



INVOICE

Invoice: 437367
Date: 6/5/2020ELITE METAL FINISHING LLC
501 SPECTRUM CIRCLE
OXNARD CALIFORNIA 93030

Page: 1

Phone: 805-983-4320

Sold To:

DRT AEROSPACE, LLC
500 MILE CROSSING BLVD.
ROCHESTER NY 14624 USA

Fax: 805-983-3830

Ship To:

DRT AEROSPACE, LLC
500 MILE CROSSING BLVD.
ROCHESTER NY 14624 USA

Phone: (585) 247-5940

Fax: (585) 247-5949

PO Number: 800-1899

Terms: NET 30

Packing Slip: 36919

Ordered: 5/13/2020

Ship Via: UPS GROUND

Ship Date: 6/5/2020

Legal Number: 437367

Line Part Number/Description	Revision	Quantity	Unit Price	Ext Price
1 00705025-001 M1D TVCA HOUSING	A	2.00EA	0.00/1	0.00

PO Line: 1

Miscellaneous Charges:

Description	Amount
10.) LOT CHARGE	425.00
11.) POLLUTION CHARGE	38.25

Line(s) Subtotal: 0.00

SURCHARGE: 463.25

Total Tax: 0.00

Total 463.25

All pricing discrepancies must be reported within 7 days of receiving invoice. Failure to pay per agreed upon terms will result in COD terms.



Certification

ELITE METAL FINISHING LLC
540 SPECTRUM CIRCLE
OXNARD, CALIFORNIA 93030

DATE: 5/13/2020
PAGE: 1 of 1

PHONE: 805-983-4320

www.elitemetalfinishing.com

FAX: 805-983-3830

SHIP TO: DRT AEROSPACE, LLC
500 MILE CROSSING BLVD.
ROCHESTER, NY 14624

SOLD TO: DRT AEROSPACE, LLC
500 MILE CROSSING BLVD.
ROCHESTER, NY 14624

PHONE: (585) 247-5940
FAX: (585) 247-5949

PHONE: (585) 247-5940
FAX: (585) 247-5949

SALES ORDER: 236364		YOUR PO: 800-1899		ORDER QTY	SHIPPED QTY
LINE	PART	REV	DESCRIPTION		
1	00705025-001	A	M1D TVCA HOUSING, WO: 204196	2	2

PROCESS	SPECIFICATION
MASK	PER BLUEPRINT
ANODIZE - TITANIUM PTFE	AMS 2488 REV. E, TYPE 2 ~ PTFE IMPREGNATE
PACKING	PACK UPS/FEDEX

SERIAL NUMBERS: DRTLАН-000602 & DRTLАН-000603

** Our liability per part is limited to a maximum of 3 times the processing charge per part. Not responsible for damages or shortages not reported within a 24 hour period after receipt of material. We assume no responsibility for losses of any kind due to our interpretation of the quality of the material submitted.

** Past-due balances will be charged 1 1/2% interest per month. Where legal action becomes necessary, purchaser will pay the costs of such legal action for attorney fees and court costs in addition to the principal and interest of the purchased services.

WTI \$425.00
+ 7-

ITAR/EAR CONTROLLED

WE HEREBY CERTIFY THAT THE ABOVE WORK WAS DONE IN ACCORDANCE WITH THE SPECIFICATIONS AS INDICATED ABOVE.

SHOP COPY

QUALITY DESIGNEE:

DATE: JUN 05 2020



Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1 Material: 6AL-4V
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	CE

Process:	Specification:
MASK	PER BLUEPRINT
ANODIZE - TITANIUM PTFE	AMS 2488 REV. E, TYPE 2 ~ PTFE IMPREGNATE
PACKING	PACK UPS/FEDEX

SALES ORDER: 236364

LINE	PART	REV	DESCRIPTION	ORDER QTY
1	00705025-001	A	M1D TVCA HOUSING, WO: 204196	2

MASKING? YES

BLUEPRINTS? YES

FIRST ARTICLE? NO

Schedule Dates
Req. By: 6/12/2020

**HANDLE
WITH CARE**

PLANNER	INSPECTOR

SERIAL NUMBERS: DRTLAN-000602 & DRTLAN-000603

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
5	INSPR	RECEIVING INSPECTION	2.00


H.O.D.

