



Doing Business with Boeing
Approved Process Sources D1-4426
 Revision: KA Effective: 1/Mar/2018

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Document D1-4426 - Processes for BE10048985

Detail Information for Processor Code number: BE10048985	
Supplier Name: HYTEK FINISHES CO	
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Province/state:	WA 98032-1996
Country:	UNITED STATES
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* An acronym in the "Nadcap Commodity" column only indicates that [Nadcap accreditation may be required](#) for this Process Code. It does not provide any indication of this company's actual Nadcap accreditation status.

Process Code	*Nadcap Commodity	Limitation Codes	Doc Notes	Nomenclature	Specification Number
002	AQS	None	.	Boeing approved QMS as defined in D1-4426 Processor Requirements Sec 6.15.2	Quality System
101	HT	H5	None	Heat Treat of Alloy Steels	BAC 5617
103J	HT	None	None	Hydrogen Embrittlement Relief (Baking) of Steel Parts	AMS 2759/9
131	HT	H5	.	Heat Treat of Corrosion Resistant Steel	BAC 5619
161	HT	H5	None	Carburizing of Steel	BAC 5641
171	HT	H5	None	Nitriding of Steel	BAC 5640
300	CP	None	.	Chromic Acid Anodizing of Alum. - Type I	MIL-A-8625
301	CP	None	.	Sulfuric Acid Anodize Type II (Approval Not Required for	MIL-A-8625

				International Space Station (ISS) Houston Only)	
302	CP	None	None	Hard Anodize Type III	MIL-A-8625
305	CP	None	.	Chromic Acid Anodizing - Class 1 and 3	BAC 5019
306	CP	None	None	Sulfuric Acid Anodizing	BAC 5022
308	CP	None	None	Hard Anodizing - Class 1 and 2	BAC 5821
312	CP	None	None	Anodizing of Magnesium (Dow 17 Process)	BAC 5734
315	CP	None	None	Boric Acid - Sulfuric Acid Anodizing Class 1	BAC 5632
317	CP	None	.	Chromic Acid Anodizing - Class 5	BAC 5019
318	CP	None	None	Boric Acid - Sulfuric Acid Anodizing Class 5	BAC 5632
320	CP	None	Class 1A & Class 3	Chemical Conversion Coating on Aluminum (Immersion App only) (Approval Not Required for International Space Station (ISS) Houston Only)	MIL-C-5541
320B	CP	None	.	Chemical Conversion Coatings on Aluminum and Aluminum Alloys (Immersion Application Only)	MIL-DTL-5541
321	CP	None	Class 1A , Class 1B & 1D	Chemical Conversion Coatings for Aluminum (Immersion Application Only)	BAC 5719
322	CP	None	None	Conversion Coating on Magnesium Type III (Dow 7)	MIL-M-3171
323	CP	None	Limited to Method I Spray and Method II Manual Application only	Application of Sol-Gel Conversion Coatings on Corrosion Resistant Alloys for Painting (Approval required for Spray, Manual and Immersion application excluding touch up due to post	BAC 5665

