

Unison Industries Quality Directive	
Document Number: QD 4.6.2.4	Revision: 04/17/2023
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
17504	Heat Treat	Nitro-Vac Heat Treat (Warren) Any MIL-H-7199 or Heat Treat (HT) NADCAP approved special processors	HT HT
17534	Passivation	Alert Plating Company (Sun Valley, CA) B-D Industries (Elkhart, IN) BGM Fastener Company (Honesdale, PA) C.H. Thompson (Binghamton, NY) Computech Mfg. Marsam Metal Finishing (New Britain, CT)	CP CP, NDT CP CP WLD CP, NDT
24585	Electro-polishing of Stainless-Steel parts	Any Chemical Processing (CP) NADCAP approved special processors	CP
24619	Polytetrafluoroethylene one coat enamel (Not a NADCAP special Process)	Donwell Co. Inc. (Manchester, CT)	None
24740	NI Plating	Any QQ-N-290 or Chemical Processing (CP) NADCAP approved special processors	CP
24745	Solder Coating of AL, Steel, and CU bearing alloy parts	Any Chemical Processing (CP) NADCAP approved special processors	CP
55102	AL Dip Brazing	Dip Braze Inc. (Sun Valley, CA) Parfuse Corp. (Westbury)	HT HT
55182	Chromate coating of AL	Any MIL-C-5541 or Chemical Processing (CP) NADCAP approved special processors	CP
55321	Electroless NI Plating	Any AMS 2404 or Chemical Processing (CP) NADCAP approved special processors	CP
55427	AG Plating of CU Base Alloys	Any QQ_S-365 or Chemical Processing (CP) NADCAP approved special processors	CP
55581	NI Plating	Any QQ-N-290 or Chemical Processing (CP) NADCAP approved special processors	CP
105572	NI Plating of STL and SST	Any QQ-N-290 or Chemical Processing (CP) NADCAP approved special processors	CP
105750	Electroless NI Plating of AL	Any MIL-C-26074 or Chemical Processing (CP) NADCAP approved special processors	CP
125553	Hot Tin Dip	Any MIL-T-10727 Type II NADCAP approved special processors	CP
175223	Vacuum Furnace Heat Treat of TI Bifurcation Box per PWA 11-32	Metals Technology (formerly Metallurgical Processing - Carol Stream) [Customer Approved Source]	None
9-1542	Acid Bright Dip, CU and AL Alloys	Any Chemical Processing (CP) NADCAP approved special processors	CP
9-1677	Silver Brazing	Computech Mfg. Nitro-Vac Heat Treat (Warren) Parfuse Corp. (Westbury) Any Heat Treat (HT) NADCAP approved special processors	WLD HT HT HT
9-1882	AG Plating	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Amphenol Corp. (Sidney, NY) Tri-Star Electronics (El Segundo, CA) **	CP CP CP None None
9-2158	Cadmium Plating	Alert Plating Company (Sun Valley, CA)	CP

