

**Standard:** PS 501

**Title:** Boeing Process Specification Index

**Approvals:**

Issue	Compiled	Date	M&P Eng.	QA	Approved	EO
1	S Ford	20190402	S Ford	P Fenton	B Roberts	ECNEU01622
2	S Ford	20190626	S Ford	P Fenton	B Roberts	ECNEU02565
3	<b>S Ford</b>	<b>20191029</b>	<b>S Ford</b>	<b>P Fenton</b>	<b>B Roberts</b>	<b>ECNEU02715</b>

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## 1.0 SCOPE

- 1.1 This document covers the issue status and process specification departures (PSD) applicable to Boeing specifications used on make-to-print parts for Moog Wolverhampton.
- 1.2 The listing is designed as a look up tool for Supply Chain to determine the latest specification and departure issue which is needed for manufacturing on make-to-print parts for Moog Wolverhampton.
- 1.3 Where industry process specifications are used in the manufacturer or other supporting processes related to make-to-print parts for Moog Wolverhampton, e.g. AMS-QQ-P-416 or ASTM B117 then these shall be obtained directly by the supplier.

## 2.0 INTRODUCTION

- 2.1 The listing is not exhaustive. Requests to add further Boeing process specifications should be made through the Moog purchasing contact.
- 2.2 When a supplier requires a copy of a particular document the request shall be made through the Moog purchasing contact.
- 2.3 An example of a Process Specification Departure (PSD) is shown in Appendix 1.

## 3.0 REFERENCE DOCUMENTS

Whenever a specification is referenced as PS xxx, then this shall imply the in-house standard of Moog Wolverhampton. Specifications from other companies or institutions shall be given a suitable prefix to identify the source.

<http://active.boeing.com/doingbiz/d14426/index.cfm>

## 4.0 PROCESS SPECIFICATION LISTING

- 4.1 In the tables below only PSDs that apply to Boeing Commercial Airplanes are shown, i.e. only those beginning 6-xxx. For those specifications with an associated Qualified Products Listing (QPL) the revision status of this is given in the PSD column. Items marked with a ★ have been updated since the last revision.
- 4.2 In the column “Date of most recent update” a date of 7-Aug-18 represents the date at which the initial issue status data was gathered for this document. Additionally, the date given is the date of the notification from the Boeing specification website which will be one day later than the date that appears as the “release date” on the document – see Appendix 2.
- 4.3 Primary specifications (marked with a ‘P’) are those which are directly called-out from the part drawing. These specifications are controlled within MBS with a link to each part number where they apply. Other specifications are secondary, i.e. called out from within the primary specifications. These are not controlled within MBS.
- 4.4 Documents with the following prefix are included in the table below:-
- BAC (Boeing Airplane Company)
  - BMS (Boeing Material Specification)
  - BSS (Boeing Specification Support Standard)
  - D2 & D6