				application operations)	
323A	CP	None	Limited to Type I Spray and Type II Manual Application only	Sol-Gel Conversion Coatings for Aluminum Alloys (Approval required for Spray, Manual and Immersion application excluding touch up due to post application operations)	BAC 5663
323C	CP	None	Limited to Method I Spray and Method II Brush Application only	Application of Sol-Gel Coating for Titanium Painting	BSPS-07-002
323D	CP	None	.	Sol-Gel Surface Treatment for Painting Titanium Alloys	5PTPHB26
324	CP	None	None	Conversion Coating on Magnesium (Dow 7)	BAC 5609
325	CP	None	None	Colored Chem Conversion Coatings for Alum Immersion App only	BAC 5626
331	CP	None	None	Phosphate Conversion Coating on Steel	DOD-P-16232
332	CP	None	None	Phosphate Conversion Coating on Steel	BAC 5810
340	CP	None	None	Cadmium Plating Types I and II	QQ-P-416
340A	CP	None	.	Plating- Cadmium (Electrodeposited)	AMS-QQ-P-416
341	CP	None	None	Cadmium Plating Types I - II	BAC 5701
342	CP	None	None	Cadmium Plating Type III	QQ-P-416
343	CP	None	None	Cadmium Plating Type III	BAC 5701
344	CP	None	None	Low Hyd. Embrittlement Cadmium/Titanium Plating (QPL)	BAC 5804
347	CP	None	.	Brush Plating Cadmium only	BAC 5849
348	CP	None	None	Low Hydrogen Embritt. - Stylus Cadmium Plate	BAC 5854
349A	CP	None	None	Zinc-Nickel Alloy Plating	AMS 2417
350	CP	None	None	Chromium- Plating	QQ-C-320
350B	CP	None	.	Chromium Plating (Electrodeposited)	AMS-QQ-C-320

351	CP	None	Class 2 Only	Hard Chromium Plating - Class 1 and 2	BAC 5709
352	CP	None	None	Hard Chromium Plating - Class 3	BAC 5709
353	CP	None	None	Hard Chromium Plating - Class 4 (QPL)	BAC 5709
356	CP	None	None	Copper Plating	BAC 5722
361	CP	T1	Type I & Nickel Strike Only	Nickel Plating Types I and II	BAC 5746
364	CP	None	Class 1, 2, And 3	Electroless Nickel Plating	BAC 5728
366	CP	None	None	Electroless Nickel Coatings	MIL-C-26074
366B	CP	None	Revision G	Plating Electroless Nickel	AMS 2404
366C	CP	None	.	Coatings- Electroless Nickel Requirements for	AMS-C-26074
368	CP	T1	None	Tin Plating Types I and II	BAC 5717
377	CP	None	None	Electroplating of Aluminum	BAC 5714
383	CP	None	None	Phosphate Fluoride Coatings - Titanium	BAC 5861
391	CP	None	None	Dry Film Lubricant - Type VIII Only (QPL)	BAC 5811
392	CP	None	.	Application Corrosion Resistant Finish for Integral Fuel Tanks - manual touch-up excluded for requiring approval	BAC 5793
400	NDT	None	None	Magnetic Particle Inspection	BAC 5424
400A	NDT	None	None	Magnetic Particle Inspection	BSS 7040
402	NDT	None	None	Magnetic Particle Inspection	ASTM-E-1444
403	NDT	None	None	Magnetic Particle Inspection	MIL-STD-1949
404	NDT	None	None	Magnetic Particle Inspection	MIL-I-6868
410	NDT	None	None	Penetrant Inspection	BAC 5423
410A	NDT	None	None	Liquid Penetrant Inspection	BSS 7039
411	NDT	None	None	Penetrant Inspection	ASTM-E-1417
412	NDT	None	None	Penetrant Inspection	MIL-STD-6866
413	NDT	None	None	Penetrant Inspection	MIL-I-6866
441	CP	None	None	Etch Inspection of Ground or	BAC 5436

