

Unison Industries Quality Directive		
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Document Number: <b>QD 4.6.2.4</b> Revision: <b>05/24/2023</b>		Approved by: Unison Quality Leaders: Christine Hannon (NOR), John Rogers (JAX), Jesus Escandon (SWC) and Keri Calero (Unison SQM)
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## **TITLE: SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL**

**PURPOSE:** This procedure defines the supplier and supplier sub-tier requirements for special processors, special processes, and related controls when invoked on the purchase order. Where the requirements of this document conflict with S-1005, this document shall take precedence.

### **1.0 GENERAL**

- 1.1 Unison defines the following categories as special processes: chemical processing, coatings, heat treat, non-destructive test, non-conventional machining, surface enhancement, and welding. Appendix A shows each category and identifies the processes within each category.
- 1.2 Unison uses NADCAP certified suppliers for special processes as flowed down by our customers' requirements. Unison reserves the right to determine the suitability of supplier or sub-tier-provided special processes to a proprietary Unison specification.

### **2.0 SPECIAL PROCESS DOCUMENTATION**

#### **2.1 Special Processor Procedures**

Special processors shall maintain procedures that define each of their special processes inclusive of the process parameters and critical process characteristics, certification requirements of their certifying personnel, and approval authorities for work instructions and personnel certifications.

Special process documentation for flight safety items shall be considered frozen processes. The process and the associated process parameters shall not be changed without written approval from Unison which may also require approval from our customer.

Special processors are not subject to an individual FAI or PPAP if solely providing a service. However, special processors are required to furnish Unison or the Unison first tier supplier with certification documentation in accordance with section 2.2 of this document. Special process(es) must be documented on the products' FAI and/or PPAP. Special process certification(s) must also be included in the part qualification package.

#### **2.2 Special Processor CofC**

In addition to the CofC requirements listed in S-1005, special processors shall provide a CofC identifying the Unison or industry specifications that the special process was performed in accordance with. The supplier shall notate on the CofC applicable approved supplier requests (SRs).

#### **2.3 Record Retention**

Special Processors shall maintain special process records in accordance with record retention requirements listed in S-1005. Special process records include but are not limited to routers/travelers/process sheets, material verification records (i.e., x-ray

Unison Industries Quality Directive	
Document Number: QD 4.6.2.4	Revision: 05/24/2023
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

films, lab metallography records, etc.), employee training records, inspector and/or operator vision tests results, and calibration records.

### 3.0 AUDITING OF SPECIAL PROCESSORS

Special processors used as a direct supplier to Unison shall be audited on a 3-year frequency. However, Unison accepts NADCAP certifications as justification to waive the special process audit requirement. If the supplier demonstrates repeated poor quality performance history, the Supplier Quality representative may elect increase audit frequency as appropriate based on level of risk.

### 4.0 USE OF SUBTIER SUPPLIERS

All suppliers and their subtiers used for special processes must either be NADCAP certified for the category of the special process they are performing or listed on the Unison's Approved Processor List. "Appendix B" lists Approved Processors List by Unison proprietary specification. **For Unison specific specifications only, the supplier must hold a NADCAP certification for the category that they are performing but are not required to have the Unison specific process listed as part of their NADCAP scope.** "Appendix A" lists the NADCAP certification and examples of the processes that are associated with the NADCAP certification category.

Suppliers which outsource special processes to their subtier remain the responsible party for final product quality and conformance to the technical and purchase order requirements. The Unison supplier is responsible to flow down and technical and purchase order requirements to the subtier. Where technical data is shared with the subtier, the supplier shall ensure that there is a signed Non-Disclosure Agreement (NDA) in place with the subtier supplier.

### 5.0 NONCONFORMANCES

Special process nonconformances shall be communicated to the buyer, supplier quality and engineering through the submission of a supplier request (SR). Special processors shall submit the SR through the SR workflow located on the supplier portal (link: <https://app.sc.ge.com/sites/1569350/portal/1053884>). A copy of the approved SR shall be included in the box with any additional product paperwork.

The supplier shall submit Form GT1005-1 "Unusual Visual Appearance" (UVA) for visible variation of the parts' appearance that may be perceived as a nonconformances. A copy of the approved UVA shall be included in the box with any additional product paperwork.

### 6.0 DEFINITIONS

CERTIFICATE OF CONFORMANCE (CofC) – refers to the certifying document provided with the product for which a special process(es) has been performed. The certifying document must reference the specification which the special process was performed in accordance with.