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5000</b>	SEALING, GENERAL	AR	6-277, 6-278, 6-279, 6-280, 6-281, 6-282, 6-283, 6-284, 6-285, 6-286, 6-288, 6-290, 6-291, 6-294, 6-298, 6-308, 6-309, 6-311, 6-313, 6-315	29-Nov-18	P	<input type="checkbox"/>
<b>BAC5004</b>	INSTALLATION OF PERMANENT FASTENERS	M	6-118, 6-121, 6-122, 6-130, 6-131, 6-133, 6-139	13-Feb-19	P	<input type="checkbox"/>
<b>BAC5008</b>	APPLICATION OF LUBRICANTS	U	6-108, 6-111, 6-112, 6-115, 6-117, 6-131, 6-133, 6-134, 6-135, 6-136, 6-139, 6-140, 6-141, 6-142, 6-143, 6-144, 6-145, 6-146, 6-147	8-Dec-18	-	<input type="checkbox"/>
<b>BAC5009</b>	BOLT AND NUT INSTALLATION	AE	6-154, 6-179, 6-183, 6-184, 6-185	5-Oct-18	P	<input type="checkbox"/>
<b>BAC5019</b>	CHROMIC ACID ANODIZING	U	6-135, 6-143, 6-145, 6-155, 6-158, 6-162, 6-163, 6-166, 6-167, 6-169	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5027</b>	INSTALLATION OF AIR PRESSURE SEALS ON CABLE ASSEMBLIES	Y	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5032</b>	GRINDING OF CHROMIUM PLATE	G	6-009, 6-011, 6-012	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5034</b>	TEMPORARY PROTECTION OF PRODUCTION MATERIALS, PARTS, AND ASSEMBLIES	P	6-131, 6-134, 6-136	10-May-19	P	*
<b>BAC5034-2</b>	TEMPORARY PROTECTION OF PRODUCTION MATERIALS, PARTS AND ASSEMBLIES WITH NONADHERENT FILM AND SHEET COVERINGS	G	6-040, 6-042	17-May-19	P	*
<b>BAC5034-3</b>	TEMPORARY PROTECTION OF PRODUCTION MATERIALS, PARTS AND ASSEMBLIES WITH PRESERVATIVES	D	6-004, 6-006	7-Aug-18	P	<input type="checkbox"/>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5034-4</b>	TEMPORARY PROTECTION OF PRODUCTION MATERIALS, PARTS, AND ASSEMBLIES WITH PRESSURE SENSITIVE TAPE	J	6-064, 6-068, 6-069, 6-073, 6-074, 6-075	12-Feb-19	P	<input type="checkbox"/>
<b>BAC5047</b>	FLUID TIGHT FASTENER INSTALLATION	M	6-104, 6-106, 6-107, 6-108, 6-109, 6-110	7-Feb-19	P	<input type="checkbox"/>
<b>BAC5064</b>	INSTALLATION OF INSERTS, PANEL FASTENERS AND RELATED HARDWARE	E	6-033, 6-034, 6-040, 6-042, 6-045, 6-046, 6-048, 6-049, 6-050, 6-052, 6-053, 6-054, 6-055, 6-057, 6-058	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5300</b>	FORMING, STRAIGHTENING AND FITTING METAL PARTS	N	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5305</b>	APPLICATION OF ALUMINUM FOIL MARKERS	P	N/A	22-Aug-18	P	<input type="checkbox"/>
<b>BAC5307</b>	PART MARKING	W	6-289, 6-315	19-Apr-19	P	<input type="checkbox"/>
<b>BAC5312</b>	APPLICATION OF PLASTIC FILM MARKERS	T	N/A	19-Dec-18	P	<input type="checkbox"/>
<b>BAC5401</b>	STORAGE, HANDLING, ISSUANCE AND AGE CONTROL OF RUBBER OR RUBBER-LIKE MATERIALS	F	6-003	5-Jan-19	P	<input type="checkbox"/>
<b>BAC5407</b>	Cementing of Metal to Wood or Plastics	B	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5408</b>	VAPOR DEGREASING	M	6-039, 6-046, 6-051, 6-054, 6-056, 6-057, 6-058, 6-061, 6-062, 6-063, 6-067, 6-069, 6-070, 6-071, 6-072, 6-074, 6-075, 6-076	22-Oct-18	-	<input type="checkbox"/>
<b>BAC5423</b>	PENETRANT METHODS OF INSPECTION	W	6-155, 6-156, 6-158, 6-159	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5424</b>	MAGNETIC PARTICLE INSPECTION	U	6-040	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5435</b>	BEARING INSTALLATION AND RETENTION	AA	6-062, 6-074, 6-075	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5436</b>	ETCH INSPECTION OF GROUND OR MACHINED STEEL PARTS	G	6-051, 6-053, 6-061, 6-070, 6-071, 6-072, 6-074, 6-075	10-May-19	P	*
