



## HMS Capability and Approval Status of Special Processes

Qualified	Document No: KS/LS/KLT/018
ATP / Provisional / Conditional	Prepared by: Egemen Taşkan
Approval activities in progress	Approved by: N. Efe Varol
Non-special Processes	Edition Date: 30.06.2017
	Revision Date: 11.06.2018
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Process Type	Process Name	Airbus	Bombardier	GKN / Diehl Aircabin	Industry Specifications	Limitations / Remarks
NDT	Penetrant Inspection	AITM 6-1001	BAPS 176-002	GKN: WAPS 25-02	ASTM E1417	Limitation Airbus : Legacy stainless steel and titanium parts related to chemical preparation per 80-T. No limitations on aluminum parts.
Chemical Process	Tartaric Sulphuric Anodising of Aluminium Alloys (TSA)	AIPS 02-01-003	BAPS 160-045	Diehl Aircabin: AIPS 02-01-003	MIL-A-8625	Limitation Bombardier: Limited to primer Seevnx 313/81
Chemical Process	Sulphuric Acid Anodising of Aluminium Alloys (SAA)	AIPS 02-01-002	-	Diehl Aircabin: AIPS 02-01-002	MIL-A-8625	
Chemical Process	DC Sulphuric Acid Anodizing (SAA)	80-T-35-2000	-	-	-	-
Chemical Process	Sealing of Anodized Layers	80-T-35-2001	-	-	-	-
Chemical Process	Chromic Acid Anodizing of Aluminium Alloys (CAA)	-	BAPS 160-010	GKN: WAPS 41-05	MIL-A-8625	Limitation Bombardier: Limited to the Manual Line
Chemical Process	Chemical Conversion Coating (CCC) (Chromating of Aluminum and Aluminum Alloy)	AIPS 02-05-001 / 80-T-35-1101	BAPS 160-020 / BAPS 160-040	GKN: WAPS 41-01	MIL-C-5541 MIL-DTL-5541	Limitation Bombardier 160-020: Type 1 Manual & Auto-Line & Type 2 - 1132 Prep Pen Limitation Bombardier 160-040: Type 1 Manual & Auto-Line & Type 2 - 1132 Prep Pen
Chemical Process	Passivation of Corrosion Resistant Steel	AIPS 02-05-005	BAPS 180-015	GKN: WAPS 41-04 Diehl Aircabin: AIPS 02-05-005	QQ-P-35 AMS 2700	Industry Spec: Type 2 and type 6
Chemical Process	Passivation of Corrosion-resistant Austenitic Steel	80-T-35-1200	BAPS 180-015	-	-	Limitation Airbus : ATP until 23-08-2017.
Chemical Process	Passivation of Martensitic, Ferritic Corrosion-Resistant Steel	80-T-35-1201	BAPS 180-015	-	-	-
Chemical Process	Zinc Plating	-	-	GKN: AMS 2402	ASTM B 633 AMS 2402	Industry Spec: Type 1 and Type 3
Chemical Process	Electrolytic Zinc-Nickel Plating	AIPS 02-04-006	-	-	-	-
Chemical Process	Cadmium Plating of Steel	80-T-35-3000	-	GKN: WAPS 28-03	AMS-QQ-P-416	-
Chemical Process	Cadmium Plating of Copper Alloys	80-T-35-3003	-	-	-	-
Chemical Process	Chromium Passivation of Cadmium-Plated Surfaces	80-T-35-1107	-	-	-	-
Chemical Process	Chemical Nickel-Plating of Steel	80-T-35-4300	-	-	-	-
Chemical Process	Electrical Bonding (Surface Preparation)	AIPS 07-01-006	BAPS 160-040	-	-	AIPS 07-01-006 is approved, limited to SP1 and SP7 surface preparation processes only.
Chemical Process	Aluminum Coating on Fasteners			GKN: NAS 4006	NAS 4006	
Chemical Process	Application of Structural Paints	AIPS 05-02-009 / 80-T-35-9120	see below paint processes	GKN: WAPS 26-01, 26-05, 26-08 Diehl Aircabin: AIPS 05-02-009	BH A 001	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Rework of paints on metallic and non-metallic structural parts	AIPS 05-02-011 / 80-T-35-9124	-	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Accelerated Curing of Organic Coatings	-	BAPS 138-055			Limitation Bombardier: Limited to Convention oven only
Chemical Process	Coating with Two Component Primer, EP-based	80-T-35-5002	BAPS 138-043 / PPS 34.08	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Coating with TwoThree-component Water-based Primer	80-T-35-5030	BAPS 138-043	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Coating with PUR-based Top Coat	80-T-35-5106	BAPS 138-044 / PPS 34.03	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Coating with TwoThree-component Water-based Top Coat	80-T-35-5130	BAPS 138-044	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Coating with Anti-Slip Paint	80-T-35-5212	-	-	-	Limitation Airbus : Manual paint application on metallic parts.
Chemical Process	Coating with PUR-based Varnish, Abrasion-resistant (two-component polyurethane-based varnishes (PUR))	80-T-35-5254	-	-	-	-
Chemical Process	Dry Film Lubricant Coating	-	PPS 32-09	-	-	-
Chemical Process	Alkaline Pickling of Aluminum and Aluminum Alloys	-	BAPS 180-030	-	-	-
Chemical Process	Acidic Pickling of Aluminum and Aluminum Alloys	-	BAPS 180-032	-	-	-