FIRST ARTICLE INSPECTION (FAI) – refers to the forms and package of documentation for a part number or assembly, including FAI results, per this specification.

NATIONAL AEROSPACE & DEFENSE CONTRACTORS ACCREDITATION PROGRAM (NADCAP) – organization that certifies special processes to the industry standards for that specific process.

NONDISCLOSURE AGREEMENT (NDA) – refers to a legally-binding document signed by two parties where confidential information such as technical information is shared between the parties. This document affirms that the confidential information is not communicated or

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

distributed outside of the parties signing on behalf of their organization and the organizations associates.

PART QUALIFICATION PACKAGE – refers to the part FAI and/or PPAP depending on the requirement flowed down on the purchase order.

PRODUCTION PART APPROVAL PROCESS (PPAP) – refers to a set of documents that establish that a product meets technical, regulatory and customer requirements. Depending on the required PPAP level, the document package may include but is not limited to: Process Failure Mode Effects Analysis (PFMEA), process flow, control plan, and FAI/dimensional layout.

SPECIAL PROCESSES – Defined by NADCAP as processes which include procedures that alter or change the mechanical, chemical, or physical parts of products within the operation or process and require rigorous, standard-specific practices as well as qualified personnel or employees. These processes cannot be verified later without destruction test.

SUBTIER – A supplier to the first tier awarded the Unison contract.

## 7.0 REFERENCES

AS/EN/JISQ 9100/9110	Quality Management Systems- Requirements for Aviation, Space and Defense Organizations
S-SPEC-4 (S-1005)	GE Aerospace Systems Supplier Quality System Requirements
S-SPEC-5 (S-1007)	GE Aerospace Systems Supplier Requirements for the Part Qualification and Approval Process

## 8.0 REVISION HISTORY

Revision Date	Description of the Change	Author
05/24/2023	Amended Section 4.0 paragraph 1.  Amended Appendix B to clarify that any NADCAP certified supplier may be used and that their scope is not expected to include the Unison proprietary process as part of their NADCAP scope.	Keri Calero
04/15/2023	Dropped letter revision; rewritten for incorporation of customer work transfer requirements. Amended Appendix A to align with NADCAP categories and process under each category. Added in the Approver Processors List as Appendix B.	Keri Calero
12/22/2017	Supersedes Rev H; Statement specifying GE-AJA quality system requirements supersede UIQD 4.6.2.2 document for Unison U1 business (Jacksonville, Norwich, and Saltillo)	Jamesia McKay
07/20/2009	Supersedes Rev G. General rewrite and formatting changes. Removed allowance of unapproved Unison and/or customer suppliers or subtiers as special processors.	Quality
01/15/1999	Supersedes Rev F	Quality

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

## APPENDIX A. SPECIAL PROCESSES

CATEGORY	EXAMPLE PROCESSES IN CATEGORY <i>(Includes but limited to these processes)</i>
Chemical Processing (CP)	Anodizing, Chemical Cleaning, Chemical Milling, Conversion/Phosphate Coating, Etching, Laboratory Evaluation, Paint/Dry Film Coatings, Plating, Stripping, Surface Prep Prior to Metal Bond, Surface Treatment/Passivation, and Vacuum Cadmium & Aluminum IVD.
Coatings (CT)	Thermal/Flame Spray, Vapor Deposition, Electro-Deposition, Vacuum-Deposition, Mechanical Deposition, Diffusion Coating Process, Curable Coatings, Impregnated Coatings, Stripping of Coated Parts, Coatings Evaluation, Plating of Coated Parts, Heat Treating of Coated Parts, and Grinding of Coatings.
Composites (COMP)	Compression Molding, Core Processing, Kitting Service Provider, Liquid Resin Processing, Metal Bond, and Prepreg/Adhesive Bonding/Resin Film Infusion.
Heat Treating (HT)	Metal Systems, Heat Treating Process, Heat Treating Equipment, Stress Relief, Aging, Solution Treatment, Embrittlement Relief, Brazing, and Hot Forming.
Materials Testing Laboratory (MTL)	ISO/IEC 17025 Equivalency (AC7006), Chemical Analysis, Mechanical Testing, Metallography (Micro & Macro), Hardness, Corrosion, Microhardness, Fastener Testing and Specimen Heat Treating, and Test Specimen Preparation.
Nonconventional Machining (NM)	Electrochemical Machining (ECM), Electrochemical Grinding (ECG), Electrical Discharge Machining EDM), Laser Beam Machining (LBM) Laser Part Marking (LPM), Spark Erosion Grinding (SEG), Abrasive Water Jet Machining (AWJM), Chemical Milling
Non-Destructive Testing (NDT)	Eddy Current, Magnetic Particle, Liquid Penetrant/Fluorescent Penetrant Inspection, Ultrasonic, Radiography/X-Ray, Digital Radiography (DDA & CR), and Remote Image & Film Viewing.
Surface Enhancement (SE)	Computer Controlled Peening, Automated Peening, Peen Forming, Flapper Peening, and Manual Peening.
Welding (WLD)	Additive Manufacturing (Laser and electron beam powder bed metallic), Diffusion Welding, Electron Beam Welding, Flash Welding, Friction/Inertia Welding, Fusion Welding (includes GTAW, PAW and Foundry in-process/casting repair), Laser Welding, Percussion Stud Welding, Resistance Welding (spot, seam and projection), Torch/Induction Brazing, Welder/ Welding Operator Qualification, and Evaluation of Welds (bend test and metallographic)

