

**Standard:** PS 500

**Title:** Master, Subject & Correlation Index

**Approvals:**

Issue	Compiled	Date	Approved	EO
46	S Ford	Jan 2010	S Ford	-
47	S Ford	Jul 2010	S Ford	-
48	S Ford	Feb 2011	S Ford	-
49	S Ford	Apr 2011	S Ford	-
50	S Ford	Feb 2012	<i>S Ford</i>	EWA000238

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## 1.0 EQUIVALENCY STATEMENT

- 1.1 The correlation index starting on page 14 of this specification shall be used to determine the appropriate substitute Moog Wolverhampton (MWL) specification when a Rotol / Dowty Aerospace Gloucester (DAG) specification is called up on a drawing. For the purposes of this substitution the acceptable alternative is given in Column A and the Rotol / DAG specification is given in column B.
- 1.2 Example 1, for a part with a drawing note calling for "Vapour Degrease to DAG PS 203" it is acceptable for this part to be processed to PS 78.
- 1.3 Example 2, for a part with a drawing note calling for "Nitride to DAG PS 302" it is acceptable for this part to be processed to MSPS200.HT.003.
- 1.4 The following restrictions apply:-
- The substitution ONLY applies in the stated direction, i.e. for the example given above, processing to DAG PS 302 is not an acceptable substitute when a drawing note calls for "Nitride to PS 27"
  - This substitution ONLY applies to drawings which were Dowty Aerospace Gloucester design, but had the design authority transferred to Smiths Wolverhampton (now Moog Wolverhampton), i.e. part numbers belonging to the following contracts and having the associated series of part numbers given:-
- |                      |                 |              |                 |
|----------------------|-----------------|--------------|-----------------|
| A330/340 high lift   | p/n 697 xxx xxx | F50 flap     | p/n 678 xxx xxx |
| BAE 146 high lift    | p/n 676 xxx xxx | F50 door     | p/n 668 xxx xxx |
| CASA CN235 high lift | p/n 677 xxx xxx | SAAB gearbox | p/n 677 014 xxx |
| EFA gearbox          | p/n DBEF xxxx   |              |                 |
- 1.5 This substitution applies to parts manufactured in house and by approved suppliers to MWL and only effects the above series of part numbers.
- Note:** Suppliers will normally ONLY be issued copies of specifications controlled by MWL.
- Note:** DAG process specifications WILL NOT normally be issued to suppliers.
- 1.6 All DAG specifications that have no substitute under the MWL series of specifications, as given by the correlation index, shall be referred to Moog Wolverhampton Materials Engineering.

## 2.0 NOTE TO SUPPLIERS

- 2.1 Approved suppliers to Moog Wolverhampton shall request copies of procedures as required for parts manufacture or dissemination to sub tier suppliers via Moog Wolverhampton Purchasing Department.

## 3.0 PROCESS SPECIFICATION (PS) MASTER INDEX

- 3.1 In the section, specifications marked with an asterisk (\*) are considered "NOT ACTIVE" and as such will not be audited or reissued.
- 3.2 All specifications that were the responsibility of Precision Handling (now Parkburn) or Fabrications Department are now cancelled

PS	Issue	Date	Title
500	50	Jan-12	Master, Subject & Correlation Index
1	11	Nov-10	Dry Lubricant, Anti-Friction Coatings
2	-	-	CANCELLED (in house use PCD 2, supplier base use MSPS100.CP.007)
3	-	-	CANCELLED
4	-	-	CANCELLED (in house use PCD 4, supplier base use MSPS100.CP.002)
5	3	3/91	Cleaning of Hydraulic Pipes
6	7	May-10	Surface Sealing of Magnesium Castings
7	-	-	CANCELLED
8	12	Mar-11	Cleaning and Surface Preparation of Metallic Materials
9	-	-	CANCELLED (use PS 174)
10	5	Mar-11	Dalic Electroplating Process
11	6	1/97	Salt Bath Nitrocarburising - SURSULF and TUFFTRIDING
12	-	-	CANCELLED (in house use PCD 12, supplier base use MSPS100.CP.003)
13	-	-	CANCELLED (use PS 69)
14	-	-	CANCELLED (in house use PCD 14, supplier base use MSPS100.CP.004)
15	-	-	CANCELLED (use PS 14)
16 *	5	Nov-05	Hard Chromium Plating of Aluminium Alloys
17	-	-	CANCELLED (in house use PCD 17, supplier base use MSPS100.CP.009)
18	7	Mar-10	Chromate Treatment of Magnesium Alloys
19	13	Jun-11	Contamination Levels for Hydraulic Fluids
20	-	-	CANCELLED
21	2	3/91	Tin Plating
22	1	5/75	Treatment for Solenoid Coil Assemblies
23	1	5/75	Fitting Shrink-on Plastic Sleeving and Boots
24	6	11/78	Packing of Hydraulic Assemblies for Storage
25	2	5/78	Packing of Electrical Components and Assemblies
26	5	3/99	Paint Removers
27	-	-	CANCELLED (in house use PCD 27, supplier base use MSPS200.HT.003)
28	9	Nov-05	Araldite Epoxy Resin Adhesives
29	-	-	CANCELLED (in house use PCD 29, supplier base use MSPS300.NDT.001)
30	-	-	CANCELLED (use PS 1)
31	2	10/74	Impregnation of Coil Windings
32	8	7/96	Induction Brazing (see also PS 119)
33	11	Aug-10	LOCTITE Sealants and Adhesives
34	-	-	CANCELLED (in house use PCD 34, supplier base use MSPS100.CP.008)
35	-	-	CANCELLED
36	-	-	CANCELLED (in house use PCD 36, supplier base use MSPS100.CP.006)
37*	2	11/74	Nickel Plating
38	3	Jan-07	Silver Plating
39	-	-	CANCELLED (supplier base use MSPS400.MISC.001)
40	3	8/76	Adhesive Fixing of Labels (SILASTIC 738 RTV)
41	5	2/94	Plugging of Hydraulic Components with Lee Plugs (Existing Civil Contracts ONLY), (see also PS 57)
42	6	4/96	Silver Brazing
43 *	2	5/75	Reclamation of Steel Components by Heavy Nickel Plating
44	3	12/99	Secondary Staking of Lee Plugs
45	8	May-11	Temporary Protection Against Corrosion
46	1	11/72	Removal of Copper Plugs from Rotary Valve Sleeves
47	-	-	CANCELLED
48	-	-	CANCELLED
49	4	Aug-06	Low Hydrogen Embrittlement (LHE) Cadmium Plating of Ultra-high Strength Steel (UTS <2140MPa or 310ksi)

