



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

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Document D1-4426 - Processes for BE10030741

Detail Information for Processor Code number: BE10030741	
Supplier Name: SOUTHWEST UNITED INDUSTRIES INC	
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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
003	AQS	None	None	Boeing approved QMS as defined in D1-4426 Processor Requirements Sec 6.15.3	Quality System
101	HT	H5	Limited to Furnaces in buildings as follows:Bldg 2 furnaces 17,24,25,32; Bldg 4 furnace 29; Bldg 8 furnaces 15, 18; Bldg 9 furnaces 30 & 31; Bldg 10 furnace 27.	Heat Treat of Alloy Steels	BAC 5617
131	HT	H5	Limited to Furnaces in buildings as follows:Bldg 2 furnaces 17,24,25,32; Bldg 4 furnace 29; Bldg 8 furnaces 15, 18; Bldg 9 furnaces 30 & 31; Bldg 10 furnace 27.	Heat Treat of Corrosion Resistant Steel	BAC 5619
300	CP	None	Performed in Building 11 only.	Chromic Acid Anodizing of Alum. - Type I	MIL-A-8625
300A	CP	None	Performed in	Hard Coating -	AMS 2468

			Building 11 only.	Aluminum	
300B	CP	None	Performed in Building 11 only.	Hard Coating - Aluminum	AMS 2469
301	CP	None	Performed in Building 11 only.	Sulfuric Acid Anodize Type II (Approval Not Required for International Space Station (ISS) Houston Only)	MIL-A-8625
302	CP	None	Performed in Building 11 only.	Hard Anodize Type III	MIL-A-8625
305	CP	None	Performed in Building 11 only.	Chromic Acid Anodizing - Class 1 and 3	BAC 5019
306	CP	None	Performed in Building 11 only.	Sulfuric Acid Anodizing	BAC 5022
308	CP	None	Performed in Building 11 only.	Hard Anodizing - Class 1 and 2	BAC 5821
315	CP	None	None	Boric Acid - Sulfuric Acid Anodizing Class 1	BAC 5632
317	CP	None	Performed in Building 11 only.	Chromic Acid Anodizing - Class 5	BAC 5019
318	CP	None	None	Boric Acid - Sulfuric Acid Anodizing Class 5	BAC 5632
320	CP	C1A	Performed in Building 11 only.	Chemical Conversion Coating on Aluminum (Immersion App only) (Approval Not Required for International Space Station (ISS) Houston Only)	MIL-C-5541
320B	CP	C1A	Performed in Building 11 only.	Chemical Conversion Coatings on Aluminum and Aluminum Alloys (Immersion Application Only)	MIL-DTL-5541
321	CP	None	Performed in Building 11 only.	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	.	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 application operations)	BAC 5665
324	CP	None	None	Conversion Coating on Magnesium (Dow 7)	BAC 5609
330	CP	None	None	Black Oxide Conversion Coating on Steel	MIL-C-13924
330B	No Nadcap Commodity Code	None	.	Coating- Oxide- Black- for Ferrous Metals	MIL-DTL-13924
331B	CP	None	Tank #221 only and part numbers 65-65030-10 and 65-65038-5 only	Phosphate Coating- Heavy- Manganese or Zinc Base	MIL-DTL-16232
340	CP	A8	Code A8 for RSS Hardware only. SMPP 101, 1/3/84.	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
344	CP	None	Tank 910 only	Low Hyd. Embrittlement Cadmium/Titanium Plating (QPL)	BAC 5804
348	CP	None	.Additional approval to accompany BAC 5804 Ti-Cad Plating	Low Hydrogen Embritt. - Stylus Cadmium Plate	BAC 5854
350	CP	A8	Code A8 for RSS Hardware only. SMPP SWP 102, 11/15/83.	Chromium- Plating	QQ-C-320
350B	CP	None	.	Chromium Plating (Electrodeposited)	AMS-QQ-C-320
351	CP	None	Tank 272 replacement tank/liner/rectifier. Approved via qualification. See BR&T report SR15023	Hard Chromium Plating - Class 1 and 2	BAC 5709
352	CP	None	Tank 272 replacement tank/liner/rectifier approved via qualification. See BR&T report SR 15023	Hard Chromium Plating - Class 3	BAC 5709
353	CP	None	None	Hard Chromium Plating - Class 4 (QPL)	BAC 5709
355	CP	None	None	Copper Plating	MIL-C-14550
356	CP	None	None	Copper Plating	BAC 5722
360	CP	None	None	Nickel Plating	QQ-N-290
360A	CP	None	.	Nickel Plating (Electrodeposited)	AMS-QQ-N-290
361	CP	None	Production limited to Tank 281 only and Part Numbers 161W2120-4, 161W2221-4 and 161W5120-2 only.	Nickel Plating Types I and II	BAC 5746
362	CP	None	Production limited to Tank 281 only and Part Numbers 161W2120-4, 161W2221-4 and 161W5120-2 only.	Nickel Plating Type III (QPL)	BAC 5746
366	CP	None	None	Electroless Nickel Coatings	MIL-C-26074
366B	CP	None	.	Plating Electroless Nickel	AMS 2404
377	CP	None	None	Electroplating of Aluminum	BAC 5714
382	No Nadcap Commodity Code	C1 C2	Bldg 10 Booths 1, 2, 3, 5 for HVOF Class 2 Coating. Booth 4 for HVOF Class 1 coating. Bldg 9 Booth 7 for HVOF Class 2 coating.**Use of approved SWATS	Application of Thermal Spray Coatings (QPL)	BAC 5851