STAMP	DATE
	MAY 13 2020

PARTS ARE ENGRAVED WITH PN, REV AND S/N

RECEIVING INSPECTION ref. EMF-845

QTY INSP: QTY REJ: QTY ACC:

***** ALL REJECTION MUST BE REPORTED TO Q.A. DEPARTMENT *****
SPACEX
 SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA	
Customer's PO: 800-1899	Date Rec: 5/12/2020	
Container Type: BOX	# of Containers: 1	Material: 6AL-4V
Part: 00705025-001	Rev: A	
Description: M1D TVCA HOUSING, WO: 204196		

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
10	RACK	RACKING	2.00



STAMP	DATE
	5/14/20

!!PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES AT ALL TIMES!!

GENERIC RACKING [ref. TP-04] ALL INK MARKINGS, CUTTING FLUIDS AND GROSS CONTAMINATION SHALL BE REMOVED WITH ACETONE.

 PARTS PER RACK: 41 #OF RACKS: 2 TOTAL PARTS: 2 TIME: 5m¹/n TAR/EAR CONTROLLED
 TYPE OF RACK USED: WALK-IN NUMBER OF BOXES: 2 LOCATION: (-)

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
20	CL	CLEAN - TITANIUM	2.00



STAMP	DATE
	5/14/20

ELECTRO-CLEANER, NO CURRENT

* OAKITE 90 / TANK# 62* TEMP. RANGE=165-185°F

IMMERSION TIME: 13m SOLUTION TEMP: 185°

HANDLE
WITH CARE

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
30	RACK	UN-RACKING	2.00



STAMP	DATE
	5/15/20

UN-RACK PARTS [ref. TP-04] QUANTITY: 2 TIME SPENT: 4min

!!!REPORT ALL SHORTAGES TO MANAGEMENT!!!

SPACEX
SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty:	2 EA
Customer's PO: 800-1899	Date Rec:	5/12/2020
Container Type: BOX	# of Containers:	1
Part: 00705025-001	Material:	6AL-4V
Description: M1D TVCA HOUSING, WO: 204196	Rev:	A

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
40	INSPC	FINAL INSPECTION CHEM PROCESS	2.00



!!PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES
AT ALL TIMES VISUAL INSPECTION - CLEAN/DEGREASE

STAMP	DATE
	5/15/20

**** INSPECTOR SHALL ENSURE THAT PARTS HAVE BEEN COMPLETELY
CLEANED / DE-GREASED AS REQUIRED ****

#INSPECT: 3 #ACCEPT: 2 #REJECT: 1

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
50	MASK	MASKING - PLANNING	2.00



MASKING INSPECTION TO PAY EXTRA FOCUS TO COUNTERSINKS ON 2 PORTS.

MANAGEMENT SUPERVISION REF. "SPECIAL PROCESS"
PROCESSING THE PARTS ON THIS ORDER REQUIRES MANGEMENT SUPERVISION.
PROCESS PLANNERS SHALL LIST THE CRITICAL DETAILS WHICH ARE TO BE
MONITORED DURING PROCESSING.

NOTE: MANAGEMENT SHALL TAKE COMPLETE RESPONSIBILITY FOR ADHERING TO THE CRITERIA LISTED ABOVE

MANAGER: DATE: 5-21-20

MASKING-PLANNING [ref. EMF-821] INSTRUCTIONS: MASK PER PRINT NOTES 10
AND 11, SEE JOEL TIME:

CUSTOMER APPROVAL REQ? [YES/NO] IF YES, CONTACT INFO: _____ 10:35 AM

**HANDLE
WITH CARE**

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
60	MASK	MASKING - FIRST ARTICLE	2.00



MASKING - FIRST ARTICLE [ref. EMF-821]

FIRST ARTICLE INSPECTION: 19 DATE: 5/22/00 TIME: 6:15 AM

STAMP	DATE
	5-18-20

SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1
	Material: 6AL-4V
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
70	MASK	MASK	2.00



STAMP	DATE
P52	5-18-20

CLEAN FOR MASK-ACETONE WIPE [ref. EMF-821] ** ACETONE CLEAN ALL AREAS TO BE MASKED. ENSURE ALL OILS, DIRT, GREASE AND FILMS ARE COMPLETELY REMOVED**