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
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) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	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) Veterans Metal/DHS (Clearwater) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP, NDT CP CP WLD CP, NDT CP CP
24585	Electro-polishing of Stainless-Steel parts	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
24740	NI Plating	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
24745	Solder Coating of AL, Steel, and CU bearing alloy parts	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
55102	AL Dip Brazing	Dip Braze Inc. (Sun Valley, CA) Parfuse Corp. (Westbury) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT HT HT
55182	Chromate coating of AL	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
55321	Electroless NI Plating	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
55427	AG Plating of CU Base Alloys	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
55581	NI Plating	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
105572	NI Plating of STL and SST	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
105750	Electroless NI Plating of AL	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
125553	Hot Tin Dip	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
175223	Vacuum Furnace Heat Treat of TI Bifurcation Box per PWA 11-32	Metals Technology (formerly Metallurgical Processing – Carol Stream) <b>[Customer Approved Source]</b>	Not required by customer
9-1542	Acid Bright Dip, CU and AL Alloys	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
9-1677	Silver Brazing	Computech Mfg. Nitro-Vac Heat Treat (Warren) Parfuse Corp. (Westbury) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None None CP
9-2158	Cadmium Plating	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

## APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-2335	Gold 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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None None CP
9-2357	Copper Plating	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP
9-2360	Zinc Plating of Aluminum	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-2530	Finish, Zinc Plating	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA) BGM Fastener Company (Honesdale, PA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP
9-2656	Silver Brazing (Grade RT)	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-2827	AMS 2400 w/ Black Finish	Alert Plating Company (Sun Valley, CA) BGM Fastener Company (Honesdale, PA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-2920	SN Plating & fusing of SN on AL	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
9-2929	Cadmium Plating	Alert Plating Company (Sun Valley, CA) BGM Fastener Company (Honesdale, PA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-3005	Res Spot Weld of Non-Hard Steel NI Alloys, Class B Welds	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3005-1	Res Spot Weld of Non-Hard Steel Alloys, Not Precipitation Hardened	Ferco Tech Corp. (Franklin) Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	NDT, WLD, NM None WLD
9-3025	Res Spot Weld of AL, MG and Alloys (Class B Welds)	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3025-1	Res Spot Weld of AL, MG and Alloys (Class C Welds)	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3026	Cadmium Plating and Chromate Treatment	Alert Plating Company (Sun Valley, CA) BGM Fastener Company (Honesdale, PA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-3047	Cadmium on AL, Olive Drab Treatment	Alert Plating Company (Sun Valley, CA) Amphenol Corp. (Sidney, NY) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP None CP

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

**APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)**

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-3139	Annealing Aluminum	Parfuse Corp. (Westbury) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT HT
9-3147	Copper Plating on Aluminum	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-3150	Anneal SS 430 tubes	Paulo Products Company (Kansas City, KS) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT HT
9-3232	Tackwelds	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3232-2	Weld of Non-Hard Steel, NI and Heat Resist Alloys	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3290	Aluminate #225 Treatment of AL	B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP None CP
9-3388	Pre-tinning and soldering with 95% tin/5% antimony solder and acid flux	Veterans Metal/DHS (Clearwater) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None None CP
9-3487	Sulfuric Acid Anodize	B-D Industries (Elkhart, IN) C.H. Thompson (Binghamton, NY) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-3500	Res Spot Weld of AL &, MG, and their Alloys Tack Welds	Prompton Tool (Honesdale, PA) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	None WLD
9-3564	NI Alloy Direct Aging Rockwell 15N76 Minimum	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-3619	Bright Dipping Aluminum	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
9-3635	Fine Silver Brazing of Metallized Ceramics	MPF Products (Gray Court) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	None HT



