

VS901 HEAT TREAT

VS SPEC	REV.	DESCRIPTION
VS901001	C	A286 CRES BAND CLAMPS & V-COUPPLINGS (8 HOURS) (REPLACED BY VS901003)
VS901002	F	T431 CRES T-BOLTS 125-160 KPSI ULTIMATE TENSILE
VS901003	D	A286 CRES BAND CLAMPS & V-COUPPLINGS (16 HOURS)
VS901004	-	1038 CARBON STEEL GRADE 5 T-BOLTS
VS901005	A	4130 ALLOY
VS901006	F	T431 CRES T-BOLTS 140-165 KPSI ULTIMATE TENSILE
VS901007	D	.1900-32 T-BOLTS 4037 ALLOY
VS901008		OBSOLETE (SEE VS901010)
VS901009		OBSOLETE (SEE VS901010)
VS901010	D	T-BOLTS 4037 ALLOY
VS901011		OBSOLETE (SEE VS901010)
VS901012	C	A286 CRES T-BOLT AND EYE BOLT BLANKS FOR 160-190 KPSI TENSILE STRENGTH (CUST. APPROVED)
VS901013	-	VFS122100-000 321 CRES
VS901014	-	UNDERAGE TREATMENT FOR INCONEL 718 STRIP
VS901015	E	T431 CRES EA T-BOLTS 180-225 KPSI
VS901016	H	STRESS RELIEF OF TITANIUM SHEET METAL DRAWN CUPS BEFORE FORMING FLANGES
VS901017	E	ANNEALING OF 300 SERIES CRES, IN625 & IN718
VS901018		OBSOLETE — 8/22/91
VS901019	B	HYDROGEN RELIEF BAKE OF PASSIVATED 301 CRES COMPONENTS
VS901020	-	17-4 PH AND 17-7 PH STAINLESS STEEL
VS901021	K	IN PROCESS STRESS RELIEF OF TITANIUM 15-3-3-3 DRAWN CUPS
VS901022	B	NICKEL ALLOY 718 FOR LOCKHEED MARTIN — DENVER AEROSPACE
VS901023	C	A286 CRES LARGE HEAD T-BOLT BLANKS & COLD HEADED TRUNNIONS (140 MIN. KSI TENSILE STRENGTH)
VS901024	-	NICKEL ALLOY 718 RING BLANKS
VS901025	-	NICKEL ALLOY 625 RING BLANKS
VS901026	A	ANNEALING OF THUMB SCREW BEFORE FLATTENING
VS901027	B	A286 CRES FORMED WELDED RING FOR RIGID COUPLING
VS901028	-	CADMIUM PLATE IAW QQ-P-416F CI T2
VS901029	-	15-5 PH WIRE FOR BOLT PRODUCT (PIN ADJUSTER)
VS901030	B	15-5 PH FOR BOLT PRODUCT AFTER HEADING
VS901031	A	BAKE TREATMENT SPEC. FOR ALL ASSEMBLED CLAMPS, COUPLINGS AND HARDWARE WHICH ARE ASSEMBLED PRIOR TO PASSIVATION.
VS901032		OBSOLETE — 02/10/03
VS901033	A	ANNEALING PROCEDURE FOR 6-6-2 TITANIUM (AB-3)
VS901034	Ø	ANNEAL 321 STAINLESS STEEL FOR P/N SK 12949 (PWA 11-15K)
VS901035	B	RE-SOLUTION HEAT TREATMENT OF BETA 21S TITANIUM
VS901036		OBSOLETE — 08/01/03
VS901037	H	RE-SOLUTION HEAT TREATMENT OF 15-3-3-3 TITANIUM
VS901038	-	AGING HEAT TREATMENT OF 15-3-3-3 TITANIUM DUCTING AND 6-4 TITANIUM FLANGE ASSEMBLIES
VS901039	A	HIGH TEMPERATURE AGE CYCLE FOR BETA 21S TITANIUM
VS901040	E	STRESS RELIEVE HEAT TREATMENT OF PRE-BULGED 15-3-3-3 TITANIUM FLANGES
VS901041	C	AGE HARDENING HEAT TREATMENT FOR 15-3-3-3 TITANIUM COUPLINGS (VC1880 SERIES)
VS901042	-	HIGH TEMPERATURE (FULL ANNEAL) OF 347 CRES TUBE (CUST. APPROVED) (08/23/06)
VS901043	F	HOT CREEP-FORMING OF 15-3-3-3 TITANIUM (08/29/06)
VS901044	-	DECORATION AGE OF 15-3-3-3 TITANIUM & VERIFICATION OF RE-SOLUTION HEAT TREATMENT (10/18/06)
VS901045	B	ANNEALING OF HASTELLOY MATERIALS (05/16/07)
VS901046	C	HOT CREEP-FORMING OF 15-3-3-3 TITANIUM SHEET METAL CUPS PRIOR TO BULGE FORMING (07/12/07)
VS901047	B	HOT CREEP-FORMING OF 6-2-4-2 TITANIUM RING USED ON SP1083 (INNER SKIN DIFFUSER) (08/09/07)
VS901048	-	HOT CREEP-FORMING & ANNEALING OF 6-4 TITANIUM CONE (SP1120), IAW AMS-H-81200B (12/09/09)
VS901049	A	HEAT TREATMENT PROCESS FOR 8640 ALLOY STEEL BOLTS (12/18/09)
VS901050		UNASSIGNED -- AVAILABLE FOR USE
VS901051	C	SOLUTION HEAT TREATMENT OF WROUGHT ALUMINUM ALLOY PARTS (11/11/13)