Chemical Process	Pickling of Stainless Austenitic Steel	80-T-35-0104	-	-	-	-
Chemical Process	Pickling of Stainless Martensitic Steels	80-T-35-0194	-	-	-	-
Chemical Process	Acidic Pickling of Titanium and Titanium Alloys	80-T-35-0106	BAPS 180-031	-	-	Limitation Bombardier: Manual Line only
Chemical Process	Cleaning and Deoxidizing Copper and Copper Alloys	-	BAPS 180-011	-	-	-
Chemical Process	Alkaline Cleaning	AIPS 09-01-003 80-T-35-0020	BAPS 180-001	WAPS 09-02	-	-
Chemical Process	Cleaning with Organic Solvents (Cold Cleaning Agents)	80-T-35-0014	-	WAPS 09-02	-	-
Chemical Process	Electrolytic Degreasing	80-T-35-0030	-	-	-	-
Chemical Process	Rinsing	80-T-35-0090	-	-	-	-
Chemical Process	Water Quality	80-T-35-0095	-	-	-	-
Chemical Process	Dehydrogenation	80-T-36-3300	-	-	-	-
Chemical Process	Abrasive Blasting	80-T-35-0200	-	-	-	-
Chemical Process	Black Oxide	-	-	-	UN D 452	-
Chemical Process	Electrolytic Polishing	-	BAPS 160-036	-	-	-
Surface Enhancement	Shot Peening	80-T-35-0205 I+D-P 006	-	-	-	80-T-35-0205 audit has been completed successfully. Approval is awaited.
Mechanical Process	Machining of Metallic Components	AIPS 03-11-001 80-T-30-4010	BAPS 188-001 PPS 01.21	-	-	-
Mechanical Process	Finishing of Metal Components (Deburring, Cleaning)	AIPS 03-11-001 80-T-30-6918	BAPS 188-001	-	-	-
Mechanical Process	Preparation of Holes in Metallic Materials for Fastening	AIPS 01-02-003 / 80-T-30-9910	-	-	-	Limitation Airbus : Drilling, reaming and countersinking only with CNC machines.
Mechanical Process	Treatment of Damage on Components Made of Aluminium Alloys	80-T-39-0230	-	-	-	-
Mechanical Process	Protection of Metallic and Non-metallic Items	-	-	GKN: WAPS 31-01	-	-
Marking/Varnish	Marking with Indelible Ink	AIPS 08-03-002 80-T-39-0132	BAPS 144-005 PPS 15.01	GKN: WAPS 21-01	-	-
Marking/Varnish	Application on External Paint Systems (varnish on marking)	AIPS 05-02-003	-	-	-	Limitation Airbus: limitation to ClearCoat UVR – AIMS04-04-23 - application on ink marking only
Assembly Process	Pressure and Environmental Sealing (wet assembly)	-	BAPS 157-028	GKN: WAPS 36-01	-	Limitation Bombardier : Limited to wet installation of fasteners, faying surface sealing & fillet seals IWO bearing/bushes
Assembly Process	Installation of Interference Fit Bushings	-	BAPS 175-005	GKN: WAPS 24-01	-	-
Assembly Process	Installation of Conventional Rivets	-	BAPS 151-001	Diehl Aircabin: FA 15-015	-	Limitation Bombardier : Limited to manual only
Assembly Process	Installation and Retention of Self-Aligning Groove Bearings by Roller or Anvil Swaging	-	BAPS 175-004	-	-	Limitation Bombardier: Limited to Roller Swaging Tool Numbers – ST001/MS14103A- 6CE, ST002/MS14103A-8CE, ST003/MS14103A-10CE & ST004/MS14103A-12CE
Assembly Process	Adhesive Bonding of Non-structurale Components	-	-	Diehl Aircabin: FA 10-006	-	-
Assembly Process	Processing of Adhesive Tapes	-	-	Diehl Aircabin: FA 11-001	-	-
Assembly Process	Electrical Bonding (assembly)	-	BAPS 145-002	-	-	-
Test Method	Determination of Electrical Conductivity of Aluminium Alloys by Eddy Current Method	AITM6-6004	BAPS 168-013, PPS 20-07	GKN: WAPS 25-04	-	-
Test Method	Other Laboratory processes and test methods	Approved. See latest test method attestation letter for details.	Laboratory is approved for BAERD GEN 018	Laboratory is approved together with processes.	-	Limitation Bombardier: Limited to Fields 1a, 1b, 5a & 5e

## REVISION HISTORY

Rev. No	DESCRIPTION	DATE
00	First issue	30.06.2017
01	Approval of BAPS 160-020, BAPS 160-040, PPS 32-09, BAPS 175-004 has been added.	24.08.2017
02	Approval of BAPS 160-010 has been added. SC19 processes to be approved have been updated.	15.09.2017
03	BAPS 145-002 has been approved. All GKN provisional approvals have benen fully qualified. WAPS 26-01, 26-05, 28-03 added.	11.06.2018