<b>BAC5439</b>	ULTRASONIC INSPECTION	J	6-023	20-Dec-18	P	<input type="checkbox"/>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5440</b>	HOLE PREPARATION, MACHINING, AND GRINDING OF STEELS	L	6-046, 6-051	11-Jun-19	P	*
<b>BAC5602</b>	HEAT TREATMENT OF ALUMINUM ALLOYS	AG	6-182, 6-184, 6-202, 6-203, 6-205	29-Jun-19	P	*
<b>BAC5604</b>	BELT GRINDING OF WEAR COATINGS	A	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5617</b>	HEAT TREATMENT OF ALLOY STEELS	W	N/A	4-Apr-19	P	*
<b>BAC5618</b>	CARBURIZING AND NITRIDING OF STEELS	F	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5619</b>	HEAT TREATMENT OF CORROSION RESISTANT STEEL	K	N/A	24-May-19	P	*
<b>BAC5621</b>	TEMPERATURE CONTROL FOR PROCESSING OF MATERIALS	L	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5625</b>	SURFACE TREATMENTS FOR FERROUS ALLOYS	E	6-040, 6-060, 6-061, 6-062, 6-066, 6-067, 6-068, 6-069	18-Apr-19	P	<input type="checkbox"/>
<b>BAC5632</b>	BORIC ACID - SULFURIC ACID ANODIZING	D	6-031, 6-039, 6-043, 6-050, 6-055, 6-060, 6-062, 6-063, 6-064, 6-067, 6-068, 6-069, 6-071, 6-072, 6-073, 6-074, 6-075, 6-076, 6-077, 6-078, 6-080, 6-081, 6-082, 6-083, 6-084, 6-085	4-Jul-19	P	*
<b>BAC5640</b>	NITRIDING OF STEEL	A	N/A	16-May-19	P	*
<b>BAC5641</b>	CARBURIZING OF CARBON AND ALLOY STEELS	ORG	6-003, 6-004, 6-007, 6-008, 6-010	22-Dec-18	P	<input type="checkbox"/>
<b>BAC5656</b>	ABRASIVE WATERJET CUTTING FOR METALS AND METAL-COMPOSITE HYBRIDS	E	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5669</b>	VIBRATORY PEENING	A	N/A	7-Aug-18	P	<input type="checkbox"/>
<b>BAC5701</b>	CADMIUM PLATING	N	6-051, 6-054, 6-055, 6-057, 6-058, 6-060, 6-061, 6-062, 6-063, 6-064, 6-065, 6-066	7-Aug-18	P	<input type="checkbox"/>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5709</b>	HARD CHROMIUM PLATING	W	QPL REV A 6-057, 6-066, 6-067, 6-071, 6-072	18-Apr-19	<b>P</b>	<b>*</b>
<b>BAC5716</b>	PREPARATION OF COLORED ANODIC FILMS	G	N/A	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5718</b>	LOW HYDROGEN EMBRITTLEMENT CADMIUM PLATING	J	QPL REV A 6-027, 6-028	7-Aug-18	<b>P</b>	<b>*</b>
<b>BAC5719</b>	CHEMICAL CONVERSION COATINGS FOR ALUMINUM AND ALUMINUM ALLOYS	AA	6-082, 6-096, 6-111, 6-131, 6-136, 6-137, 6-138, 6-142, 6-143, 6-144, 6-145, 6-147, 6-148, 6-149, 6-150, 6-152, 6-153, 6-154, 6-155, 6-156, 6-157	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5720</b>	PROTECTION OF THE INTERIOR OF STRUCTURAL TUBING	D	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5722</b>	COPPER PLATING	E	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5725</b>	STRIPPING ORGANIC MATERIALS	H	N/A	11-Jan-19	-	<input type="checkbox"/>
<b>BAC5730</b>	SHOT PEENING	T	6-111	13-Jun-19	-	<b>*</b>
<b>BAC5736</b>	APPLICATION OF CHEMICAL AND SOLVENT RESISTANT FINISHES	Y	6-196, 6-198, 6-199, 6-201, 6-206, 6-208, 6-209	19-Apr-19	<b>P</b>	<input type="checkbox"/>
<b>BAC5748</b>	ABRASIVE CLEANING, DEBURRING, AND FINISHING	U	6-108, 6-109, 6-110, 6-112	8-Mar-19	<b>P</b>	<input type="checkbox"/>
<b>BAC5749</b>	ALKALINE CLEANING	W	6-079, 6-091, 6-102, 6-111, 6-118, 6-119, 6-129, 6-133, 6-146, 6-152, 6-157, 6-158, 6-161, 6-163, 6-164, 6-165, 6-166, 6-167, 6-168, 6-169, 6-170, 6-172, 6-173, 6-174, 6-175, 6-176, 6-177	1-Nov-18	-	<input type="checkbox"/>