VS902 MATERIAL SPECS

VS SPEC	REV.	DESCRIPTION
VS902001	G	A286 CRES COLD HEADING WIRE FOR 160 KPSI MIN. TENSILE T-BOLT
VS902002		OBSOLETE (COMBINED WITH VS902005)
VS902003	D	305 CRES COLD HEADING WIRE FOR T-BOLTS
VS902004	B	316 CRES COLD HEADING WIRE FOR T-BOLTS
VS902005	B	REVISION B (CARPENTER ORDERS ONLY) 431 CRES WIRE FOR E, EC & EA T-BOLTS
VS902005	D	REVISION D (TECHALLOY ORDERS ONLY) PROCUREMENT SPEC FOR 431 CRES (CHQ) WIRE
VS902006	-	T316 ANL CRES COLD HEADING WIRE FOR T-BOLTS
VS902007	D	PROCUREMENT SPECIFICATION FOR TYPE 301ANL SHEET AND STRIP
VS902008	B	MODIFIED PROCUREMENT SPEC. FOR TYPE 301 1/2 H CRES STRIP FOR BORG WARNER
VS902009	H	PROCUREMENT SPECIFICATION FOR COMMERCIAL PURE TITANIUM (REF. AMS4901)
VS902010	D	MATERIAL PURCHASING SPEC FOR 301 1/4 H (AMS5517) USED ON STAMPED "SV" BORG WARNER COUPLINGS.
VS902011	-	RECEIVING INSPECTION REQUIREMENTS FOR 21-6-9 CRES STRIP AND SHEET IAW BMS 7-191
VS902012		PURCHASING OF .031" THICK, 347 CRES TUBE MATERIAL FOR USE IN BULGE FORMING PROCESSES (OBSOLETE 04/21/06 per JFF)
VS902013	A	MATERIAL PURCHASING SPECIFICATION FOR A286 CRES COLD HEADING WIRE USED ON 160 KPSI MIN. TENSILE TRUNNIONS
VS902014	-	THREAD ROLLING DIE PROCUREMENT SPECIFICATION (05/30/09)