MATERIALS USED: *Amu* TOTAL PARTS: 2 TIME SPENT: 3 min

OPER: *32* MASKING OPERATIONS [ref. EMF-821] TIME SPENT: 40 min

MINIMUM OF 24 HOUR CURE REQUIRED

IF LACQUER IS USED RECORD TIME LAST PART WAS COMPLETED: 1.00 pm

ITAR/EAR CONTROLLED

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
80	INSPM	FINAL INSPECTION MASKING	2.00



STAMP	DATE
ACCEPT	5/22/20

✓ RED LACQUER USED ON JOB [YES OR NOT REQ]
 NOTE: LAST PART MASKED IS START TIME OF CURE

IF YES REC. START TIME OF RED LACQUER CURE:

END TIME OF RED LACQUER CURE:

MINIMUM OF 24 HOUR CURE REQUIRED

MASKING INSPECTION

- CHECK FOR STAMPS ON PREVIOUS PROCESSES
- CHECK REVISION, PO, PRINT AND JOB HISTORY
- INSPECT TO PHOTO, FIRST ARTICLE AND BLUEPRINT
- CUSTOMER APPROVAL SENT: YES - NOT REQUIRED
- DIMENSIONAL CHECK: YES - NOT REQUIRED
- TRACEABILITY; PARTS TAGGED?: YES - NOT REQUIRED
- VERIFY QUANTITY: 2
- COUPONS WITH THE JOB? QTY: N/A

HANDLE
WITH CARE

SPACEX
SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1
	Material: 6AL-4V
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
90	BC	BLAST	2.00



STAMP	DATE
PP82	06/01/2020

MANAGER SUPERVISION REQUIRED AT PRE-BLAST TO ENSURE LARGE ID PLUG IS USED PRIOR TO BLASTING

MANAGEMENT SUPERVISION REF. "SPECIAL PROCESS"
 PROCESSING THE PARTS ON THIS ORDER REQUIRES MANAGEMENT SUPERVISION.
 PROCESS PLANNERS SHALL LIST THE CRITICAL DETAILS WHICH ARE TO BE MONITORED DURING PROCESSING.

NOTE: MANAGEMENT SHALL TAKE COMPLETE RESPONSIBILITY FOR ADHERING TO THE CRITERIA LISTED ABOVE

MANAGER: _____ DATE: 06-01-20

PARTS MUST BE ANODIZED WITHIN 24 HOURS OF BLASTING PROCESS TO PREVENT OXIDE LAYER FROM FORMING!!!

USE OF BASKETS IS PROHIBITED!!!
 AL-OXIDE 180-200, WIDE, 20-30 PSI, <60 DEGREES

ABRASIVE BLASTING [ref. EMF-837 / FC-15]

BLAST GROUP: ^BLAST CLEAN^ ^STRIP COATING^ ^SURFACE EFFECT^ ^OTHER:

****BLAST MATERIAL**** AL OXIDE: 320-400 / 240-280 / 180-220 / 60-120
 OTHER: _____

GLASS: 120-270 (AG) 100-170 (AE) 70-140 (AD) 60-120 (AC) 50-70 (D)

PLASTIC: NEW MEDIA USED MEDIA OTHER: TYPE = SIZE =

DISTANCE:CLOSE (1-2") MEDIUM (3-6") WIDE (OVER 6") PRESSURE: 20-30 PSI

NOZZLE ANGLE: <60° 60-90° >90° TIME STARTED 1:00 PM

****ALL GRIT MUST BE REMOVED FROM PARTS WITH COMPLETED COMPRESSED AIR AFTER BLASTING IS COMPLETE**** TIME 1:43 PM

HANDLE WITH CARE

SPACEX
 SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC

Job Qty: 2 EA

Customer's PO: 800-1899

Date Rec: 5/12/2020

Container Type: BOX

of Containers: 1

Material: 6AL-4V

CE

Part: 00705025-001

Rev: A

Description: M1D TVCA HOUSING, WO: 204196

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
100	INSPC	FINAL INSPECTION CHEM PROCESS	2.00



PARTS MUST BE KEPT IN CUSTOMER PROVIDED CONTAINERS AT ALL TIMES

VISUAL INSPECTION 100% INSPECTION REQUIRED

BLASTING MUST BE PERFORMED AS REQUIRED. INSPECTOR MUST ASSURE THAT ALL PARTS HAVE A UNIFORM SURFACE FINISH AND RESIDUAL BLAST MATERIAL HAS BEEN REMOVED.