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9-2335	Gold Plating	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Amphenol Corp. (Sidney, NY)	None
		Tri-Star Electronics (El Segundo, CA) **	None
9-2357	Copper Plating	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
9-2360	Zinc Plating of Aluminum	ADTEC II (Tampa, FL)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
9-2530	Finish, Zinc Plating	ADTEC II (Tampa, FL)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		BGM Fastener Company (Honesdale, PA)	CP
9-2656	Silver Brazing (Grade RT)	Any Heat Treat (HT) NADCAP approved special processors	HT
9-2827	AMS 2400 w/ Black Finish	Alert Plating Company (Sun Valley, CA)	CP
		BGM Fastener Company (Honesdale, PA)	CP
9-2869	Pre-Tin & Solder with 50/50 solder & rosin base flux	Prompton Tool (Honesdale, PA)	None
9-2902	Pre-Tin & Solder with 10SN, 2SB .5 AG Bal PB with rosin flux	Prompton Tool (Honesdale, PA)	None
9-2920	SN Plating & fusing of SN on AL	Any MIL-T-10727 Type I or Chemical Processing (CP) NADCAP approved special processors	CP
9-2929	Cadmium Plating	Alert Plating Company (Sun Valley, CA)	CP
		BGM Fastener Company (Honesdale, PA)	CP
9-3005	Res Spot Weld of Non-Hard Steel NI Alloys, Class B Welds	Prompton Tool (Honesdale, PA)	None
9-3005-1	Res Spot Weld of Non-Hard Steel Alloys, Not Precipitation Hardened	Ferco Tech Corp. (Franklin)	NDT, WLD, NM
		Prompton Tool (Honesdale, PA)	None
9-3025	Res Spot Weld of AL, MG and Alloys (Class B Welds)	Prompton Tool (Honesdale, PA)	None
9-3025-1	Res Spot Weld of AL, MG and Alloys (Class C Welds)	Prompton Tool (Honesdale, PA)	None
9-3026	Cadmium Plating and Chromate Treatment	Alert Plating Company (Sun Valley, CA)	CP
		BGM Fastener Company (Honesdale, PA)	CP
9-3033	Brush Treatment of Iridite #14 (AL-coat) on localized surface (Not a NADCAP special Process)	Alexandria Metal Finisher (Alexandria, VA)	CP
		B-D Industries (Elkhart, IN)	CP, NDT
		Tri-Star Electronics (El Segundo, CA) **	None
9-3047	Cadmium on AL, Olive Drab Treatment	Alert Plating Company (Sun Valley, CA)	CP
		Amphenol Corp. (Sidney, NY)	None
		Any QQ-P-416, CL2, TYPE II or Chemical Processing (CP)	CP
		NADCAP approved special processors	
9-3139	Annealing Aluminum	Parfuse Corp. (Westbury)	HT
9-3147	Copper Plating on Aluminum	Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None

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Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-3150	Anneal SS 430 tubes	Paulo Products Company (Kansas City, KS)	HT
9-3155	Solder, Solid and Rosin Cored .5 (Not a NADCAP special Process)	Prompton Tool (Honesdale, PA)	None
9-3232	Tackwelds	Prompton Tool (Honesdale, PA)	None
9-3232-2	Weld of Non-Hard Steel, NI and Heat Resist Alloys	Prompton Tool (Honesdale, PA)	None
9-3264	Protective Treatment for Silver Plate (Not a NADCAP special Process)	Booth Electrosystems Inc Deutsch Hermetic Connector Ideal Plating and Polishing	N/A N/A N/A
9-3283	PreTin & Solder 95SN/5SB Solder and Rosin Base Fluxes (Not a NADCAP special Process)	Prompton Tool (Honesdale, PA)	None
9-3290	Aluminate #225 Treatment of AL	B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY) Any MIL-A-8625 Type III NADCAP approved special processors	CP, NDT CP CP
9-3350	Chemical Conversion Coating on AL	Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY) Tri-Star Electronics (El Segundo, CA) ** Any MIL-C-5541, CL 1A or Chemical Processing (CP) NADCAP approved special processors	CP CP CP CP None CP
9-3380	PreTin & Solder 95SN/5SB Solder and Acid Flux (Not a NADCAP special Process)	Prompton Tool (Honesdale, PA)	None
9-3381	PreTin & Solder 95SN/5SB Solder with Nokorode Flux (Not a NADCAP special Process)	Prompton Tool (Honesdale, PA)	None
9-3406	AU with a NI base	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** Any MIL-G-45205, AMS 2422, or Chemical Processing (CP) NADCAP approved special processors	CP CP CP None CP
9-3435	Bright Nickel Plating on AL	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Amphenol Corp. (Sidney, NY) Tri-Star Electronics (El Segundo, CA) ** Any QQ-N-290 or Chemical Processing (CP) NADCAP approved special processors	CP CP CP None None CP
9-3487	Sulfuric Acid Anodize	B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY)	CP CP
9-3500	Res Spot Weld of AL &, MG, and their Alloys Tack Welds	Prompton Tool (Honesdale, PA)	None
9-3564	NI Alloy Direct Aging Rockwell 15N76 Minimum	Any Heat Treat (HT) NADCAP approved special processors	HT
9-3608	Application of Teflon Coat to Steel, Ceramic & AL Parts (Not a NADCAP special Process)	Cerco (Shreve) Donwell Co. Inc. (Manchester, CT)	None None