VS903 TEST

VS SPEC	REV.	DESCRIPTION
VS903001	-	PULL TEST FOR QUICK RELEASE LATCHES T30-T40-T50-T60
VS903002	-	T-BOLT BEND TEST
VS903003	-	COUPLING PROOF LOAD TEST
VS903004	-	PROOF LOAD TEST AEROJET
VS903005	-	HYDROSTATIC PROOF PRESSURE AND LATCH GAP TEST
VS903006	C	STRESS RUPTURE TESTING OF A286 CRES T-BOLT AND EYEBOLTS
VS903007	B	TENSILE SHEAR TESTING FOR HI-SHEAR TYPE RIVETS
VS903008	-	CHECK FIXTURE FOR VR1041
VS903009	E	INSPECTION PROCEDURE FOR BOEING BACC10GY, BACC10KH, BACC10LE & BACC10NU COUPLINGS
VS903010	G	TESTING REQUIREMENTS OF PASSIVATED PARTS
VS903011	B	HYDROSTATIC PROOF PRESSURE TEST (VC1231)
VS903012	C	PRESSURE TEST PLAN FOR ROLLS-ROYCE TUBE ASSEMBLIES (03/06/09)
VS903013	-	INCOMING INSPECTION OF BC1104B SPRINGS AFTER ZINC PLATE (09/01/09)
VS903014	-	TESTING TO IDENTIFY MATERIAL TYPES (09/04/09)
VS903015	-	HYDROSTATIC PROOF PRESSURE TEST FOR 724205A-587-Z COUPLING (G.E. 5071T32P01) (12/04/09)
VS903016	-	METALLOGRAPHIC SAMPLE PREPARATION PROCEDURE (11/12/13)
VS903017	A	GUIDED BEND TEST (10/01/10)
VS903018	-	PASSIVATION QUALIFICATION AND PROCESS MONITORING REQUIREMENTS IAW LIEBHERR MFT0128 (01/07/11)
VS903019	-	PROOF PRESSURE & LEAK TEST IAW BAC5001-2 (05/12/16)

VS904 SPECIAL INSPECTION

VS SPEC	REV.	DESCRIPTION
VS904001	-	INSPECTION PROCEDURE FOR CHECKING DISTORTION OF SUNDSTRAND P/N 715154, VOSS P/N 714201A-800-A
VS904002	-	INSPECTION REQUIREMENTS FOR TITANIUM FLANGES
VS904004	E	BOEING 'GY' / 'KH' / 'LE' GAP INSPECTION USING BEVELED CHECK PLATE
VS904005	-	ACCEPTABILITY LIMITS FOR DRIVEN RIVETS
VS904006	-	DIMENSIONAL TOLERANCES FOR DRAWING VC1652 (REF. SPEC DIN 7168-m)
VS904007	D	BACC10KG INSPECTION
VS904010	B	FLUORESCENT PENETRANT INSPECT
VS904011	-	MACHINED FLANGES INSPECTION ACCEPT/REJECT CRITERIA IAW AS1895
VS904012	-	BORG WARNER V-RETAINER TORQUE VALUES
VS904013	B	ENGINEERING CRITERIA FOR "VFS" STYLE FLANGES
VS904014	C	PRODUCTION ACCEPTANCE OF AMS 4901 AND AMS 4914 TITANIUM
VS904015	B	EXTRUSION CHECK GAGE FOR GOODRICH LOCKING RINGS
VS904016	-	INSPECTION PROCEDURE FOR SEMI-TUBULAR RIVETS
VS904017	A	INTERPRETATION GUIDELINES FOR F.P.I. INSPECTION OF SHEET METAL FLANGES
VS904018	Ø	LOOP GAP INSPECTION CHART (CHOOSE LATCH STYLE BELOW)
VS904019	-	PROCEDURE TO INSPECT GAGE POINT DIAMETER OF HF1023-2 DUCT (02/01/08)
VS904020	-	INSPECTION PROCEDURE FOR LASER CUT HF1023-2 END-CUTS (02/01/08)
VS904021	-	TITANIUM 15-3 ALPHA CASE INSPECTION STANDARD (02/28/08)
VS904022	-	PRESSURE TESTING OF WELDED HOUSINGS
VS904023	B	THREADED BOLT INSPECTION PROCEDURE (04/16/08)
VS904024	-	IN-PROCESS PROOF LOAD TESTING OF VC1933 (TD105004) RETAINER-BAND ASSEMBLIES (02/06/09)
VS904025	D	ATP FOR E-SEAL VS2527-800 (01/07/09)
VS904026	-	BORG WARNER INSPECTION DISK (FOR 5300 & 7100 SERIES COUPLINGS) (03/04/14)
VS904027	A	VISUAL CRITERIA FOR EXTERNAL BRAZED JOINT INSPECTION OF R-R TURBINE NOZZLE SHIELD ASSEMBLIES (3/16/09)
VS904028	-	INSPECTION PROCEDURE FOR ROLL FORMED RINGS (09/21/09)
VS904029	A	IN-PROCESS PROOF LOAD TESTING OF VC2046 (TD108203) RETAINER-BAND ASSEMBLIES (04/09/10)
VS904030	-	VISUAL CRITERIA FOR EXTERNAL BRAZE-JOINT INSPECTION OF ROLLS-ROYCE COMPRESSOR DISCHARGE TUBE ASSEMBLIES (08/31/10)
VS904031	A	FLUORESCENT PENETRANT INSPECTION PROCEDURE/CRITERIA FOR VR1157 COUPLING (BOEING S332A600) (12/08/14)