QTY INSPECT: 2 QTY ACCEPT: 2 QTY REJECT: 0

STAMP	DATE
6/12/20	6/12/20

ITAR/EAR CONTROLLED

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
105	MASK	MASKING	2.00



REMOVE MASKING FROM ID

REMOVE MASKING

DO NOT USE METAL OR SHARP TOOLS TO REMOVE MASKING MATERIAL; IF TOOLS PROVIDED ARE NOT SUFFICIENT PLEASE NOTIFY MANAGEMENT TIME SPENT: 10m

AFTER MASKING IS REMOVED INSPECTOR SHALL VERIFY PRODUCT QUALITY ENSURING ALL MASKING WAS REMOVED, MASKING DID NOT FAIL AND THAT THE PROCESS OF UNMASKING DID NOT CAUSE QUALITY ISSUES. AT MINIMUM SAMPLE INSPECT IAW MIL-STD-105 LEVEL II NORMAL INSPECTOR: DATE: 6/12/20 TIME SPENT:

QTY INSPECT: 7 QTY ACCEPT: 2 QTY REJECT: 0

STAMP	DATE
6/12/20	6/12/20

HANDLE
WITH CARE

SPACEX
SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1
Material: 6AL-4V	CE
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
110	RACK	RACKING	2.00


SEE JOEL FOR RACKING AND PROCESSING INSTRUCTIONS

MANAGEMENT SUPERVISION REF. "SPECIAL PROCESS"
 PROCESSING THE PARTS ON THIS ORDER REQUIRES MANAGEMENT SUPERVISION.
 PROCESS PLANNERS SHALL LIST THE CRITICAL DETAILS WHICH ARE TO BE
 MONITORED DURING PROCESSING.

**NOTE: MANAGEMENT SHALL TAKE COMPLETE RESPONSIBILITY FOR ADHERING TO
 THE CRITERIA LISTED ABOVE**

MANAGER: _____ **DATE:** 6/1/20

NO RACK MARKS ALLOWED

PARTS MUST BE ANODIZED WITHIN 24 HOURS OF BLASTING PROCESS TO PREVENT
 OXIDE
 LAYER FROM FORMING!!! NO ACID ETCH UNLESS APPROVED BY CUSTOMER

PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES AT ALL TIMES!

****GENERIC RACKING**** RACK PARTS ref. TP-04 ALL INK MARKINGS, CUTTING
 FLUIDS
 AND GROSS CONTAMINATION SHALL BE REMOVED WITH ACETONE.

PARTS PER RACK 1 #OF RACKS 2 TOTAL PARTS 1 TIME _____

TYPE OF RACK USED C-1 SPACEX NUMBER OF BOXES 2 LOCATION SpaceX

STAMP	DATE
	<u>6/1/20</u>

ITAR/EAR CONTROLLED
**HANDLE
WITH CARE**


SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA	
Customer's PO: 800-1899	Date Rec: 5/12/2020	
Container Type: BOX	# of Containers: 1	Material: 6AL-4V
Part: 00705025-001	Rev: A	
Description: M1D TVCA HOUSING, WO: 204196		

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
120	AT	ANODIZE - TITANIUM PTFE	2.00



ELECTRO-CLEANER, NO CURRENT

 ** OAKITE 90 / TANK# 62** TEMP. RANGE=165-185F SOLUTION TEMP 185'

 IMMERSION TIME: 5 MINUTES MIN. TIME IN TANK 5m'

INSPECT FOR WATER-BREAK PER EMF-817 (PASS OR FAIL)

STAMP	DATE
	6/12/20

ITAR/EAR CONTROLLED

PROCESS AT 24 VOLTS TITANIUM ANODIZE [ref. FC-28 / AMS 2488]

TITANIUM ANODIZE / TANK#55 TEMP. RANGE=57-63F

 STARTING VOLTAGE 10 END VOLTAGE 24 VOLTS PER MINUTE .5

 TIME AT END VOLTAGE 30mI # OF LOADS 1

STAMP	DATE
	6/12/20

HANDLE WITH CARE
OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
130	RACK	UN-RACKING	2.00


 UN-RACK PARTS [ref. TP-04] QUANTITY 2 TIME SPENT 5m
 !!!REPORT ALL SHORTAGES TO MANAGEMENT!!!