PS	Issue	Date	Title
50 *	1	7/74	Chemical cleanliness of steels (sulphur prints)
51	1	3/72	Pre-Treatment and Surface Coating of PTFE Insulated Cables prior to Potting
52	-	-	CANCELLED (in house use PCD 52, supplier base use MSPS100.CP.005)
53	-	-	CANCELLED (use PS 118)
54	2	5/77	Plugging of Hydraulic Components (other than Lee Plugs)
55 *	1	5/71	Bolt etching process (forged heads)
56	1	8/71	Manipulation of Cold set preformed Rigid Pipes
57	9	Nov-11	Plugging of Hydraulic Components with Lee Plugs (see also PS 41)
58	1	3/72	Reclamation of Cast Iron Components by Powder Welding
59	-	-	CANCELLED (use PS 174)
60	1	12/73	Undercutting of screw threads
61	-	-	CANCELLED
62	-	-	CANCELLED (use PS 11)
63 *	3	8/82	Photographic examination of hard chrome plated cylinder bores
64	-	-	CANCELLED (use Design Standard 53)
65	-	-	CANCELLED (use PS 179)
66	4	3/99	Crimped Cable Connections
67	1	4/74	Removal of excess Copper braze from Bushes
68	-	-	CANCELLED
69	-	-	CANCELLED (in house use PCD 69, supplier base use MSPS100.CP.001)
70	-	-	CANCELLED
71	-	-	CANCELLED (in house use PCD 71, supplier base use MSPS400.MISC.002)
72	-	-	CANCELLED
73	-	-	CANCELLED (in house use PCD 73, supplier base use MSPS200.HT.002)
74	21	Jun-11	Magnetic Particle Inspection
75	-	-	CANCELLED (use PS 28)
76	1	12/74	Procedure for potting Concorde Linear Transducers
77	11	Nov-09	Jointing and Sealing Compounds
78	7	Jan-09	Trichloroethylene Vapour Degreasing
79	22	Jun-11	Fluorescent Penetrant Inspection
80	-	-	CANCELLED
81	-	-	CANCELLED
82	-	-	CANCELLED (use PS 174)
83	-	-	CANCELLED (use PS 1)
84	-	-	CANCELLED
85	-	-	CANCELLED
86	2	10/76	Brazing Technique for Transducer type P297 45 0060
87*	1	6/76	General requirements for spot welding sheet assemblies
88	3	7/76	Assembly of KEELARING Couplings
89	1	10/75	General Riveting Process
90	2	10/76	Cryogenic Jointing
91	-	-	CANCELLED
92*	4	3/84	Printed wiring board manufacture
93	-	-	CANCELLED
94	-	-	CANCELLED (supplier base use MSPS100.CP.001)
95	1	9/76	Glass Bead Peening
96	7	Jan-07	RILSAN Nylon Coatings
97	-	-	CANCELLED
98	1	9/78	Grinding of Titanium Alloys
99	-	-	CANCELLED

PS	Issue	Date	Title
100	1	3/77	Application of Extrude-Hone Process for Surface Finish Improvement
101	2	11/82	Application of two Package RTV 88 Silicone for Potting Purposes
102 *	1	10/78	NDT Ultrasonic Inspection of Aluminium Alloys
103	-	-	CANCELLED
104 *	1	7/77	Impregnation of Oilite Porous Bronze Bearings
105	-	-	CANCELLED (use PS 28)
106 *	1	10/77	Black oxide treatment of steels
107	-	-	CANCELLED (use PS 33)
108	-	-	CANCELLED (see PS 13 or PS 69)
109 *	1	6/78	Assembly and protection of printed wiring boards
110	2	5/85	Hydraulic Pipe Identification (<12mm)
111	14	Oct-10	Hardness Testing of Metallic Materials
112	-	-	CANCELLED
113	1	11/78	Dow Corning 3400A Bonded Lubricant
114 *	1	2/79	Hard Chromium Plating of Copper Alloys
115	-	-	CANCELLED
116 *	1	2/79	Cadmium Plating of Cuprous Alloys
117	-	-	CANCELLED
118	13	Mar-11	Heat Treatment of Alloy Steels
119	2	11/97	Induction Hardening (see also PS 32)
120	1	10/82	Crystal clear Silicon Potting Compound
121	2	May-08	Pickling of S145 Forgings
122	-	-	CANCELLED (use PS 28)
123 *	1	3/80	Sealing of pipe/coupling ends with Heat Shrinkable Sleeving
124 *	1	7/80	Use of Waylock S-17163 Adhesive
125	1	3/80	Swaging of Metric pipe Couplings
126	1	9/80	Tube/pipe Bending
127	1	7/80	Routing and Installation of non-lofted Hydraulic Pipes
128	-	-	CANCELLED
129	-	-	CANCELLED
130	-	-	CANCELLED
131	-	-	CANCELLED
132	1	11/81	Thread Rolling of Special Applications
133	1	9/82	Application of Dow Corning 3145 RTV Adhesive Sealant
134	-	-	CANCELLED (use PS 118)
135	1	11/82	Electron Beam Welding of 4340 ESR
136	2	6/90	Vacuum deposited Cadmium Plating on ultra high Strength Steels
137	-	-	CANCELLED
138	3	Feb-10	Special Machining Techniques for ultra high Strength Steels
139	4	Aug-10	Protective Treatment against Corrosion – MASTINOX
140	-	-	CANCELLED
141	-	-	CANCELLED
142	3	Oct-10	Ultrasonic Cleaning and suitable Cleaning Solutions
143	8	Nov-05	Abrasive Blasting of Metallic Materials
144	-	-	CANCELLED (use PS 74)
145	-	-	CANCELLED
146	-	-	CANCELLED
147	1	7/87	Laminated Servo Valve - Epoxy Bonding Procedure
148	-	-	CANCELLED
149	-	-	CANCELLED (supplier base use MSPS100.CP.001)