<b>BAC5750</b>	SOLVENT CLEANING	R	6-064, 6-106, 6-109, 6-110, 6-111, 6-113, 6-115, 6-117	8-May-19	-	<b>*</b>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5751</b>	CLEANING, DESCALING AND SURFACE PREPARATION OF FERROUS ALLOYS	M	6-069	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5765</b>	CLEANING AND DEOXIDIZING ALUMINUM ALLOYS	Y	6-197, 6-205, 6-207, 6-217, 6-218, 6-223, 6-224, 6-227, 6-229, 6-235, 6-236, 6-238, 6-239, 6-240	14-Jun-19	-	<b>*</b>
<b>BAC5771</b>	STRIPPING INORGANIC FINISHES	J	6-080, 6-081, 6-082	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5786</b>	ETCH CLEANING OF ALUMINUM ALLOYS	N	6-061, 6-064, 6-068	22-Jan-19	-	<input type="checkbox"/>
<b>BAC5804</b>	LOW HYDROGEN EMBRITTLEMENT	AD	QPL REV - 6-100, 6-102, 6-103, 6-105, 6-106, 6-109, 6-110	15-Mar-19	<b>P</b>	<input type="checkbox"/>
<b>BAC5807</b>	APPLICATION OF HIGH TEMPERATURE EPOXY PRIMER	P	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5810</b>	PHOSPHATING	M	6-022, 6-023	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5811</b>	APPLICATION OF BONDED SOLID FILM LUBRICANTS	U	QPL REV AE, 6-027, 6-034, 6-036, 6-037, 6-038, 6-039, 6-040, 6-041	15-Jan-19	<b>P</b>	<input type="checkbox"/>
<b>BAC5845</b>	APPLICATION OF POLYURETHANE TOPCOAT	T	6-064, 6-073, 6-074, 6-075, 6-076	26-Jan-19	-	<input type="checkbox"/>
<b>BAC5854</b>	LOW HYDROGEN EMBRITTLEMENT STYLUS CADMIUM PLATING	L	6-009, 6-010, 6-011, 6-012	7-Aug-18	-	<input type="checkbox"/>
<b>BAC5868</b>	APPLICATION OF REFERENCE INFORMATION, PART NUMBERS, AND SERIAL NUMBERS ON PRINTED-CIRCUIT BOARDS	P	6-025	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5875</b>	FABRICATION OF ALUMINUM MARKERS AND ALUMINUM AND PLASTIC APPLIQUES	T	N/A	22-Nov-18	-	<input type="checkbox"/>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BAC5928</b>	THERMAL CUTTING OF METALS	K	6-009	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5951</b>	GLASS BEAD PEENING	E	N/A	13-Jun-19	<b>P</b>	<b>*</b>
<b>BAC5969</b>	ELECTRICAL DISCHARGE MACHINING	E	6-005	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BAC5982</b>	LASER CUTTING OF METAL	C	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BACD2074</b>	FASTENER CODES AND SYMBOLS- DESIGN DETAIL	BD	N/A	19-Jun-19	-	<b>*</b>
<b>BACD2079</b>	HELICAL COIL INSERT HOLE DETAIL	C	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BACD2097</b>	SURFACE TEXTURE (U.S. CUSTOMARY AND METRIC)	AA	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BMS5-45</b>	FUEL TANK SEALANT	K	QPL	7-Aug-18	-	<input type="checkbox"/>
<b>BMS10-11</b>	CHEMICAL AND SOLVENT RESISTANT FINISH	AC	QPL REV ORG	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BMS7-122</b>	CONSUMABLE ELECTRODE VACUUM ARC REMELTED 4330 MODIFIED ( AMS 6411 ) STEEL	D	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BMS7-26</b>	STEEL BAR, FORGING STOCK, FORGINGS, AND TUBING - 4340 MODIFIED	R	QPL REV ORG	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>BSS7039</b>	LIQUID PENETRANT INSPECTION	C	6-004, 6-006, 6-009, 6-010	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7040</b>	MAGNETIC PARTICLE INSPECTION	C	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7084</b>	PRE-APPROVED STATISTICAL SAMPLING PLANS	A	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7217</b>	AIR CLEANLINESS, SHOP COMPRESSED AIR	C	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7219</b>	INTERGRANULAR ATTACK, TEST METHOD	E	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7321</b>	HYDROGEN DETECTION INSTRUMENT TEST METHOD	G	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7600</b>	EMPLOYEE CERTIFICATION, GENERAL REQUIREMENTS	W	6-013, 6-014	7-Aug-18	-	<input type="checkbox"/>

