

| Unison Industries Quality Directive | | |
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| 7575 Baymeadows Way Jacksonville, FL 32256 | Norwich/Oxford Road Norwich, NY 13815 | Parque Industrial La Angostura Saltillo, Coahuila, Mexico 25086 |
| Document Number: QD 4.6.2.7 Revision: 7/17/2023 | | 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 PRE-PENETRANT ETCHING PROCESS CONTROL AND APPROVAL

PURPOSE: This procedure defines the supplier and supplier sub-tier requirements for pre-penetrant etching. This procedure is applicable to the Unison Norwich, NY site.

1.0 GENERAL

- 1.1 In addition to the requirements specified within, the requirements of Unison QD 4.6.2.4 shall also apply.
 - a. Unison defines pre-penetrant etching as a special process under the category of Chemical Processing (CP).
- 1.2 Any supplier or supplier sub-tier performing pre-penetrant etching on Unison hardware shall be NADCAP certified to AC7108/2 unless otherwise approved by the Unison Norwich NDT Responsible Level 3.

2.0 SPECIAL PROCESS PROCEDURE AND DOCUMENTATION

- 2.1 Pre-penetrant etching shall be performed prior to Liquid Penetrant Inspection in the scenarios as defined by ASTM E1417, or at the discretion of the Unison NDT Responsible Level 3.
- 2.2 The process, procedure, or technical work instruction that will be used to complete the pre-penetrant etching process shall be reviewed and approved by the Unison Norwich NDT Responsible Level 3 prior to use.
 - a. Any change in revision to the approved procedure shall require reapproval and shall not be implemented until there is documented Unison acceptance.
- 2.3 A CofC shall be provided for each lot processed certifying completion to the Unison approved procedure and revision that the pre-penetrant etching was performed in accordance with.

3.0 REFERENCES

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| UNISON QD 4.6.2.4 | Supplier Special Processes and Special Process Control |
| ASTM E1417 | Standard Practice for Liquid Penetrant Testing |
| NADCAP AC7108/2 | Audit Criteria for Chemical Processing and Nondestructive Testing for Pre-Penetrant Etching and Etch Inspection Processes |

4.0 REVISION HISTORY

| Revision Date | Description of the Change | Author |
|---------------|---------------------------|---------------------|
| 7/17/2023 | New Issue | Anthony Gascon, RL3 |
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