PS	Issue	Date	Title
150	-	-	CANCELLED (use PS 118)
151	4	Feb-11	Plasma (Ion) Nitriding
152	-	-	CANCELLED
153	-	-	CANCELLED
154	-	-	CANCELLED (use PS 73)
155	1	4/91	Hot Isostatic Pressing of Investment Castings
156	8	Jul-09	Part Marking
157	2	12/99	MJ Threads modified for critical Load Applications
158	2	12/99	U NJ Threads modified for critical load Applications
159	1	4/91	Helical Compression Springs for critical Load Applications
160	2	5/93	NITROTEC (Nitrocarburising) Surface Treatment
161	3	Oct-10	Use and Control of Cleaning Fluids
162	2	2/94	IVD Aluminium on Steel
163	-	-	CANCELLED
164	1	7/92	Electropolishing of Investment Castings
165	1	5/93	Nickel Sulphamate Plating
166	2	7/95	Requirements for Electron beam Welding of B777 Ball ramp Assembly
167	2	6/00	Grinding and Inspection of Chromium plated parts
168	2	1/02	Requirements for Hot Form Swaging
169	1	4/93	Laser Cutting of Metals
170	1	5/93	Assembly and installation of Magnetic seals
171	2	7/97	Aircraft Hydraulic/Mechanical Assemblies - Storage and Preservation Information
172	2	11/95	Assembly Procedure for Flareless fittings
173	3	Aug-10	Requirements for Electron beam Welding SAAB JAS 39 IDG and Breather Gears
174	14	Feb-12	Paint Schemes
175	3	3/00	Controlling Document for the manufacture of A330/340 Composite Transmission Shafts
176	-	-	CANCELLED
177	1	Aug-08	Staking of Spherical Bearings
178	-	-	CANCELLED – see PS 1 Appendix 6
179	9	Dec-09	Thermal Sprayed Tungsten Carbide Coatings
180	3	1/02	Nodular Thin Dense Chromium (NTDC) Plating
181	3	Jan-11	Welding of Hydraulic Pipe Assemblies
182	2	Nov-11	Fitting of seals without Lead groove Locations
183	1	9/95	Control of Shelf Life Limited Items
184	1	6/96	JAS 39 Gearbox Housing Casting Inspection Technique
185	1	7/96	Radiographic Acceptance Standards for Castings
186	1	7/97	Manufacture of Bevel Gears
187	1	10/96	Electrochemical Deburring (ECD) and Machining (ECM)
188	1	2/98	Termination Requirements for Chromium plated surfaces
189	draft		Torque Loads to be applied to Union Fittings
190	draft		Unit Assembly Label fixing using Cable Ties
191	1	6/00	TRIBOMETT104CS Coatings
192	5	Mar-11	Salt Spray Testing
193	1	7/00	Air Cleanliness of shop floor Compressed Air Lines
194	3	Apr-06	APTICOTE 400 and 450 Coatings
195	2	Nov-11	TECH 12 Chrome Plate Impregnation and Densification
196	2	Mar-07	Plunge Grinding
197	2	Jun-05	Visual Inspection
198	3	Sep-08	Assembly of Bushes with wet Primer
199	2	Jan-10	JSF Titanium Material and Casting Requirements

PS	Issue	Date	Title
200	2	Mar-09	Physical Vapour Deposition (PVD) of an Amorphous Carbon Coating
201	2	Nov-05	KERONITE Coatings for Ti, Al & Mg Alloys
202	2	Nov-05	Tungsten Disulphide (WS2) Thin, dry film Lubricant
203	1	8/03	Procedure for installation of Imperial thin wall Inserts
204	1	11/03	Barrel deburring for Non-ferrous loads <200g
205	3	Dec-04	Thermal Stabilisation of Servo Valves
206	draft		Scragging of shaft Assemblies
207	2	Nov-09	Electron Beam Welding Flap System Shafts for A380
208	2	Mar-06	Titanium Nitride Coatings
209	1	Apr-06	787 Aluminium material Procurement & Casting Inspection Requirements for Casting Housing, P677A0160-00
210	4	Mar-11	Mechanical Property Sampling of Oversized Aluminium Billets
211	3	Jan-08	Requirements for Electron beam welding of 787 diaphragm sub-Assembly
212	1	Sep-07	Control of Metal Working Fluids
213	1	Nov-07	Installation procedure for Tyco standard Solder Sleeve Shield Terminators
214	2	Jan-08	Controlled glass bead blasting – Diaphragm Coupling
215	1	Jan-09	Aqueous Cleaning

#### 4.0 MOOG SUPPLIER PROCESS SPECIFICATIONS (MSPS)

4.1 The following documents are for use within Moog Wolverhampton supplier base.

Document #	Issue	Date	Process #	Process Name
MSPS100.CP	2	Oct-08	MSPS100.CP.001	Anodising of Aluminium & Aluminium Alloys
			MSPS100.CP.002	Chemical Conversion Coatings on Aluminium & Aluminium Alloys
			MSPS100.CP.003	Hard Chromium Plating
			MSPS100.CP.004	Cadmium Plating
			MSPS100.CP.005	Passivation of Corrosion Resistant Steel
			MSPS100.CP.006	Copper Plating
			MSPS100.CP.007	Bronze Plating for Nitriding Stop Off Purposes
			MSPS100.CP.008	Electroless Nickel Plating
			MSPS100.CP.009	Manganese Phosphate Treatment of Steel
MSPS200.HT	1	May-08	MSPS200.HT.001	Furnace Control & Calibration (Pyrometry)
			MSPS200.HT.002	Gas Carburising / Case Hardening of Steel Parts
			MSPS200.HT.003	Gas Nitriding of Low Alloy Steel Parts
MSPS300.NDT	2	Jun-11	MSPS300.NDT.001	Etch Inspection of High Strength Steel Parts
MSPS400.MISC	1	Oct-08	MSPS400.MISC.001	Shot Peening
			MSPS400.MISC.002	Electro Discharge Machining, EDM

## 5.0 PROCESS CONTROL DOCUMENTS (PCD)

5.1 The following documents are for use at Moog Wolverhampton in-house treatments department ONLY.  
**These documents are not to be distributed externally.**

PCD	Issue	Date	Title
2	2	Nov-10	Bronze Plating
3	5	Sep-10	Furnace Operating Procedures
4	2	Nov-10	Protective Treatment of Aluminium using Alocrom 1200 Process
7	6	Sep-10	Metallography
12	4	Nov-10	Hard Chromium Plating of Steels
14	4	Mar-11	Cadmium Plating
17	2	Nov-10	Phosphate Treatment of Steel
27	3	Sep-10	Gas Nitriding of Steel Components
29	4	Mar-11	Etch Inspection of Steel Components
34	5	Mar-11	Electroless Nickel Plating
36	3	Nov-10	Copper Plating
52	2	Nov-10	Passivation of Corrosion Resistant Steels
69	4	Nov-10	Chromic Acid Anodising
71	2	May-09	Electrical Discharge Machining (EDM)
73	3	Sep-10	Gas Carburising of Steel Components
149	3	Nov-10	Sulphuric Acid Anodising of Aluminium and Titanium alloys

## 6.0 DAG PROCESS SPECIFICATIONS TRANSFERRED TO MOOG - WOLVERHAMPTON

6.1 The following are process specifications which were originally issued by Dowty Aerospace Gloucester (now GE Aviation Systems Ltd of Cheltenham), but are now controlled by MWL as they represent work that is now the technical and manufacturing responsibility of MWL (see part number groups listed in paragraph 1.2)

PS	Issue	Date	Title
DAG PS 121	3	12/70	Protection of Engine Accessory Magnesium Alloy Castings Against Corrosion
DAG PS 505	4	1/93	Requirements for Electron Beam Welding of A330/340 Flap System Shafts

**Note:** The two process specifications listed above are given the prefix DAG to distinguish them from process specifications with origins at MWL.