			Only** -- See QPL		
383	CP	None	.	Phosphate Fluoride Coatings - Titanium	BAC 5861
391	CP	None	Application to be accomplished in buildings 8 and 11. QPL added Everlube 9001 on 29-Sep-2005.	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	Penetrant inspection performed in Buildings 4 and 6. Bldg 6 limited to landing components.	Penetrant Inspection	BAC 5423
410A	NDT	None	Penetrant inspection is accomplished buildings 4 and 6. Bldg 6 is limited to landing gear components.	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 Machined Steel Parts	BAC 5436
500	SE	None	None	Shot Peening	BAC 5730
502	SE	None	Limited to processing P/N 161W1020-2 (Pin.	Shot Peening - Self Contained	BAC 5730-2
503	SE	None	None	Shot Peening	MIL-S-13165
507	SE	None	.	Shot Peening	AMS 2430
510	CP	None	.	Cleaning - Descaling of Titanium - Method II Only	BAC 5753
570	No Nadcap Commodity Code	None	None	Grinding of Chromium Plate - Landing gear parts 275 KSI or above	BAC 5032
802	MTL	A3	.	Mechanical Testing - Metallic	Mech. Testing
803	MTL	A3	.	Metallurgical Testing	Met. Testing
806	HT	None	None	Temper Inspection of Non-ferrous Alloys (Conductivity Method including BAC 5651)	BAC 5946
809	CP	A3	None	Process Solution	Chem. Testing

				Control	
810	CP	A3	None	Salt Spray Testing	ASTM-B-117
848	No Nadcap Commodity Code	None	None	NDI Personnel Certification Level 3 Magnetic (Applies to certification of Boeing Company inspection personnel only)	BSS 7698
848A	NDT	None	None	NDI Personnel Certification Level 3 Magnetic	NAS 410
848B	No Nadcap Commodity Code	None	None	NDI Personnel Certification Level 3 Magnetic	MIL-STD-410
849	No Nadcap Commodity Code	None	None	NDI Personnel Certification Level 3 Penetrant (Applies to certification of Boeing Company inspection personnel only)	BSS 7698
849A	NDT	None	None	NDI Personnel Certification Level 3 Penetrant	NAS 410
849B	No Nadcap Commodity Code	None	None	NDI Personnel Certification Level 3 Penetrant	MIL-STD-410
L101B	HT	H5	None	HT Steel (> 260 KSI) - Does NOT apply when referenced to DPS9.74	DPS5.00-1HI
L282A	No Nadcap Commodity Code	None	.	Metallizing	DPS9.83
L283A	No Nadcap Commodity Code	None	.	Plasma Arc Spraying	DPS9.85
L283D	No Nadcap Commodity Code	None	.	High Velocity Oxyfuel (HVOF) Deposited Coatings	DPS9.99
L304	CP	None	Performed in Building 11 only.	Chromic Acid Anodizing	DPS11.01
L304B	CP	None	Performed in Building 11 only.	Chromic Acid Anodizing - Chromate Sealed	DPS11.01-3
L306	CP	None	Performed in Building 11 only.	Sulfuric Acid Anodizing	DPS11.05
L308	CP	None	Performed in Building 11 only.	Hard Anodizing - Aluminum	DPS11.04
L313	CP	None	Dn 0872, 0903	Color Anodizing	DPS11.06
L325	CP	None	Performed in Building 11 only.	Coating-Multicolored Chemical Surface Treatment of Aluminum Alloys (Immersion Application Only)	DPS9.45
L341	CP	None	None	Cadmium Plating - High Strength Steel	DPS9.28
L341A	CP	None	None	Cadmium Plating - High Strength Steel - Post Chromate Treat.	DPS9.28-1
L347	CP	None	None	Brush Plating	DPS9.89
L351	CP	None	None	Chromium Plating	DPS9.71
L354	CP	None	None	Chromium Plating - Thin Dense	DPS9.84
L356	CP	None	None	Copper Plating	DPS9.69
L363	CP	None	None	Nickel Plating - Sulfamate	DPS9.76-1
L364	CP	None	None	Electroless Nickel Plating	DPS9.67
L392A	CP	None	None	Fuel Tank Coating -	DPS4.50-127

