO PRODUCTS
2929 1ST AVENUE SOUTH
MINNEAPOLIS, MN 55408
(PH) 612-822-2185

When placing these on order with Nico Products, the PO to Nico Products must state that these are for BAE Systems, Weapons Systems, and that these instructions must be flowed down to Nico Products.