## 7.0 MATERIAL SPECIFICATIONS (MAT)

7.1 The following are MWL controlled material specifications (some originally Dowty Boulton Paul - DBP) which have been raised on very few specific occasions - it being MWL policy to use material from a nationally recognized standard

PS	Issue	Date	Title
DBP MAT 100	4	9/93	Additional Requirements for Tool and Die Steel to BS 4659:1989, Grade BO-1
DBP MAT 101	3	9/93	Requirements for Valve spring Steel wire to AS 33A
DBP MAT 102	2	9/93	Requirements for Aluminium plate to 7075-T7351 with thickness >75mm
MAT 103	1	4/03	Additional Requirements for phosphor bronze bar to DTD 265A
MAT 104	2	Oct-05	Copper-Beryllium Alloy UNS C17200

7.2 The following are Material Specifications which were originally issued by Dowty Aerospace Gloucester (now GE Aviation Systems Ltd of Cheltenham), but have since been reissued by MWL as they represent work that is now the technical and manufacturing responsibility of MWL.

PS	Issue	Date	Title
DAG MAT 138	2	2/93	Corrosion resisting 17-4PH Steel Tube
DAG MAT 601	3	1/01	Grease/oil mixture for Flap system Gearboxes
DAG MAT 602	3	1/01	Low viscosity Grease/oil mixture for Gearbox

## 8.0 PROCESS SPECIFICATION (PS) SUBJECT INDEX

**Note:** Only current documents are given in the following listing

### 8.1 Plating / Passivation

PS 194	Apticote 400 and 450 Coatings
PS 106	Black Oxide Treatment for Steels
PCD 2 §	Bronze Plating
MSPS100.CP.007 ‡	Bronze Plating for Nitriding Stop Off Purposes
PS 18	Chromate Treatment of Magnesium Alloy
PCD 14 §	Cadmium Plating
MSPS100.CP.004 ‡	Cadmium Plating
PS 49	Cadmium Plating of UHT Steels
PS 116	Cadmium Plating of UHT Cuprous Alloys
PS 136	Cadmium Plating of UHT Steels by Vacuum Deposition
PCD 36 §	Copper Plating
MSPS100.CP.006 ‡	Copper Plating
PS 10	Dalic Electro Plating Process
PCD 34 §	Electroless Nickel Plating
MSPS100.CP.008 ‡	Electroless Nickel Plating
PCD 12 §	Hard Chromium Plating on Steels
MSPS100.CP.003 ‡	Hard Chromium Plating
PS 16	Hard Chromium Plating of Aluminium Alloys
PS 114	Hard Chromium Plating of Copper Alloys
PS 162	Ion Vapour Deposition (IVD) of Aluminium on Steel
MSPS100.CP.009 ‡	Manganese Phosphate Treatment of Steel
PS 180	Nodular Thin Dense Chromium (NTDC) Plating
PS 37	Nickel Plating
PS 165	Nickel Sulphamate Plating
PCD 52 §	Passivation of Corrosion Resistant Steel
MSPS100.CP.005 ‡	Passivation of Corrosion Resistant Steel
PCD 17 §	Phosphate Treatment of Steels
PS 43	Reclamation of Steel Components by Heavy Nickel Plating
PS 38	Silver Plating
PS 188	Termination Requirements of Chrome Plated Surfaces
PS 21	Tin Plating

## 8.2 Painting &amp; Coatings

PS 174	Paint Schemes for use at Smiths Wolverhampton
PS 26	Paint Removers
PS 1	Dry Lubricant, Anti-Friction Coatings
PS 113	Dow Corning 3400A Bonded Lubricant
PS 178	Molykote P37 Thread Paste (Solid Lubricant)
PS 96	Rilsan Nylon Coating
PS 179	Thermal Sprayed Tungsten Carbide Coatings
PS 191	TribometT104CS Coating
PS 195	Tech-12 Chromium Plate Impregnation and Densification
PS 200	Physical Vapour Deposition (PVD) of an amorphous Carbon Coating
PS 201	Tungsten Disulphide (WS <sub>2</sub> ) Thin, Dry Film Lubricant
PS 202	Keronite Coatings for Titanium, Aluminium and Magnesium Alloys
PS 208	Titanium Nitride coatings

8.3 Surface Treatments (including machining)

PS 8	Cleaning and Surface Preparation of Metallic Materials
PS 121	Pickling of S145 Forgings
PS 143	Abrasive Blasting of Metallic Materials
MSPS400.MISC.001 ‡	Shot Peening
PS 95	Glass Bead Peening
PS 100	Application of Extrude Hone Process for Surface Finish Improvement
PS 138	Special Machining Techniques for UHT Steels
PS 187	Electrochemical Deburring (ECD) and Machining (EDM)
PCD 71 §	Electro Discharge Machining (EDM)
MSPS400.MISC.002 ‡	Electro Discharge Machining, EDM
PS 98	Grinding of Titanium Alloys
PS 167	Grinding and Inspection of Chromium Plated Parts
PS 125	Swaging of Metric Pipe Couplings
PS 132	Thread Rolling of Special Applications
PS 164	Electropolishing of Investment Castings
PS 169	Laser Cutting of Metals
PS 196	Plunge Grinding

## 8.4 Anodising and Surface Oxidation of Light Alloys

PCD 4 §	Alocrom 1200 Process
MSPS100.CP.002 ‡	Chemical Conversion Coatings on Aluminium & Aluminium Alloys
PCD 69 §	Chromic Acid Anodising
PCD 149 §	Sulphuric Acid Anodising of Aluminium and Titanium Alloys
MSPS100.CP.001 ‡	Anodising of Aluminium and Aluminium Alloys