				Machined Steel Parts	
500	SE	None	None	Shot Peening	BAC 5730
503	SE	None	None	Shot Peening	MIL-S-13165
505	SE	None	None	Glass Bead Peening	BAC 5951
510	CP	None	None	Cleaning - Descaling of Titanium - Method II Only	BAC 5753
531	CP	P6	None	Chemical Milling of Steel- Nickel - Cobalt	BAC 5759
802	MTL	None	Hardness Inspection Only	Mechanical Testing - Metallic	Mech. Testing
803	MTL	A10 A3 A7	EGA/EGP as outlined in BAC5759 PSD6-16	Metallurgical Testing	Met. Testing
809	CP	A3	None	Process Solution Control	Chem. Testing
810	CP	None	None	Salt Spray Testing	ASTM-B-117
848	No Nadcap Commodity Code	A3	.	NDI Personnel Certification Level 3 Magnetic (Applies to certification of Boeing Company inspection personnel only)	BSS 7698
848A	NDT	A3	.	NDI Personnel Certification Level 3 Magnetic	NAS 410
848B	No Nadcap Commodity Code	A3	.	NDI Personnel Certification Level 3 Magnetic	MIL-STD-410
849	No Nadcap Commodity Code	A3	.	NDI Personnel Certification Level 3 Penetrant (Applies to certification of Boeing Company inspection personnel only)	BSS 7698
849A	NDT	A3	.	NDI Personnel Certification Level 3 Penetrant	NAS 410
849B	No Nadcap Commodity Code	A3	.	NDI Personnel Certification Level 3 Penetrant	MIL-STD-410
L101A	HT	H5	Stress Relief And Embrittlement Bakes Only	HT Steel (< 260 KSI) - Does NOT apply when referenced to DPS9.74	DPS5.00-1LO
L101B	HT	H5	Stress Relief And Embrittlement Bakes Only	HT Steel (> 260 KSI) - Does NOT apply when referenced to DPS9.74	DPS5.00-1HI
L101C	HT	H5	.	HT Steel - Precipitation Hardenable - Does	DPS5.00-2

				NOT apply when referenced to DPS9.74	
L101E	HT	None	Limited to stress relief and embrittlement bake only	HT Steel - Martensitic Stainless	DPS5.00-11
L304	CP	None	.	Chromic Acid Anodizing	DPS11.01
L304B	CP	None	.	Chromic Acid Anodizing - Chromate Sealed	DPS11.01-3
L306	CP	None	.	Sulfuric Acid Anodizing	DPS11.05
L308	CP	None	.	Hard Anodizing - Aluminum	DPS11.04
L313	CP	None	Dn0903 White Gold	Color Anodizing	DPS11.06
L325	CP	None	.	Coating- Multicolored Chemical Surface Treatment of Aluminum Alloys (Immersion Application Only)	DPS9.45
L341	CP	None	.	Cadmium Plating - High Strength Steel	DPS9.28
L341A	CP	None	.	Cadmium Plating - High Strength Steel - Post Chromate Treat.	DPS9.28-1
L351	CP	None	.	Chromium Plating	DPS9.71
L354	CP	None	.	Chromium Plating - Thin Dense	DPS9.84
L356	CP	None	.	Copper Plating	DPS9.69
L392A	CP	None	None	Fuel Tank Coating - manual touch-up excluded for requiring approval	DPS4.50-127
L400	NDT	None	None	Magnetic Particle Inspection	DPS4.704
L410	NDT	None	None	Penetrant Inspection	DPS4.707
L441	CP	None	.	Etch Inspection - Machined / Ground Steel	DPS4.715
L500	SE	None	None	Shot Peening - Metal Parts	DPS4.999
S304	CP	None	Alternate solutions and procedures are approved as allowed by section 1.5 PS13201. Hytek procedure HT-4421 Rev F, is approved as the controlling procedure for	Anodizing Aluminum	PS13201

			these noted alternate solutions.		
S400	NDT	None	.	Magnetic Particle Inspection	PS21201
S410A	NDT	None	.	Penetrant Inspection - Aluminum	PS21202
S410B	NDT	None	.This process is limited to parts that do not require etching prior to penetrant inspection only	Penetrant Inspection - Beryllium	PS21202
S410D	NDT	None	.This process is limited to copper parts that do not require etching prior to penetrant inspection only	Penetrant Inspection - Copper	PS21202
S410E	NDT	None	.This process is limited to parts that do not require etching prior to penetrant inspection only	Penetrant Inspection - Low Alloy Steels	PS21202
S410H	NDT	None	.This process is limited to parts that do not require etching prior to penetrant inspection only	Penetrant Inspection - Stainless Steels	PS21202
S410J	NDT	None	.This process is limited to parts that do not require etching prior to penetrant inspection only	Penetrant Inspection - Titanium	PS21202