STAMP	DATE
	6/12/20

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
140	INSPC	FINAL INSPECTION CHEM PROCESS	2.00



PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES AT ALL TIMES!

THE COATING SHALL BE CONTINUOUS, SMOOTH,ADHERENT, UNIFORM IN APPEARANCE, FREE FROM POWDERY AREAS, LOOSE FILMS, BREAKS, SCRATCHES AND OTHER DEFECTS.

VISUAL INSPECTION - AS NOTED ABOVE

 QTY INSPECT 2 QTY ACCEPT 2 QTY REJECT 0

STAMP	DATE
	6-2-20

100%

SPACEX
 SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1
Material: 6AL-4V	CE
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
150	BC	BLAST	2.00



STAMP	DATE
6/16/20	6-2-20

AG, 20 PSI, WIDE, 60-90 DEGREES USE OF BASKETS IS PROHIBITED!!!

ABRASIVE BLASTING [ref. EMF-837 / FC-15]

BLAST GROUP: ^BLAST CLEAN^ ^STRIP COATING^ ^SURFACE EFFECT^ ^OTHER:

BLAST MATERIAL

AL OXIDE: 320-400 240-280 180-220 60-120 OTHER:

GLASS: 120-270 (AG) 100-170 (AE) 70-140 (AD) 60-120 (AC) 50-70 (D)

PLASTIC: NEW MEDIA USED MEDIA OTHER: TYPE = SIZE =

 DISTANCE:CLOSE(1-2") MEDIUM(3-6") WIDE(OVER 6") PRESSURE 20 PSI

NOZZLE ANGLE: <60° 60-90° >90° TIME STARTED: 12:20 PM

ALL GRIT MUST BE REMOVED FROM PARTS WITH COMPRESSED AIR AFTER BLASTING IS COMPLETE

ITAR/EAR CONTROLLED

**HANDLE
WITH CARE**
OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
160	INSPC	FINAL INSPECTION CHEM PROCESS	2.00



STAMP	DATE
A	6-2-20

PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES AT ALL TIMES!

THE COATING SHALL BE CONTINUOUS, SMOOTH, ADHERENT, UNIFORM IN APPEARANCE, FREE FROM POWDERY AREAS, LOOSE FILMS, BREAKS, SCRATCHES AND OTHER DEFECTS. VISUAL INSPECTION - AS NOTED ABOVE

 QTY INSPECT: 2 QTY ACCEPT: 2 QTY REJECT: 0
SPACEX
 SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA	
Customer's PO: 800-1899	Date Rec: 5/12/2020	
Container Type: BOX	# of Containers: 1	Material: 6AL-4V
Part: 00705025-001	Rev: A	
Description: M1D TVCA HOUSING, WO: 204196	CE	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
165	PACK	UNMASK	2.00



REMOVE MASKING

STAMP	DATE
	6/2/20

DO NOT USE METAL OR SHARP TOOLS TO REMOVE MASKING MATERIAL;
 IF TOOLS PROVIDED ARE NOT SUFFICIENT PLEASE NOTIFY MANAGEMENT
 TIME SPENT :

AFTER MASKING IS REMOVED INSPECTOR SHALL VERIFY PRODUCT QUALITY
 ENSURING ALL MASKING WAS REMOVED, MASKING DID NOT FAIL AND THAT
 THE PROCESS OF UNMASKING DID NOT CAUSE QUALITY ISSUES.

AT MINIMUM SAMPLE INSPECT IAW MIL-STD-105 LEVEL II NORMAL
 INSPECTOR: DATE: 05.20 TIME SPENT:

QTY INSPECT: 2 QTY ACCEPT: 2 QTY REJECT: 0


OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
167	CL	CLEAN	2.00



PARTS MUST BE KEPT IN CUSTOMER PROVIDED CONTAINERS AT ALL TIMES

BURNISH - HAND OPERATION

SURFACE FINISH ON THE 3.119 Ø BORE MUST MEASURE AT 12RA FINISH AFTER
 PLATING.