**Note:** MSPS100.CP.001 covers chromic acid anodising, sulphuric acid anodising and hard anodising

- 8.5 Heat Treatment
- PS 118 Heat Treatment of Alloy Steels
  - PS 119 Induction Hardening
  - PCD 73 § Gas Carburising
  - MSPS200.HT.002 ‡ Gas Carburising / Case Hardening of Steel Parts
  - PCD 27 § Nitriding of Steel Components
  - MSPS200.HT.003 ‡ Gas Nitriding of Low Alloy Steel Parts
  - PS 151 Plasma (Ion) Nitriding
  - PS 11 Salt Bath Nitrocarburising - Sursulf and Tufftriding
  - PS 160 Nitrotec (Nitrocarburising) Surface Treatment
  - PS 155 Hot Isostatic Pressing (HIP) of Investment Castings
  - PS 168 Requirements for Hot Form Swaging
- 8.6 Joining (including adhesives, mechanical and thermal processes)
- PS 89 General Riveting Process
  - PS 90 Cryogenic Jointing
  - PS 28 Araldite Epoxy Resin Adhesives
  - PS 147 Epoxy Bonding Procedure of Laminated Servo Valve
  - PS 33 Loctite Sealants and Adhesives
  - PS 77 Jointing and Sealing Compounds
  - PS 133 Application of Dow Corning 3145 RTV Adhesive Sealant
  - PS 124 Use of Waylock S-17163 Adhesive
  - PS 42 Silver Brazing
  - PS 32 Induction Brazing
  - PS 67 Removal of Excess Copper Braze from Bushes
  - PS 86 Brazing Technique for Transducer Type P297-45-0060
  - PS 58 Reclamation of Cast Iron components by Powder Welding
  - PS 87 General Requirements for Spot Welding Sheet Assemblies
  - PS 181 Welding Hydraulic Pipes and End Fittings
  - PS 135 Electron Beam Welding of 4340 ESR
  - PS 166 Electron Beam Welding of B777 Ball Ramp Assembly
  - PS 173 Electron Beam Welding of JAS 39 Engine Accessory Gearbox IDG and Breather Gears
  - PS 505 † Electron Beam Welding of A330/340 Flap System Shafts
  - PS 207 Electron Beam Welding of Flap System Shafts for A380
  - PS 211 Requirements for Electron Beam Welding of 787 Diaphragm Sub-Assembly
- 8.7 Assembly and Fitting
- PS 126 Tube/Pipe Bending
  - PS 56 Manipulation of Cold Set Performed Rigid Pipes
  - PS 127 Routing and Installation of Non-Lofted Hydraulic Pipes
  - PS 88 Assembly of Keelaring Couplings
  - PS 23 Fitting Heat Shrink on Plastic Sleeving and Boots
  - PS 123 Sealing of Pipe/Coupling Ends with Heat Shrinkable Sleeving
  - PS 41 Plugging of Hydraulic Components with Lee Plugs (existing Civil Contracts only)
  - PS 57 Plugging of Hydraulic Components with Lee Plugs (all current and future contracts)
  - PS 44 Secondary Staking of Lee Plugs
  - PS 54 Plugging of Hydraulic Components (other than Lee Plugs)

	PS 46	Removal of Copper Plugs from Rotary Valve Sleeves
	PS 66	Crimped Cable Connectors
	PS 60	Undercutting of Screw Threads
	PS 157	MJ Threads Modified for Critical Load Applications
	PS 158	UNJ Threads Modified for Critical Load Applications
	PS 92	Printed Wiring Board Manufacture
	PS 109	Assembly and Protection of Printed Wiring Boards
	PS 159	Helical Compression Springs for Aerospace Applications
	PS 170	Assembly and Installation of Magnetic Seals
	PS 172	Assembly Procedure for Flareless Fittings
	PS 182	Fitting of Seals without Lead Groove Locations
	PS 189	Torque Loads to be Applied to Union Fittings
	PS 198	Assembly of Bushes with Wet Primer
	PS 203	Procedure for Installation of Imperial Thin Wall Inserts
	PS 205	Thermal Stabilisation of Servo Valves
8.8	Contamination and Cleaning	
	PS 19	Contamination Levels in Hydraulic Fluid
	PS 20	Sampling of Fluids for Contamination Checks
	PS 5	Cleaning of Hydraulic Pipes
	PS 78	Trichloroethylene Vapour Degreasing
	PS 215	Aqueous Cleaning
	PS 142	Ultrasonic Cleaning and Suitable Aqueous Cleaning Solutions
	PS 50	Chemical Cleaning of Steels (Sulphur Prints)
	PS 161	Use and Control of Cleaning Fluids
	PS 193	Air Cleanliness of Shop Floor Compressed Air Lines
8.9	Protection and Storage	
	PS 45	Temporary Protection against Corrosion
	PS 121 †	Protection of Engine Accessory Magnesium Alloy Castings against Corrosion
	PS 24	Packaging of Hydraulic Assemblies for Storage
	PS 25	Packaging of Electrical Components and Assemblies
	PS 139	Protective Treatment against Galvanic Corrosion - Mastinox
	PS 171	Aircraft Hydraulic/Mechanical Assemblies Storage and Preservation Information
	PS 183	Control of Shelf Life Limited Items

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- 8.10 NDT and other Inspection Techniques
- PCD 29 § Etch Inspection of Steel Components
  - MSPS300.NDT.001 ‡ Etch Inspection of High Strength Steel Parts
  - PS 55 Bolt Etching Process (Forged Heads)
  - PS 111 Hardness Inspection of Metallic Materials
  - PS 74 Magnetic Particle Inspection
  - PS 79 Fluorescent Penetrant Inspection
  - PS 167 Grinding and Inspection of Chromium Plated Parts
  - PS 102 Ultrasonic Inspection of Aluminium Alloys
  - PS 63 Photographic Examination of Hard Chrome Plated Cylinder Bores
  - PS 185 Radiographic Acceptance Standards for Castings
  - PS 192 Salt Spray Testing to ASTM B117
  - PS 197 Visual Inspection
- 8.11 Component Identification
- PS 156 Part Marking
  - PS 110 Hydraulic Pipe Identification (<12mm)
  - PS 40 Adhesive Fixing of Labels (Silastic 738 RTV)
  - PS 190 Unit Assembly Label Fixing using Cable Ties
- 8.12 Potting Techniques
- PS 51 Pretreatment and Surface Coating of PTFE Insulated Cables Prior to Potting
  - PS 101 Application of two Package RTV 88 Silicone for Potting Purposes
  - PS 76 Procedure for Potting Concorde Linear Transducers
  - PS 120 Crystal clear Silicon Potting Compound
- 8.13 Miscellaneous
- PS 31 Impregnation of Coil Windings
  - PS 104 Impregnation of Oilite Porous Bronze Bearings
  - PS 22 Treatment for Solenoid Coil Assemblies
  - PS 6 Surface Sealing of Magnesium Alloys
  - PS 175 Manufacture of A330/340 Composite Transmission Shafts
  - PS 186 Manufacture of Bevel Gears
  - PS 199 JSF Titanium Material Procurement & Casting Inspection Requirements
  - PS 204 Barrel De-Burring for Non-Ferrous Loads Under 200g
  - PS 210 Mechanical Property Sampling of Oversized Aluminium Billets
  - PS 209 787 Aluminium Material Procurement & Casting Inspection Requirements for Casting Housing, P677AO160-00
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8.14	Material Specifications (MAT)	
	MAT 100	Additional Requirements for Tool and Die Steel to BS 4659
	MAT 101	Requirements for Valve Spring Steel Wire to AS 33A
	MAT 102	Requirements for Aluminium Plate to 7075-T7351 with Thickness >75mm
	MAT 103	Additional requirements for Phosphor Bronze Bar to DTD 265A
	MAT 104	Copper-Beryllium Alloy UNS C17200
	MAT 138 □	Corrosion Resisting 17-4PH Steel Tube
	MAT 601 □	Grease/Oil Mixture for Flap System Gearboxes
	MAT 602 □	Low Viscosity Grease/Oil Mixture for Flap System Gearboxes
8.15	Relevant Quality Control Instructions (QCI) or Business Procedures (BP) or Moog Aircraft Group Quality Procedures	
	QCI 001	Explanatory Notes
	BP 9002 §	Equipment Calibration/Heat Treatment Control
	MSPS200.HT.001 ‡	Furnace Control & Calibration (Pyrometry)
	QCI 124	Acceptance Sampling Plans
	QCI 126	Classification of Parts
	BP 7106	Control of NDT Operations and Approval of NDT Personnel
	QCI 216	Recommended and Cancelled Metallic Material Specifications for Aerospace Applications
	QCI 311	Test Pieces for Heat Treatment and Process
	BP 7107	Inspection Records and Inspection Cards
	7100-001-090	Special Processes Procedures