Unison Industries Quality Directive	
Document Number: QD 4.6.2.4	Revision: 05/24/2023
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

## APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-365	Process HT-TR RH-C30/35 STLAMS 6320 AMS 6330	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-3742	Copper Brazing	Deringer Nye MPF Products (Gray Court) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	None None HT
9-3791	Copper Plating Metallized Ceramics	Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP None CP
9-4027	Steel, Stainless, CR AISI Type 410 or 416 Annealing	Nitro-Vac Heat Treat (Warren) Paulo Products Company (Kansas City, KS) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT HT HT
9-4029	Nickel Plating Metallized Ceramics	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	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 McDonough, NY) <a href="#">Any Welding (WLD) NADCAP approved special processors</a>	WLD WLD NDT, WLD, NM None None None None WLD
9-4259	Black Oxide Treatment for Stainless Steel (Conversion Coating)	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-4332	Cadmium Plating with a Nickel Base	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-4747	Aluminum Flux Dip Brazing & Heat Treat	Dip Braze Inc. (Sun Valley, CA) Parfuse Corp. (Westbury) <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT HT HT
9-4804	Silver and Gold Plating per 9-1882 and 9-2335	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-4853	17-7PH Stainless Steel Heat Treat to RH 950 condition	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-492	Heat Treatment of Beryllium CU Alloy	Nitro-Vac Heat Treat (Warren) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT CP HT
9-4960	Olive Drab Cadmium Plating with NI Base Plate	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-4966	Bright Tin-Lead Solder Plate AL and AL Alloys	ADTEC II (Tampa, FL) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-5015	Bright Tin-Lead Solder Plate Ferrous and Non-Ferrous Alloys	ADTEC II (Tampa, FL) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP



Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

**APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)**

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-515	Black Oxide, Steel	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-5500	Tin-Lead Coating, Hot Dipped 60 to *0% Tin	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	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) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP
9-5934	Silver Brazing of Tungsten Carbide to Steel	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-5955	Bright Tin Plate AL and AL Alloys	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP
9-5966	Bright SN on Ferrous & CU Alloys Similar to MIL-T-10727	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None CP
9-6002	CR Plating Aluminum	Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-6191	HT Inconel X750, AMS 5582 or AMS 5667	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-6594	Electroless NI Plating and AL Alloys	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-6612-2	Teflon-S Finish (Black)	<a href="#">Any Chemical Processing (CP) or Coating (CT) NADCAP approved special processors</a>	CP or CT
9-6697	Bright SN on ferrous & CU Alloys (Similar to MIL-T-10727, type I)	ADTEC II (Tampa, FL) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP None CP
9-6744	NI Alloy Brazing, Low temperature	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-6768	AG Brazing (50AL/16CD/15.5ZN/15.5CU/3NI) Easy Flo 3	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-6800-G	Gold Plating Elec. Contacts	<a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP
9-6880	Bright Tin Plating Stainless Steel	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None CP

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

**APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)**

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
9-689	Process HT-TR RH-C35/40STL SAE 4130 SAE 8630	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-6914	ECD NI Alloy Plating, TYPE ENC Aluminum and Alloys	Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP
9-6972	NI Alloy Plating Al & AL Alloys	Alert Plating Company (Sun Valley, CA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP
9-7510	Silver Brazing	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-7519	Bright Tin Plating Stainless Steel	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None CP
9-7599	Bright SN Plate CU & CU Alloys with a NI Base Plating	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None CP
9-8003	Heat Treating	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-807	Tin Plating (Similar to MIL-T-10727, Type I)	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) Tri-Star Electronics (El Segundo, CA) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None CP
9-809	Process HT-TR SST AISI 416 Rockwell-C18/24	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	HT
9-885	NI Plating (Similar to QQ-N-290)	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) ** <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP None None CP
9-997	Passivation of Stainless Steel (Similar to QQ-P-35)	Alert Plating Company (Sun Valley, CA) B-D Industries (Elkhart, IN) BGM Fastener Company (Honesdale, PA) C.H. Thompson (Binghamton, NY) Computech MFG <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP None CP
CI10016	Anodic Coating on AL from Chromic Acid with DIC Seal	<a href="#">Any Heat Treat (HT) NADCAP approved special processors</a>	CP
CI10035	Gold Plating on CU Alloys	ADTEC II (Tampa, FL) Alert Plating Company (Sun Valley, CA) Alexandria Metal Finisher (Alexandria, VA) <a href="#">Any Chemical Processing (CP) NADCAP approved special processors</a>	CP CP CP CP