POLISH ID

* Q-TIP * TEX-WIPE * SCOTCH-BRITE * SAND PAPER * POLISH WHEEL *

SURFACE FINISH REQUIREMENT: 12 Ra

BURNISH MATERIAL: Molten Polishing

TIME SPENT: 5 hr

STAMP	DATE
	6/15/20

**HANDLE
WITH CARE**

SPACEX
SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA
Customer's PO: 800-1899	Date Rec: 5/12/2020
Container Type: BOX	# of Containers: 1
Material: 6AL-4V	CE
Part: 00705025-001	Rev: A
Description: M1D TVCA HOUSING, WO: 204196	

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
170	RACK	RACKING	2.00



STAMP	DATE
(LL)	6/5/20

** GENERIC RACKING ** RACK PARTS [ref. TP-04] ALL INK MARKINGS, CUTTING FLUIDS AND GROSS CONTAMINATION SHALL BE REMOVED WITH ACETONE.

PARTS PER RACK: 1 # OF RACKS: 2 TOTAL PARTS: 2 TIME: 5m

TYPE OF RACK USED: hook NUMBER OF BOXES: 2 LOCATION:

ITAR/EAR CONTROLLED

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
180	PTFE	PTFE ANODIZE	2.00



STAMP	DATE
(LL)	6/5/20

TEFLON / PTFE SEALER [ref. EMF-848]
-RO 59 / TM4 TANK# 16-OR- ANODAL EE / TANK# 24 -

TIME IN TANK: 3min # OF LOADS: 1

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
190	RACK	UN-RACKING	2.00



HANDLE
WITH CARE

UN-RACK PARTS [ref. TP-04] QUANTITY: 2 TIME SPENT: 1min
!!!REPORT ALL SHORTAGES TO MANAGEMENT!!!

STAMP	DATE
(LL)	6/5/20

SPACEX
SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA		
Customer's PO: 800-1899	Date Rec: 5/12/2020		
Container Type: BOX	# of Containers: 1	Material: 6AL-4V	CE
Part: 00705025-001	Rev: A		
Description: M1D TVCA HOUSING, WO: 204196			

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty
200	INSPP	FINAL INSPECTION PAINT	2.00



NO RESIDUAL MASKING BLEED OUT IS ALLOWED ON THESE LOCATIONS. SEE QA MANAGEMENT FOR ANY QUESTIONS DURING FINAL INSPECTION. (THIS NOTE AT FINAL INSPECTION)

PARTS SHALL BE HANDLED WITH WHITE COTTON GLOVES AT ALL TIMES!

THE COATING SHALL BE CONTINUOUS, SMOOTH,ADHERENT, UNIFORM IN APPEARANCE, FREE FROM POWDERY AREAS, LOOSE FILMS, BREAKS, SCRATCHES AND OTHER DEFECTS.VISUAL INSPECTION 100% OF PARTS [ref. EMF-852, PARA. 6.0]

QTY INSPECT: 2

QTY ACCEPT: 2

QTY REJECT: 0

STAMP	DATE
✓ ACCEPT	105-20

ITAR/EAR CONTROLLED
**HANDLE
WITH CARE**


SpaceX Critical Hardware

Job: 236364-1-1

SPACEX

Customer: DRT AEROSPACE, LLC	Job Qty: 2 EA		
Customer's PO: 800-1899	Date Rec: 5/12/2020		
Container Type: BOX	# of Containers: 1	Material: 6AL-4V	CE
Part: 00705025-001	Rev: A		
Description: M1D TVCA HOUSING, WO: 204196			

OPERATIONS

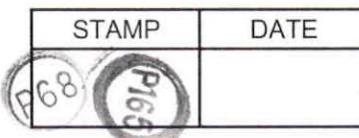
Seq No.	Oper.	Description	Oper. Qty
210	PACK	PACKING	2.00


SPACE-X & VENDORS - FINAL VISUAL REVIEW

A MANAGER or DESIGNATED INSPECTOR SHALL REVIEW PARTS AT FINAL INSPECTION, PRIOR TO PACKAGING TO ENSURE THAT THERE ARE NO SCRATCHES, DINGS or UN-ACCEPTABLE FINISHES ON PARTS.