#### Key to Symbols used in section 8

†	see section 5.1
□	see section 6.2
§	for in-house use at MWL only (see section 5.0)
‡	for use within MWL supplier base (see section 4.0)

## 9.0 CORRELATION INDEX

9.1 See Following tables and symbols below:-

\*\* An alternative specification for MWL approved suppliers (see each PS for specific limitations/requirements)

\* Originally a Cheltenham specification now under MWL control

**Note:** In this section some specifications which are superseded (e.g. PS 2 Bronze Plating) are given for reference. See section 2.0 – Master Index – for the issue status of specifications.

9.2 Column C in the following tables represents the internal instruction or procedure to be used when a corresponding customer specification is called for on the Moog Wolverhampton job documentation (Layout Sheet). This applies to processing in house at Moog Wolverhampton only.

	Wolver-hampton (Col A)	Rotol / DAG (Col B)	MWL in-house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls-Royce RPS	Avio	International Alternative **
<b>Plating / Passivation</b>										
Bronze Plating	MSPS100. CP.007	PS 111	PCD 2	PS 111				438		
Cadmium Plating	MSPS100. CP.004	PS 100	PCD 14	PCS 2102	03-19 (RS 116B)	5701 QQ-P- 416	4-3000	170		
Cadmium Plating of Cuprous Alloys	PS 116		n/a	PCS 2102						
Cadmium Plating of UHT Steel	PS 49	PS 131	n/a	PCS 2100		5718				
Cadmium Plating of UHT Steels by Vacuum Deposition	PS 136		n/a	-	03-28					
Hard Chromium Plating on Steel	MSPS100. CP.003	PS 101	PCD 12	PCS 2110	03-14	5709	4- 3200/1/2/4/5	130		
Hard Chromium Plating of Light Alloys	PS 16	PS 119	n/a	PS 119						
Hard Chromium Plating of Copper Based Alloys	PS 114	PS 116	n/a	-						
Nodular Thin Dense Chromium (NTDC) Plating	PS 180	PS 135	n/a	-		5709				
Copper Plating	MSPS100. CP.006	PS 106	PCD 36	PS 106		5722		297		
Nickel Plating	PS 37	PS 107	n/a	PS 107	03-10	5746				
Nickel Sulphamate Plating	PS 165		n/a	-	03-27					
Electroless Nickel Plating	MSPS100. CP.008		PCD 34	-	03-5	5728	4-4300			
Reclamation of Steel Components by Heavy Nickel Plating	PS 43		n/a	-						
Silver Plating	PS 38		n/a	-	03-9	5715		168		
Tin Plating	PS 21		n/a	-	03-8	5717		497		
Dalic Electroplating Process	PS 10	PS 118 PS 137	PS 10	PS 118 PCS 2141		5849			6616F	
Passivation of Corrosion Resistant Steel	MSPS100. CP.005	PS 124	PCD 52	PS 124		5625	4-1201			
Phosphate Treatment of Steel	MSPS100. CP.009	PS 108	PCD 17	PS 108	03-11	5810	4-1002	6		
Black Oxide Treatment for Steels	PS 106	PS 132	n/a	PCS 2200						
Chromate Treatment of Magnesium Alloys	PS 18	PS 103	PS 18	PS 103	DTD 911			22		
Ion Vapour Deposition (IVD) of Aluminium on Steel	PS 162		n/a	-	03-28	5315				
Apitocote 400 & 450 Coating/Niflor Low Friction Coating	PS 194	PS 129	n/a	-						
Termination Requirements of Chrome Plated Surfaces	PS 188	PS 1031	PS 188	M-DLPS1031						

	Wolver- hampton (Col A)	Rotol / DAG (Col B)	MWL in- house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls- Royce RPS	Avio	International Alternative **
<b>Anodising</b>										
Alocrom 1200 Process	MSPS100. CP.002	PS 114	PCD 4	PCS 2220		5719	4-2004		6618F	
Chromic Acid Anodising	MSPS100. CP.001	PS 102	PCD 69	PS 102	03-24 RS 116D	5019	4-2103	54/3		
Sulphuric Acid Anodising of Aluminium and Titanium Alloys	MSPS100. CP.001	PS 102	PCD 149	PS 102	03-25	5022	4-2001/2/3	54/4	6603F	
Hard Anodising of Aluminium Alloys	MSPS100. CP.008		n/a	-	03-26	5821	4-2200		6617F	
<b>Painting / Coatings</b>										
Paint Schemes	PS 174	various	PS 174	various		5736	4-5314/6			
Use of Paint Remover	PS 26	PS 211	PS 26	PCS 2700						
Dry Lubricant, Anti-Friction Coatings	PS 1	PS 1	PS 1	PS 117			4-5906	661/10		
Dow Corning 3400A Bonded Lubricant	PS 113		PS 113	-						
Rilsan Nylon Coating	PS 96	PS 133	PS 96	PS 133						AMS 2447 (HVOF only)
Metal/Ceramic Coating	PS 65		PS 65	-		5851				
Thermal Sprayed Tungsten Carbide Coatings	PS 179		n/a	-						
Tribomet T104CS Coating	PS 191		n/a	-						
Tech 12 Chromium Plate Impregnations and Densification	PS 195		n/a	-						
Physical Vapour Deposition (PVD) of an amorphous Carbon Coating	PS 200		n/a	-			4-4202			
Tungsten Disulphide (WS2) thin, Dry Film Lubricant	PS 201		n/a	-						
Keronite Coatings for Titanium, Aluminium and Magnesium Alloys	PS 202		n/a	-						
Titanium Nitride Coatings	PS 208		n/a	-						