VS905 CLEANING

VS SPEC	REV.	DESCRIPTION
VS905001		OBSOLETE — 06/30/05, REPLACED BY PI-22-05
VS905002		OBSOLETE — 05/18/04, REPLACED BY VS903010
VS905003	B	CLEANING OF ALUMINUM PRIOR TO WELDING
VS905004	F	ALKALINE "SPRAY" CLEANING
VS905005	-	CHEMICAL ETCHING OF ALUMINUM TO PRODUCE SATIN FINISH
VS905006	-	GLASS BEAD BLASTING OF THIN WALL ALUMINUM DUCTING
VS905007	-	ALKALINE IMMERSION CLEANING (12/11/07)

VS906 PAINTING & COATINGS

VS SPEC	REV.	DESCRIPTION
VS906001	-	PAINT PROCEDURE FROM ORDNANCE DRAWING
VS906002	A	HERTNER DIVISION REF. DWG. 1955-000920 REV. F
VS906003	-	APPLICATION OF PRIME COAT AND R.T.V. ADHESIVE / SEALANT
VS906004	-	FINISH PROCEDURE FOR BOEING ALUMINUM PARTS
VS906005	-	FINISH PROCEDURE FOR BOEING ALUMINUM PARTS
VS906006	-	FINISH PROCEDURE FOR BOEING ALUMINUM PARTS
VS906007	-	FINISH, PRIMER, GREEN (BOEING BMS 10-11)
VS906008	A	PROCEDURE IAW ORDNANCE 10931280 REV. B
VS906009	-	PAINT PROCEDURE IAW ORDNANCE SPEC 12369004 REV. B
VS906010		UNASSIGNED
VS906011	M	PRE-TREATMENT, APPLICATION AND TESTING OF CHEMICAL COATINGS
VS906012	B	CARC SYSTEM APPLICATION PROCEDURE AND QUALITY CONTROL INSPECTION IAW MIL-C-53072
VS906013	-	PROCEDURE FOR APPLYING TURCO PRETREAT IN ORDER TO PREVENT OXIDATION DURING HEAT TREATMENT
VS906014	-	ZAHN #2 VISCOSITY CUP CALIBRATION INSTRUCTIONS (08/11/09)
VS906015	-	FORD #4 VISCOSITY CUP CALIBRATION INSTRUCTIONS (08/11/09)
VS906016	A	ADHESIVE APPLICATION OF RUBBER TO STEEL (08/27/12)

VS907 LUBRICATION

VS SPEC	REV.	DESCRIPTION
VS907001		OBSOLETE — 06/26/91 (USE MIL-SPEC ON DWG.)
VS907002	D	APPLICATION OF XYLAN COATING 1010
VS907003		OBSOLETE — 08/17/04, REPLACED BY VS907009
VS907004	-	TEFLON COATING PER WILLIAMS INTERNATIONAL DRAWING 36391
VS907005	-	POWDER COAT FINISH FOR TYPE 300 SERIES STAINLESS STEEL COUPLINGS
VS907006	A	PROCEDURE FOR APPLYING LUBRICATION ON T-BOLT THREADS
VS907007	D	PRETREATMENT, APPLICATION AND TESTING OF SOLID FILM LUBRICANTS APPLIED USING DIP AND SPIN METHOD
VS907008		APPLICATION FOR SOLID FILM LUBRICANT IAW SAE AS4704-CLASS 6 OBSOLETE — 10/28/13 SEE VS907009 FOR SPRAY APPLICATION; OR VS907007 FOR DIP & SPIN APPLICATION
VS907009	U	SOLID FILM LUBRICANTS
VS907010	A	PROCEDURE FOR APPLICATION OF CETYL ALCOHOL TO NUTS
VS907011		APPLICATION/TESTING OF DFL FOR G.E. SOURCE SUBSTANTIATION REQUIREMENTS
VS907012	-	APPLICATION OF FUCHS TUF DRAW 1919 LUBRICANT TO MS21046C4S NUTS (01/19/09)