ANY PARTS THAT ARE FOUND TO HAVE DAMAGE, MUST BE TAGGED WITH A RED "DISCREPANT MATERIAL" TAG, and THE CUSTOMER MUST BE NOTIFIED PRIOR TO SHIPMENT

INSPECTOR:

DATE:
6/5/20

ITAR/EAR CONTROLLED
PN: 00705025-001 REV.A
WO: 204196
S/N: DRTLAN-000602
**HANDLE
WITH CARE**
PN: 00705025-001 REV.A
WO: 204196
S/N: DRTLAN-000603
MATERIALS:
TIME:

BLUEPRINTS? YES NO PART DIM'S RECORDED?: YES NO

----- DO NOT SEAL BOXES UNTIL AFTER INSPECTION -----

**** PACKAGING INSPECTION ****

INSPECTOR SHALL ENSURE THAT PARTS ARE PACKAGED IN CUSTOMER'S ORIGINAL MATERIALS OR ACCEPTABLE NEW PACKAGING, AND THAT PARTS ARE PROTECTED FROM DAMAGE WHILE BEING RETURNED TO CUSTOMER

INSPECTOR:

SPACEX
 SpaceX Critical Hardware

PACKING REVIEW

1. Have all operations been completed and filled out? N N/A
2. Are all applicable certs/test reports with the order? N N/A
(Including NDT/Lap Shear)
3. Are all applicable certs/test reports signed and stamped as required? (Including NDT/Lap Shear) Y N N/A

Notes:

STAMP	DATE
P151	JUN 05 2020

ITAR/EAR CONTROLLED

**HANDLE
WITH CARE****SPACEX**
SpaceX Critical Hardware



Document No:EMF-708	Issue Date: 8/26/14	Approved By: Zach Beal
Revision: D	Rev. Date: 8/10/16	Quality Director: Joel Clemons

COMMUNICATION PASS DOWN SHEET

Pass-down sheet to be used by inspection personnel when verbal pass-downs are not possible such as second shift to first shift or weekend work.

List all information explaining hold for quality review.

P.O./VS: 800-1899/236364 Customer: DR7

Inspector: Antonio Date: 6/4/20 Time: 1:03

Process _____

Reason For Hold:

2/2 - Bleed in missing AG

Disposition: Acceptable _____ Rework _____ Repair _____ Customer Contact _____

Who made disposition _____ Date: _____ Time _____

Internal - Instructions- (ie. Waiting for rework, reverse mask/touch up chemfilm, OK per)

Repair or rework instructions: (Operators stamp off after completion of repair or rework step)

Process	Stamp	Time Spent	Date
Scotch Brite		15min	06-05-20

External

Customer notification required: Yes _____ No _____

Who notified customer? _____ Date: _____ Time _____

Per Customer: Rework _____ Repair _____ Return _____

Instructions-





DRT Aerospace - Rochester

A division of DRT Aerospace, LLC

Date 5/8/2020
Purchase Order 800-1899

PURCHASE ORDER

Return Date 6/5/2020
Return Method UPS 54265W

230304

Supplier

ELITE METAL FINISHING
540 SPECTRUM CIRCLE
OXNARD CA 93030
805-983-4320

DRT No. 1899 *18QQ*
Work Order 204196

Return To

Rochester
500 Mile Crossing Blvd
Rochester NY 14624
585-247-5940

Part No SX-00705025-001
Part Rev A

Unit Quantity	Unit	Price Per Unit	Lot/Min Price	Expedite Addl	Total
2	EA	\$212.50	\$0.00	\$0.00	\$425.00

2

Certification Req
Per Specification

Process PLATE
Material TI 6AL-4V

Special Instructions: *Serial Numbers for this PO are:*
DRTLAN-000602 & DRTLAN-000603

PLATING PER NOTE # 2
TITANIUM ANODIZE, TYPE II PER AMS 2488 WITH PTFE
IMPREGNATION. MASK PER FLAG
10, 11.

ITAR/EAR CONTROLLED

18499

FINISH IS CRITICAL, NO DINGS, DENTS OR SCRATCHES ARE ALLOWED.

SURFACE FINISH ON THE 3.1190 BORE MUST MEASURE A 12Ra FINISH AFTER PLATING.