	Wolver-hampton (Col A)	Rotol / DAG (Col B)	MWL in-house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls-Royce RPS	Avio	International Alternative **
<b>Surface Treatments (incl. machining)</b>										
Pickling of 5145 Forgings	PS 121		n/a							
Cleaning and Surface Preparation of Metallic Materials	PS 8	PS 207	PS 8	PS 207	03-4	5751				
Shot Peening	MSPS400. MISC.001	PS 123	n/a	PS 123		5730				
Abrasive Blasting of Metallic Materials	PS 143	PS 200 PS 201	PS 143	PCS 2610				386		
Application of Extrude Hone Process for Surface Finish Improvement	PS 100		PS 100							
Glass Bead Peening	PS 95	PS 134	n/a	PS 134 PS 139		5951				
Special Machining Techniques for UHT-Steels	PS 138	PS 1004	PS 138	M-DLPS1004						
Electrical Discharge Machining (EDM)	MSPS400. MISC.002	PS 504	PCD 71	PS 504		5969		418		
Electrochemical Deburring (ECD) and Machining (ECM)	PS 187		PS 187				4-0034			
Grinding of Titanium and Titanium Alloys	PS 98	PS 935	PS 98	PS 935		5492	2-0004			
Grinding of Inspection of Chromium Plated Parts	PS 167	NDT 3	PS 167	M-DLNDT3		5032				
Swaging of Metric Pipe Couplings	PS 125		PS 125							
Thread Rolling of Special Applications	PS 132	PS 138	PS 132	PS 138						
Electropolishing of Investment Castings	PS 164	PS 128	n/a	PS 128		5622	7-5008 4-0034			
Laser Cutting of Metals	PS 169		n/a			5982				
Plunge Grinding	PS 196	PS 1004-1	PS 196	M-DLPS1004						

	Wolver- hampton (Col A)	RotoI / DAG (Col B)	MWL in- house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls- Royce RPS	Avio	International Alternative **
<b>Heat Treatment</b>										
Heat Treatment of Alloy Steels	PS 118	PS 319	PS 118	PS 319		5619	3-0XXX 4-4202			various
Induction Hardening	PS 119		n/a	-		5616				
Gas Carburising	MSPS200. HT.002	PS 312	PCD 73	PS 312		5641	3-0121	371		
Gas Nitriding of Steel Components	MSPS200. HT.003	PS 302	PCD 27	PS 302		5640	3-1004/9	135		
Plasma (Ion) Nitriding	PS 151		n/a	-						
Salt Bath Nitrocarburising - Sursel and Tuffriding	PS 11		n/a	-						
Nitrotec (Nitrocarburising) Surface Treatment	PS 160		n/a	-						
Hot Isostatic Pressure (HIP) of Investment Castings	PS 155		n/a	-						
Requirements for Hot Form Swaging	PS 168	PS 321	n/a	PS 321						
Equipment Calibration/Heat Treatment Control	MSPS200. HT.001		BP 9002	PS 311		5621		953		
<b>Contamination and Cleaning</b>										
Contamination Levels for Hydraulic Fluids	PS 19	PS 910	PS 19	M-DLPS910						
Cleaning of Hydraulic Pipes	PS 5		PS 5	-						
Trichloroethylene Vapour Degreasing	PS 78	PS 203	PS 78	PCS 2620		5408		128		
Aqueous Cleaning	PS 215		PS 215							
Ultrasonic Cleaning and Suitable Aqueous Cleaning Solutions	PS 142	PS 204	PS 142	PCS 3213				498		
Chemical Cleaning of Steels (Sulphur Prints)	PS 50		n/a	-						
Use and Control of Cleaning Fluids	PS 161		PS 161	-						
Air Cleanliness of Shop Floor Compressed Air Lines	PS 193		PS 193	-		7217				
Cleaning and Surface Preparation of Metallic Materials	PS 8	PS 207	PS 8	PS 207	03-4	5751				

Wolver-hampton (Col A)	Rotol / DAG (Col B)	MWL in-house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls-Royce RPS	Avio	International Alternative **
<b>Joining (adhesives, mechanical &amp; thermal processes)</b>									
General Riveting Process		n/a	-						
Cryogenic Jointing		n/a	-						
Araldite Epoxy Resin Adhesives	PS 707/805	PS 28	M-DLPS709						
Epoxy Bonding Procedure of Laminated Servo Valve		PS 147	-						
Loctite Sealants and Adhesives	PS 709	PS 33	M-DLPS709			6-0112			
Jointing and Sealing Compounds	PS 709	PS 77	M-DLPS709			6-0112 4-5802	638		
Application of Dow Corning 3145 RTV Adhesive Sealant		PS 133	-						
Use of Waylock S-17163 Adhesive		PS 124	-						
Silver Brazing	PS 303	PS 42	PS 303		5940				
Induction Brazing		PS 32	-						
Removal of Excess Copper Braze from Bushes		PS 67	-						
Brazing Technique for Transducer Type P297-45-0060		PS 86	-						
Reclamation of Cast Iron Components by Powder Welding		PS 58	-						
General Requirements for Spot Welding Sheet Assemblies		PS 87	-						
Welded Hydraulic Pipes and End Fittings		PS 181	-						
EB Welding of ESR 4340		PS 135	-						
EB Welding of B777 Ball Ramp Assembly		PS 166	-						
EB Welding of JAS 39 EAG Gear Couplets		PS 173	-						
EB Welding of A330/340 Flap System Shafts	PS 505*	n/a	-						
EB Welding of Flap System Shafts for A380		PS 207	-						