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Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-3619	Bright Dipping Aluminum	Any Chemical Processing (CP) NADCAP approved special processors	CP
9-3635	Fine Silver Brazing of Metallized Ceramics	MPF Products (Gray Court)	None
9-365	Process HT-TR RH-C30/35 STLAMS 6320 AMS 6330	Any Heat Treat (HT) NADCAP approved special processors	HT
9-3742	Copper Brazing	Deringer Nye MPF Products (Gray Court)	None None
9-3791	Copper Plating Metallized Ceramics	Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) **	CP None
9-4027	Steel, Stainless, CR AISI Type 410 or 416 Annealing	Nitro-Vac Heat Treat (Warren) Paulo Products Company (Kansas City, KS)	HT HT
9-4029	Nickel Plating Metallized Ceramics	Any Chemical Processing (CP) NADCAP approved special processors	CP
9-4187	Weld Oper. & Equip., must be certified for Type Weld per MIL-STD-1595	Airway Welding Inc (Jackson) Computech Mfg. (Washington, MO) Ferco Tech Corp. (Franklin) Florida Metal Services (Largo, FL) MPF Products (Gray Court) Prompton Tool (Honesdale, PA) ** Two Witches Welding (formerly Superior Welding in McDonough, NY)	WLD WLD NDT, WLD, NM None None None None
9-4259	Black Oxide Treatment for Stainless Steel (Conversion Coating)	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA)	CP CP
9-4332	Cadmium Plating with a Nickel Base	Alert Plating Company (Sun Valley, CA)	CP
9-4747	Aluminum Flux Dip Brazing & Heat Treat	Dip Braze Inc. (Sun Valley, CA) Parfuse Corp. (Westbury)	HT HT
9-4804	Silver and Gold Plating per 9-1882 and 9-2335	Alert Plating Company (Sun Valley, CA)	CP
9-4853	17-7PH Stainless Steel Heat Treat to RH 950 condition	Any AMS 5528 or Heat Treat (HT) NADCAP approved special processors	HT
9-492	Heat Treatment of Beryllium CU Alloy	Nitro-Vac Heat Treat (Warren) Tri-Star Electronics (El Segundo, CA) **	HT CP
9-4960	Olive Drab Cadmium Plating with NI Base Plate	Alert Plating Company (Sun Valley, CA)	CP
9-4966	Bright Tin-Lead Solder Plate AL and AL Alloys	ADTEC II (Tampa, FL)	CP
9-5015	Bright Tin-Lead Solder Plate Ferrous and Non-Ferrous Alloys	ADTEC II (Tampa, FL)	CP
9-515	Black Oxide, Steel	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA)	CP CP
9-5500	Tin-Lead Coating, Hot Dipped 60 to *0% Tin	Any Chemical Processing (CP) NADCAP approved special processors	CP
9-5885	Passivation of Stainless Steel Similar to QQ-P-35	Alert Plating Company (Sun Valley, CA) B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY)	CP CP CP

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9-5895-2	MFG of Ceramic Semiconductors by Semiconductive Paint Penetr.	ADTEC II (Tampa, FL)	CP
9-5934	Silver Brazing of Tungsten Carbide to Steel	Any Heat Treat (HT) NADCAP approved special processors	HT
9-5955	Bright Tin Plate AL and AL Alloys	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
9-5966	Bright SN on Ferrous & CU Alloys Similar to MIL-T-10727	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
9-6002	CR Plating Aluminum	Alexandria Metal Finisher (Alexandria, VA)	CP
9-6191	HT Inconel X750, AMS 5582 or AMS 5667	Any Heat Treat (HT) NADCAP approved special processors	HT
9-6569	Application of Primer and FEP Enamel to AL (Not a NADCAP special Process)	Any Coating (CT) NADCAP approved special processors	CT
9-6594	Electroless NI Plating and AL Alloys	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
9-6612-2	Teflon-S Finish (Black)	Any Chemical Processing (CP) or Coating (CT) NADCAP approved special processors	CP or CT
9-6697	Bright SN on ferrous & CU Alloys (Similar to MIL-T-10727, type I)	ADTEC II (Tampa, FL)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
9-6744	NI Alloy Brazing, Low temperature	Any Heat Treat (HT) NADCAP approved special processors	HT
9-6768	AG Brazing (50AL/16CD/15.5ZN/15.5CU/3NI) Easy Flo 3	Any Heat Treat (HT) NADCAP approved special processors	HT
9-6800-G	Gold Plating Elec. Contacts	Any Chemical Processing (CP) NADCAP approved special processors	CP
9-6880	Bright Tin Plating Stainless Steel	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
9-689	Process HT-TR RH-C35/40STL SAE 4130 SAE 8630	Any Heat Treat (HT) NADCAP approved special processors	HT
9-6914	ECD NI Alloy Plating, TYPE ENC Aluminum and Alloys	Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
9-6972	NI Alloy Plating Al & AL Alloys	Alert Plating Company (Sun Valley, CA)	CP
9-7510	Silver Brazing	Any Heat Treat (HT) NADCAP approved special processors	HT
9-7519	Bright Tin Plating Stainless Steel	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
9-7599	Bright SN Plate CU & CU Alloys with a NI Base Plating	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None