SURFACE FINISH IS MEASURED AND RECORDED PRIOR TO LEAVING DRT AND IS LESS THAN 8Ra.

OUTSIDE OF MASKING AREAS NO BARE BASE MATERIAL IS ALLOWED.(NO RACK MARKS)

Est. Completion Date: 6-12-20

MATERIAL: TI 6AL-4V PER AMS 4928

Verified By: MF

RETURN PARTS IN THE PELICAN CASES THAT THEY ARRIVED IN.

\$212.50 EACH (Quoted)

**PARTS MUST BE PACKAGED & HANDLED IN A MANNER NOT TO DAMAGE PARTS IN ANY WAY.

NO METAL TO METAL CONTACT IS ALLOWED. **

CERTS REQUIRED

*** PLEASE EMAIL ACKNOWLEDGMENT TO sam.goz@drtusa.com WITHIN 24 HRS ***

PARTS ARE ENGRAVED. Pln, Rev, Slv

QTY. INSP: 2 QTY. ACC: 2

RECEIVING INSPECTION Ref. ENH-845



5/12/2020 12:05pm



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PURCHASE ORDER

****MUST BE A SPACEX APPROVED VENDOR****

***** PLEASE EMAIL ACKNOWLEDGMENT TO sam.goz@drtusa.com WITHIN 24 HRS *****

Quotations are sent to AP (Purchase) at drtusa.com. Subject to the terms and conditions found at <http://www.drt aerospace.com/terms/>



(P80) Contract Reviewed By: _____ Order# 23103104 Final Review By: _____ (P56)

Contract Review Checklist

Completed checklist shall be attached with the customer Purchase Order for permanent record of the review.

Check the Customer Purchase Order and Check ALL that Apply for the following:

Boeing Order? YES Use D1-4426 Appendix D Checklist and attach to PO
NO Continue with EMF-822A Checklist below

	YES	NO	N/A
TOP 7 Steps: 7 Step Review Completed to Eliminate Potential Waste	/		
Discrepancies: If there are any discrepancies the customer shall be contacted to resolve prior to release of the order. <i>If necessary, place on PO HOLD shelf</i>	/	/	
Processing: Verify that EMF can perform and Certify to Customer Processing Requirements.	/		
Prime Contractor Specification: Verify with Quality Manager or designee to ensure EMF is approved by the Prime Contractor for the process listed on the Purchase Order or applicable drawing.	/		
Part Quantity: Verify quantity on the Purchase Order match with quantity of parts received.	/		
Part Description: Verify the part description agrees with the Customer Purchase Order.	/		
Repeat Orders: Review part history in the ERP System for previous processing information, revision and if there was a history of discrepancy reported.	/		
Drawing: Verify the Drawing Information (Notes) agrees with the Purchase Order.	/		
Revision Levels: Verify Process Specification Revision Level on Customer Purchase Order is current. <i>If not listed or states current specification applies, contact Quality Manager or designee to review and ensure most current revision level is used</i>	/		
ITAR/EAR Control: Stamp documents to identify parts are under ITAR/EAR control.	/		
Duplicated Order: Order # _____ Ensure Sold To and Ship To addresses are correct	/		
Frozen Process: When required ensure frozen shop traveler is released. Frozen Processing may appear on Purchase Order as "Controlled Priority Process" followed by applicable specification number.	/		
Process Master: Verify the appropriate process master is used in the ERP System and all required information has been included.	/		
QA-200 Process Specification Matrix: shall be used as a reference guide to ensure that specification and any special testing requirements are identified and flowed down to the Shop Traveler.	/		
Special Instructions: Verify if there are any special instructions, quality flow down requirements or History of Discrepancy (HOD) and Stamp using Special Stamps, as required i.e. Handle with Care, Maintain Traceability, Silicone Free, etc.	/		
Process Specification: Review to ensure all customer Purchase Order requirements are included on the Shop Traveler.	/		
Blueprint: Verify the "Job Card" review and mark-up has been completed in accordance with EMF-819 Blueprint Review and Mark up.			
Final Review: Planner Inspector or Designee: Review for accuracy and completeness.	P56		
New ERP System Accuracy Review: Verify the sequencing, referenced specifications, procedures and flowcharts listed are accurate.			

Ref
234889

APPROVED FOR RELEASE
DATE 2/24/20 INIT