



UTC Aerospace Systems

Hamilton Sundstrand
Windsor Locks, CT 06096

SUPPLIER CIRCULAR



“Supplier Gold” is the one, single United Technologies Corporation award bestowed upon a supplier to recognize performance excellence.

Items of Interest 157

Date: February 17, 2016

NOTE: This Supplier Circular has been generated for all suppliers that provide product or services to UTC Aerospace Systems. (UTAS)

ASQR-01, Form 3: Supplier Request for Information (SRI) System

This Supplier Circular has been written due to a recent quality escape which was the result of an improper SRI response. The supplier submitted an SRI requesting to chemically etch a series of parts prior to electrolytic marking, as this would improve legibility. The SRI response stated that the submitted package/process was acceptable to use but did not mention a permanent correction to the field of the drawing or an internal deviation would be written. During an FAI review it was determined that this was a violation of HSC0001 paragraph A3.2.1.1.

A3.2.1.1 Engineering Controlled Processes: The following table lists restricted processes that shall not be used unless specifically authorized on the drawing.

Brazing
Chem Milling
Coatings (Organic and Inorganic)
Dry Film Lubrication
Electro-Chemical Machining (ECM)
Electro-Discharge Machining (EDM)
Electrolytic Cleaning 1
Electropolish
Etching 2
Heat Treat 3
Hot Isostatic Pressing
Impregnation
Passivation
Peening 4
Plating (Electrolytic and Electroless)
Soldering
Straightening after Heat Treating

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Surface Cold Work 5
Thermal Cutting 6
Thermal or Chemical Deburring
Thermal Processing after Heat Treat
Utilization of Low Melting Alloys⁷
Welding

Table A3.2.1.1
Engineering Controlled Processes

Notes for Table A3.2.1.1

1. Not permitted on any ferrous metal parts where the hardness is $\geq 40\text{HRC}$.
2. Excluding etching used by forging shops or foundries to clean-up a raw forging or raw casting. Also excludes etching performed for cleaning purposes prior to plating or welding.
3. Excluding thermal processes performed in-process for relief of machining or forming stresses or for enhancement of machining characteristics (such as stress relieving, annealing or normalizing) provided that such processes precede heat treatments specified on the drawing for establishment of finished part Engineering properties.
4. Peening includes shot, glass, laser, etc.
5. Surface cold work includes cold rolling, coining, burnishing, etc.
6. Examples of thermal cutting are: Electron Beam, Friction, Laser, Plasma.
7. Material used primarily in bending and forming operations such as Cerrobend, Bandalloy, Bismuth, etc.

Note that other UTAS drawing interpretation specifications have similar requirements within them.

It is important to note that SRIs are not used for accepting product non-conformances or altering contractual requirements.

For more information, contact Alain.Deltenre@utas.utc.com

UTC Aerospace Systems / Hamilton Sundstrand Supplier Circulars cover items of interest, interpretation of drawings and specifications as well as clarifications of Hamilton Sundstrand procedures. In addition, they bring attention to examples of problems encountered by other suppliers and present their solutions for possible application in your organization. After review and appropriate action, file this circular for the future reference.

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