Process Spec No.	Title	Rev	PSD	Date of most recent update	P	*
<b>BSS7621</b>	HYDROGEN DETECTION INSTRUMENT OPERATOR, PERSONNEL CERTIFICATION FOR	F	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7636</b>	ETCH INSPECTION OF GROUND OR MACHINED STEEL PARTS, EMPLOYEE CERTIFICATION FOR	H	N/A	7-Aug-18	-	<input type="checkbox"/>
<b>BSS7666</b>	VISION REQUIREMENTS, EMPLOYEE CERTIFICATION FOR	H	N/A	12-Jan-19	-	<input type="checkbox"/>
<b>BSS7698</b>	NONDESTRUCTIVE INSPECTION, EMPLOYEE CERTIFICATION FOR	K	N/A	28-Nov-18	-	<input type="checkbox"/>
<b>D2-5000</b>	PROTECTIVE FINISH CODES	CH	N/A	7-Aug-18	<b>P</b>	<input type="checkbox"/>
<b>D6-5000</b>	SPECIAL COMMERCIAL AIRPLANE COMPANY FINISH CODES	BL	N/A	27-Oct-18	<b>P</b>	<input type="checkbox"/>

**APPENDIX 1 – EXAMPLE OF PROCESS SPECIFICATION DEPARTURE**

**Boeing Proprietary**  
Basic Control

\*\*\*\*\* PSDS GENERATED \*\*\*\*\*

<b>PROCESS SPECIFICATION DEPARTURE</b> Implementation of this departure is: <input type="checkbox"/> OPTIONAL - May be implemented at discretion of affected organization. <input checked="" type="checkbox"/> MANDATORY - Must be implemented as noted below.	Originator: F. Stavehaug Supervisor: A. L. Wingert Manufacturer: A. B. Cooper Quality: A. B. Cooper Material: A. B. Cooper Engineering: Q. Nguyen	PSD NUMBER <b>6-52</b> Page 1 of 1	PROCESS SPEC NO. <b>BAC5619</b>
	PROCESS SPEC TITLE <b>HEAT TREATMENT OF CORROSION RESISTANT STEEL</b>		
REASON: Revise quenching requirements for AISI 321 and AISI 347 stainless steel.		RELEASE DATE <b>23-APR-2010</b>	
SUBCONTRACTOR(S) AFFECTED ALL	ON MODELS ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	MFG DEPTS OF DIV BELOW AFFECTED ALL BCA AND SUPPORTING	
<p style="text-align: center;">This PSD must be implemented by 23-JUL-2010.</p> <p><b>8 MANUFACTURING CONTROL</b></p> <p>8.2 <u>HEAT TREATMENT OF AUSTENITIC ALLOYS (AISI 300 SERIES)</u></p> <p>8.2.2 PROCESS REQUIREMENTS</p> <p>8.2.2.3 <u>Quenching Requirements</u></p> <p>Revise to read as follows:</p> <ul style="list-style-type: none"> <li>a. With the exception of AISI 321 and AISI 347, all product forms of AISI 300 - series alloys listed in Table II require water quench. Sheet material up to 0.064 inch thick may optionally be air cooled.</li> <li>b. All AISI 321 or AISI 347 product forms or parts shall be air cooled, forced gas cooled, or water quenched for sections up to 0.250 inch thick. Sections greater than 0.250 inch thick shall be water quenched.</li> </ul>			

**APPENDIX 2 – EXAMPLE OF NOTIFICATION**

Example of Notification -

Notification date

BOEING PROPRIETARY EXPORT CONTROLLED - See Cover Page

\*\*\*\*\* PSDS GENERATED \*\*\*\*\*

<b>PROCESS SPECIFICATION DEPARTURE</b> Implementation of this departure is: <input checked="" type="checkbox"/> OPTIONAL - May be implemented at discretion of affected organization. <input type="checkbox"/> MANDATORY - Must be implemented as noted below.	Originator: N. G. Gonzalez-Pereyra Supervisor: J. H. Chakrabarty Engineering: J. W. Chan	PSD NUMBER <b>6-75</b> Page 1 of 2	PROCESS SPEC NO. <b>BAC5034-4</b>
	PROCESS SPEC TITLE <b>TEMPORARY PROTECTION OF PRODUCTION MATERIALS, PARTS, AND ASSEMBLIES WITH PRESSURE-SENSITIVE TAPE</b>		
REASON: Allow the use of tape Nitto Denko NO-223S for the protection of surfaces during Storage and Transportation.	RELEASE DATE <b>09-NOV-2018</b>		
SUBCONTRACTOR(S) AFFECTED ALL	ON MODELS ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	MFG DEPTS OF DIV BELOW AFFECTED ALL BCA AND SUPPORTING	

Release date