

**Société Safran émettrice :**  
 Safran Landing Systems Gloucester

**prononce la qualification sur les référentiels indiqués suivant GRP-0087 – GRM-0123.**  
*grants the qualification on the specifications indicated as per GRP-0087 – GRM-0123.*

### Fundacion CIDETEC


191 Paseo De Miramon  
 Donostia, San Sebastian

**Pour les procédés spéciaux suivants, les domaines sont précisés page suivante**  
*For the following special processes, refer to next page for scope definition*

N° procédé Safran Safran process N°	Procédés Processes	Référentiel Technique Technical	Statut Status	Restrictions techniques Technical limitation	Fin de Validité Expiration Date
4.4.2	Fluorescent Penetrant Inspection	PCS 3200	QUALIFIED		WITHOUT EXPIRATION
4.4.2	Penetrant Inspection of Ground Chrome Plate	PCS 3002	QUALIFIED		WITHOUT EXPIRATION
4.2.1	Magnetic Particle Inspection	PCS 3100	QUALIFIED		WITHOUT EXPIRATION
11.2.2	Etch Inspection of High Strength Steel Parts	PCS 3600	QUALIFIED	UHTS 300M Material	WITHOUT EXPIRATION
4.10.1	Barkhausen Noise Inspection	PCS3700	QUALIFIED	Set up for A330 Retraction Actuator, Pison Rod and Cylinder part numbers 50-2113001-00 & 50-2113002-00	WITHOUT EXPIRATION
12.5.4	Stress Relieving	IFC40-606-01MD	QUALIFIED		WITHOUT EXPIRATION
9.3.2	Alkaline Cleaning of Parts/Cold Degreasing	PCS2621/2622	QUALIFIED		WITHOUT EXPIRATION
N° de rapport Report No.	Observations Remarks				
CRQPS0099 Issue 0	Certificate issued following audit of Barkhausen Noise Inspection audit and review of all other NDT processes				

La validité des qualifications des fournisseurs est confirmée et actualisée par la publication de la liste des procédés spéciaux qualifiés sur le site (AIRCOLLAB : www.boostaerospace.com/aircollab/). L'activation des accès fournisseurs à ce site se fait par demande à l'adresse suivante : saf.admin-gps@safran.fr / The supplier qualification validity is confirmed and updated by the publication of qualified special process list on website (AIRCOLLAB: www.boostaerospace.com/aircollab/). The activations of suppliers access to the website will be done upon request to this following email address: saf.admin-gps@safran.fr

**Auditeur / Responsable de la Qualification**  
Auditor / Qualification Leader

Date :	Nom / Name :	Signature / Visa :
14th October 2019	Antony Ford	

## Domaine de Qualification des Procédés Spéciaux

### Special Processes Qualification Scope

Identification des installations <i>Facilities identification</i>	Caractéristiques de l'installation <i>Facilities features</i>	Matériau(x) <i>Material(s)</i>	Domaine d'utilisation <i>Operating scope</i>	Commentaires <i>Comments</i>
NDT Penetrant Line	Pre-cleaning using Ardrox 6333 and cold solvent if appropriate	Inspection of ground chromium plate	Tank size 1300X500X800mm	Validation of process parameters by use of Tesco NiCr 10,20,30 microns
MPI Bench - CND Conception Serial Number :2016-1282	IdS.o.06.111	Magnetic Steels	500-5000Amp FWDC 1282.60 500mm 5 Turn Coil (3000-10000 A.t)	Validation pieces : Ketos Ring IdS.P.10.006, and known defect shim on part - IdS.F792-032
Etch Line	Tank 5 – Cleaning 8-10% Ardrox 6333 55±5°C Tank 6&7 DI Water Rinse Tank 8 Etch Tank 9 DI Water rinse Tank 3 DI Hot Water Rinse Oven dry 65±8°C	All tanks fabricated from Polypropylene	Size of all Tanks 1.3X0.5X0.8M containing 500 litres of solution	Water conductivity 13µS/cm 300M alloy test piece Parts are dried and coated with WADIS 24/60 before inspection <b>Local etch approved using bath solution (Tank 8) REF CID-FT-10.001B</b>

Rollscan 250	Automated controlled system. Evaluates and records values in realtime using Viewscan software	Base material and Ground Chrome Plate	Spherical Inspection using conforming probes	Single Standard/Setting piece 16DMP12621401 – 300m material. Utilises '2 sample method' by showing distinct, significant differences of a 'standard condition' against a 'burnt condition'
Cleaning Tank 4	Ardrox 6333 (PCS 2621) Cleaning system complimented with cold solvent degreasing to PCS 2622 (Acetone)	Steel and Ground Chrome Plate	For cleaning prior to FPI & MPI processes	ECCI Laboratory Report 18-2152 Issue 0 refers
Cleaning Tank 5	Ardrox 6333 (PCS 2621) Cleaning system complimented with cold solvent degreasing to PCS 2622 (Acetone)	Steel	For cleaning prior to Etch process	ECCI Laboratory Report 18-2152 Issue 0 refers
Grit blast cabinet	Fitted with rotating table	Aluminium Oxide MESH 90	Nozzle distance 15-20cm	Used for preparation of parts prior to the etching process