Unison Industries Quality Directive	
Document Number: <b>QD 4.6.2.4</b>	Revision: <b>05/24/2023</b>
SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

**APPENDIX B. APPROVED SPECIAL PROCESSORS LIST FOR UNISON PROPRIETARY SPECIFICATIONS (cont'd.)**

Unison Specification	Type of Process	Approved Processor	NADCAP Certified Category
CI10061	Heat Treatment of Rene 41	Any Heat Treat (HT) NADCAP approved special processors	HT
CI10113	Aluminum Backshells	Any Chemical Processing (CP) NADCAP approved special processors	CP
CI1032	AL Dip Brazing	Parfuse Corp. (Westbury)	HT
		Any Heat Treat (HT) NADCAP approved special processors	HT
CI1033	CU Plating	Any Chemical Processing (CP) 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
		Any Chemical Processing (CP) NADCAP approved special processors	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
		Any Chemical Processing (CP) NADCAP approved special processors	CP
JS0378	Plating, Bright Tin of Ferrous Alloys	Alexandria Metal Finisher (Alexandria, VA)	CP
		Any Chemical Processing (CP) NADCAP approved special processors	CP
JS0379	Coating, Electroless NI of Ferrous Alloys	ADTEC II (Tampa, FL)	CP
		Alert Plating Company (Sun Valley, CA)	CP
		Any Chemical Processing (CP) NADCAP approved special processors	CP
JS1676	EDM Machining (generic process specification)	Any Nonconventional Machining (NM) NADCAP approved special processors	NM

Unison Industries Quality Directive	
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SUPPLIER SPECIAL PROCESSES AND SPECIAL PROCESS CONTROL	

#### APPENDIX C. APPROVED PROCESSORS LIST FOR NON-NADCAP PROCESSES

Unison Specification	Type of Process	Approved Processor
24619	Polytetrafluoroethylene one coat enamel ( <i>Not a NADCAP special Process</i> )	Donwell Co. Inc. (Manchester)
9-2869	Pre-Tin & Solder with 50/50 solder & rosin base flux	Prompton Tool (Honesdale)
9-2902	Pre-Tin & Solder with 10SN, 2SB .5 AG Bal PB with rosin flux	Prompton Tool (Honesdale)
9-3033	Brush Treatment of Iridite #14 (AL-coat) on localized surface ( <i>Not a NADCAP special Process</i> )	Alexandria Metal Finisher (Alexandria) B-D Industries (Elkhart) Tri-Star Electronics (El Segundo)
9-3155	Solder, Solid and Rosin Cored .5 ( <i>Not a NADCAP special Process</i> )	Professional Tech Metal (Maryville) Prompton Tool (Honesdale, PA)
9-3264	Protective Treatment for Silver Plate ( <i>Not a NADCAP special Process</i> )	Booth Electrosystems Inc (Greenville) Deutsch Hermetic Connector (Hemet & Oceanside) Ideal Plating and Polishing (Belleville)
9-3608	Application of Teflon Coat to Steel, Ceramic & AL Parts ( <i>Not a NADCAP special Process</i> )	Cerco (Shreve) Denmac Industries (Paramount) Donwell Co. Inc. (Manchester, CT) General Plastics Co. (Highland City) Imagineering Enterprises (South Bend) Microfin Corporation (Providence) Precision Coating Co. (Dedham) Synergy Metal Finishing (Titusville, FL)
9-5895-2	MFG of Ceramic Semiconductors by Semiconductive Paint Penetr.	ADTEC II (Tampa, FL) Cerco (Shreve) Superior Tech. Ceramics (St. Albans)
9-6569	Application of Primer and FEP Enamel to AL ( <i>Not a NADCAP special Process</i> )	Imagineering Enterprises (South Bend) Microfin Corporation (Providence) Precision Coating Co. (Dedham)
9-8074	Painting - Teflon-S. Green	Imagineering Enterprises (South Bend) Microfin Corporation (Providence) Precision Coating Co. (Dedham)
JS0491	Oxidation of Silicon Iron Laminations ( <i>Not a NADCAP special Process</i> )	HTG, Nettleton Steel
JS1487	Bi-Metal Transition Material ( <i>Not a NADCAP special Process</i> )	High Energy Metals