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Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-8003	Heat Treating	Any Heat Treat (HT) NADCAP approved special processors	HT
9-807	Tin Plating (Similar to MIL-T-10727, Type I)	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
9-8074	Painting - Teflon-S. Green	Any Chemical Processing (CP) or Coating (CT) NADCAP approved special processors	CP or CT
9-809	Process HT-TR SST AISI 416 Rockwell-C18/24	Any MIL-H-6875 or Heat Treat (HT) NADCAP approved special processors	HT
9-885	NI Plating (Similar to QQ-N-290)	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Amphenol Corp. (Sidney, NY) **	None
		Tri-Star Electronics (El Segundo, CA) **	None
		Any QQ-N-290 NADCAP approved special processors	CP
9-997	Passivation of Stainless Steel (Similar to QQ-P-35)	Alert Plating Company (Sun Valley, CA)	CP
		B-D Industries (Elkhart, IN)	CP
		BGM Fastener Company (Honesdale, PA)	CP
		C.H. Thompson (Binghamton, NY)	CP
		Computech MFG	None
		Any QQ-P-35 NADCAP approved special processors	CP
CI10016	Anodic Coating on AL from Chromic Acid with DIC Seal	Any MIL-A-8625, AMS 2470 or Heat Treat (HT) NADCAP approved special processors	CP
CI10035	Gold Plating on CU Alloys	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Any MIL-G-45204 NADCAP approved special processors	CP
CI10061	Heat Treatment of Rene 41	Any Heat Treat (HT) NADCAP approved special processors	HT
CI10113	Aluminum Backshells	Any MIL-C-5541 NADCAP approved special processors	CP
CI1032	AL Dip Brazing	Parfuse Corp. (Westbury)	HT
		Any AMS 4117 NADCAP approved special processors	HT
CI1033	CU Plating	Any MIL-C-14550 NADCAP approved special processors	CP
JS0160	Black Finish, Cold	Any Chemical Processing (CP) or Coating (CT) NADCAP approved special processors	CP or CT
JS0189	Silver Brazing (Alloy 9-7493)	Any Heat Treat (HT) NADCAP approved special processors	HT
JS0236	Bright Tin-Lead Solder Plate Al & AL Alloys	Alexandria Metal Finisher (Alexandria, VA)	CP
JS0258	Electroless NI/AL	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Alexandria Metal Finisher (Alexandria, VA)	CP
		Tri-Star Electronics (El Segundo, CA) **	None
		Any Chemical Processing (CP) NADCAP approved special processors	CP
JS0261	Plating, Bright Tin of Al & AL Alloys	Alexandria Metal Finisher (Alexandria, VA)	CP
JS0378	Plating, Bright Tin of Ferrous Alloys	Alexandria Metal Finisher (Alexandria, VA)	CP

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JS0379	Coating, Electroless Ni of Ferrous Alloys	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA)	CP CP
JS0491	Oxidation of Silicon Iron Laminations (<i>Not a NADCAP special Process</i>)	HTG, Nettleton Steel	N/A
JS1487	Bi-Metal Transition Material (<i>Not a NADCAP special Process</i>)	High Energy Metals	N/A
JS1676	EDM Machining (generic process specification)	Any Nonconventional Machining (NM) NADCAP approved special processors	NM