				manual touch-up excluded for requiring approval	
L400	NDT	None	None	Magnetic Particle Inspection	DPS4.704
L410	NDT	None	None	Penetrant Inspection	DPS4.707
L441	CP	None	None	Etch Inspection - Machined / Ground Steel	DPS4.715
L500	SE	None	None	Shot Peening - Metal Parts	DPS4.999
L570	No Nadcap Commodity Code	None	None	Metal Grinding	DPS4.601
M304	CP	None	Limited To Types I & II, Class 1 Only, Performed in Building 11 only.	Anodizing - Aluminum (QPL)	HP4-2
M308	CP	None	Type III Class 1 & 2, Dye Chromate Seal Un-Dyed Only.Performed in Building 11 only.	Anodizing Aluminum - Wear Resistance (QPL)	HP4-79
M324	CP	None	Type II Only	Corrosion Protection - Magnesium (QPL), Approval not required for application of Type VII preservation oil	HP4-9
M325	CP	None	Performed in Building 11 only.	Chemical Film - Aluminum (Immersion Application Only) (QPL)	HP4-57
M351	CP	None	Class II Type I	Chromium Plating (QPL)	HP4-13
M361	CP	None	Building 2- tanks 281 and 282 and tank 280 for Wood's nickel strike. Per Robert Knically.	Nickel Electrodeposited (QPL)	HP4-60
M364	CP	T1	None	Electroless Nickel Plating (QPL)	HP4-10
M400	NDT	None	None	Magnetic Particle Inspection (QPL)	HP6-5
M410A	NDT	None	None	Penetrant Inspection - Fluorescent (QPL)	HP6-13
M441	CP	None	.	Etching For Detection Of Grinding Burns (QPL)	HP30-4
N372	CP	None	Naa Approved Processor	Brush Plating/Electrodeposited (Approval Required for NASA Space Shuttle and IDS Anaheim Only)	MIL-STD-865
S103A	No Nadcap Commodity Code	H5	None	HT Steel - Stress & Embrittlement Relief	PS15063
S304	CP	None	Performed in Building 11 only.	Anodizing Aluminum	PS13201
S304A	CP	None	Performed in Building 11 only.	Black Anodizing Aluminum	PS13201.1
S306	CP	None	Performed in Building 11 only.	Hard Coat - Aluminum	PS13208
S325	CP	None	Performed in Building 11 only.	Coating - Multicolored Chemical Conversion of Aluminum Alloys by Immersion	PS13209

S341	CP	None	None	Cadmium Plating	PS13101
S347	CP	None	Cadminum	Brush Plating	PS13113
S348	CP	None	None	Cadmium Plating - Low Embrittlement	PS13144
S351	CP	None	None	Chromium Plating	PS13102
S356	CP	None	None	Copper Plating	PS13104
S361	CP	None	None	Nickel Plating	PS13112
S364	CP	None	None	Electroless Nickel Plating	PS13105
S365	CP	None	None	Plating - Diffused Nickel Cadmium	PS13107
S391	CP	None	Exclude Class 7 & Pretreat Types G&M.	Application - Dry Film Lubricant	PS18021
S400	NDT	None	None	Magnetic Particle Inspection	PS21201
S410A	NDT	None	None	Penetrant Inspection - Aluminum	PS21202
S410C	NDT	None	None	Penetrant Inspection - Cobalt - Nickel	PS21202
S410D	NDT	None	None	Penetrant Inspection - Copper	PS21202
S410E	NDT	None	None	Penetrant Inspection - Low Alloy Steels	PS21202
S410F	NDT	None	None	Penetrant Inspection - Magnesium	PS21202
S410H	NDT	None	None	Penetrant Inspection - Stainless Steels	PS21202
S410J	NDT	None	None	Penetrant Inspection - Titanium	PS21202
S441	CP	None	None	Temper Etch Inspection	PS21205
S500	SE	None	None	Peening	PS14023
U400	NDT	None	None	Magnetic Particle Inspection - SMPP Req-d	ST0501LT0011
U410	NDT	None	None	Penetrant Inspection - SMPP Req-d	ST0501LT0010
U914	CP	None	None	Application of Intregal Fuel Tank Coating	ST0108LA0011