	Wolver- hampton (Col A)	Rotol/ DAG (Col B)	MWL in- house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls- Royce RPS	Avio	International Alternative **
<b>Assembly and Fitting</b>										
Tube/Pipe Bending	PS 126		PS 126	-						
Manipulation of Cold Set Performed Rigid Pipes	PS 56		PS 56	-						
Routing and Installation of Non-Lofted Hydraulic Pipes	PS 127		PS 127	-						
Assembly of Keelring Couplings	PS 88		PS 88	-						
Fitting Heat Shrink on Plastic Sleeving and Boots	PS 23	PS 821	PS 23	M-DLPS821						
Sealing of Pipe/Coupling Ends with Heat Shrinkable Sleeving	PS 123	PS 820	PS 123	M-DLPS802						
Plugging of Hydraulic Components - Lee Plugs (Civil Contracts only)	PS 41	PS 1009	PS 41	PS 1009						
Plugging of Hydraulic Components (other than Lee Plugs)	PS 54		PS 54	PS 1009						
Plugging of Hydraulic Components - Lee Plugs (Military Contracts only)	PS 57	PS 1009	PS 57	PS 1009						
Secondary Staking of Lee Plugs	PS 44		PS 44	PS 1009						
Removal of Copper Plugs from Rotary Valve Sleeves	PS 46		PS 46	-						
Crimped Cable Connectors	PS 66	PS 902	PS 66	PS 902						
Undercutting of Screw Threads	PS 60		PS 60	-						
MJ Threads Modified for Critical Load Applications	PS 157		PS 157	-						
UNJ Threads Modified for Critical Load Applications	PS 158		PS 158	-						
Printed Wiring Board Manufacture	PS 92		PS 92	-						
Assembly and Protection of Printed Wiring Boards	PS 109		PS 109	-						
Helical Compression Springs for Aerospace Applications	PS 159		PS 159	-						
Assembly and Installation of Magnetic Seals	PS 170		PS 170	-						
Assembly and Procedure for Flareless Fittings	PS 172		PS 172	-						
Assembly of Wet Bushes with Wet Primer	PS 198	PS 1011- 14	PS 198	M-DLPS1011- 14						
Procedure for Installation of Imperial Thin Wall Inserts	PS 203		PS 203							
Thermal Stabilisation of Servo Valves	PS 205		PS 205							

	Wolver-hampton (Col A)	Rotol / DAG (Col B)	MWL in-house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls-Royce RPS	Avio	International Alternative **
<b>Protection and Storage</b>										
Temporary Protection Against Corrosion	PS 45	PS 202	PS 45	PCS 2800			4-5802/704	367		
Protection of Engine Accessory Magnesium Alloy Castings Against Corrosion		PS 121*	PS 121*	-						
Packaging of Hydraulic Assemblies for Storage	PS 24		PS 24	-						
Packaging of Electrical Components and Assemblies	PS 25		PS 25	-						
Protective Treatment against Galvanic Corrosion - Mastinox	PS 139	PS 709	PS 139	M-DLPS709			4-5802			
Aircraft Hydraulic/Mechanical Assemblies - Storage and Preservation Information	PS 171	PS 1016	PS 171	M-DLPS1016				259		
Control of Shelf Limited Items	PS 183	PS 909	PS 183	PS 909						
<b>Potting Techniques</b>										
Pre-treatment and Surface Coating of PTFE Insulated Cables	PS 51	PS 812	PS 51							
Potting Application of Two Package RTV 88 Silicone Rubber	PS 101		PS 101							
Crystal Clear Silicone Potting Compound	PS 120		PS 120							
<b>Component Identification</b>										
Part Marking	PS 156	PS 405	PS 156	PS 405		5307	0-0016	753		
Hydraulic Pipe Identification (12mm and less) for MCMV	PS 110		PS 110							
Adhesive Fixing of Labels using Silastic 738 RTV	PS 40	PS 727	PS 40	PS 727						
Unit Assembly Label Fixing using Cable Ties	PS 190		PS 190				0-0379			

	Wolver- hampton (Col A)	Rotal / DAG (Col B)	MWL in- house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls- Royce RPS	Avio	International Alternative **
<b>NDT &amp; other Inspection Techniques</b>										
Eich Inspection of Steel Components	MSPS300. NDT.001	NDT 6	PCD 29	PCS 3600		5436		147		AMS 2649
Bolt Etching Process (Forged Heads)	PS 55	NDT 6	n/a	PCS 3600				MSRR 9969		
Hardness Inspection of Metallic Materials	PS 111		PS 111	-						
Magnetic Particle Inspection	PS 74	NDT 2&3 PS 400	PS 74	PCS 3100		5424 7040	7-4900	700	9400F	ASTM E1444
Fluorescent Penetrant Inspection	PS 79	NDT 3&8 PS 404	PS 79	NDT 8		5423 7039	7-4910	702	9300F	ASTM E1417
Ultrasonic Inspection of Aluminium Alloys	PS 102	NDT 16	n/a	NDT 16		5439				
Photographic Examination of Hard Chrome Plated Cylinders	PS 63		n/a	-						
Radiographic Acceptance Standards for Castings	PS 185	NDT 14	n/a	QCI 521	PS 507		PS 507			
Salt Spray Testing	PS 192		PS 192							
Visual Inspection	PS 197		PS 197	-				709		
Control of NDT Operations and Approval of NDT Personnel	BP7106	NDT 10	BP 7106	M-DLNDT10		7698		906/908		NAS 410 prEN 4179

	Wolver- hampton (Col A)	Rotol / DAG (Col B)	MWL in- house PS (Col C)	Messier Dowty	Def Std	Boeing BAC	Liebherr LAT	Rolls- Royce RPS	Avio	International Alternative **
<b>Miscellaneous</b>										
Impregnation of Coil Windings	PS 31	PS 802	PS 31	-						
Locite Sealants & Adhesives	PS 33		PS 33	-			2-3200			
Secondary Staking of Lee Plugs	PS 44		PS 44	-			0-0192			
Plugging of Hydraulic Components with Lee Plugs	PS 57		PS 57	-			0-0192			
MJ Threads Modified for Critical Load Applications	PS 157		PS 157	-			2-1901			
UNJ Threads Modified for Critical Load Applications	PS 158		PS 158	-			2-1901			
Impregnation of Oilite Porous Bronze Bearings	PS 104		PS 104	-						
Treatment of Solenoid Coil Assemblies	PS 22		PS 22	-						
Surface Sealing of Magnesium Alloys	PS 6	PS 619	PS 6	PS 619	DTD 935			367		
Manufacture of A330/340 Composite Transmission Shafts	PS 175		n/a	-						
Manufacture of Bevel Gears	PS 186		PS 186	-						
Termination Requirements of Chrome Plated Surfaces	PS 188	PS 1031	PS 188	M-DLPS1031						
Joining & Sealing compounds	PS 77		PS 77	-			4-5802			
JSF Titanium Material Procurement & Casting Inspection Requirements	PS 199		n/a	-				MSRR 8670		
Barrel de-burring for non-ferrous loads under 200 grams	PS 204		PS 204	-				251		
Mechanical Property Sampling of Oversized Aluminium Billets	PS 210		PS 210	-						
787 Aluminium Material Procurement & Casting Inspection Requirements for Casting Housing, P677A0160-00	PS 209		PS 209	-						
Recommended and Cancelled Metallic Materials Specification for Aerospace Applications	QCI 216	PS 1001/ MAT 905/ MAT 909	n/a	M-DLPS1001 MAT 905 MAT 909						
Inspection Records and Inspection Cards	BP 7107		n/a							
Test Pieces for Heat Treatment and Process	QCI 311	MAT 902	n/a							
Special Processes Procedures	7100-001-090		n/a							