VS908 MARKING

VS SPEC	REV.	DESCRIPTION
VS908001	-	MARKING SPEC. FOR VOSS DWG. 312205 (ORD. P/N 9090783)
VS908002	J	FAA / PMA MARKING
VS908003	C	LABELING OF UNIT PACKAGES
VS908004	A	SERIAL NUMBER LOG — G.E.
VS908005	-	DATE CODE MARKING FOR GARRETT
VS908006	-	HARDNESS TEST REQUIREMENTS FOR VC1525-596 REF. G.E. 9649M39P05
VS908007	A	VOSS ASSIGNED SERIES — NUMBER LOG FOR G.E. AIRCRAFT ENGINES
VS908008	A	HAMILTON SUNDSTRAND SERIAL NUMBER LOG
VS908009	-	VOSS ASSIGNED SERIES — SEQUENCE NUMBER LOG FOR SIKORSKY
VS908010	-	VOSS ASSIGNED SERIES — SEQUENCE NUMBER LOG FOR WILLIAMS INTERNATIONAL
VS908011	-	VOSS ASSIGNED SERIES — SEQUENCE NUMBER LOG FOR RAYTHEON
VS908012	A	VOSS ASSIGNED SERIES — SEQUENCE NUMBER LOG FOR PALL AEROPower
VS908013	-	MARKING AND LABELING IAW NORTHROP GRUMMAN SPECIFICATION T-13A & T-13
VS908014	-	SERIAL NUMBER LOG — USEC
VS908015	-	SERIAL NUMBER LOG — ROLLS-ROYCE
VS908016	B	ROLLS-ROYCE 2D MACHINE READABLE DATA MATRIX MARKING (11/01/06)
VS908017	-	SERIAL NUMBER LOG — ACC LA JONCHERE
VS908018		MARKING INTERIOR PACKAGING PER MIL-STD-129
VS908019	-	INSTRUCTIONS FOR CONSTRUCTION OF WOOD PACKAGING CONTAINERS OR CRATES
VS908020	-	SERIAL NUMBER LOG — ATK
VS908021	A	CONTROLLED DOT PEENING OF ROLLS-ROYCE 2D DATA MATRIX MACHINE READABLE DATA MARKING & HUMAN READABLE MARKING (12/07/09)
VS908022	C	IDENTIFICATION MARKING METHODS (05/20/10)
VS908023	-	SERIAL NUMBER LOG — LOCKHEED MARTIN (ST1696) (07/19/12)
VS908024	-	SERIAL NUMBER LOG — LOCKHEED MARTIN (ST1701) (02/01/13)
VS908025	-	LOT CODE LOG FOR PARKER AEROSPACE; IAW PARKER DESIGN STANDARD BDS1037 (11/01/13)
VS908026	-	SERIAL NUMBER LOG — ZODIAC AERO DUCT SYSTEMS (01/16/15)

VS909 WELDING

VS SPEC	REV.	DESCRIPTION
VS909001	-	HELI-ARC SPEC. FOR WELDING BRIDGE TO RETAINER (REF. VC1077) S
VS909002	-	WELD PROCEDURE — ST1444-A
VS909003	-	WELD PROCEDURE — SK12901
VS909004	-	REWORK PROCEDURE FOR AERONCA CONE (WELD) P/N: SK12945
VS909005	H	RESISTANCE WELDING SPECIFICATION (03/06/12)

VS910 SPECIAL SPECIFICATIONS

VS SPEC	REV.	DESCRIPTION
VS910001	-	SHEET METAL FLANGE: SHOP RUN TOLERANCES
VS910002		OBSOLETE
VS910003	E	PROCESS SPEC. DRAWING FOR VOSS RIGID COUPLING — DRIVE SCREW HOLE LOCATION
VS910004	J	ELECTRO ETCH MARKING PROCEDURE
VS910005		MATERIAL HANDLING FOR MP1022 SENT TO ANODIZING (OBSOLETE PER PRCN 106662)
VS910006	-	RETAINER CRITERIA
VS910007	-	REPAIR PROCEDURE FOR CP70 & 15-3-3-3 SHEET METAL FLANGES (MACHINING)
VS910008	-	THREADED INSERT INSTALLATION PROCESS FOR VC1740
VS910009	-	MATCH DRILL & RIVETING OF VC1889-2 BRACKET TO VC1889-3 RETAINER
VS910010	A	MATCH DRILL & RIVETING OF VC1915-2 BRACKET TO VC1915-3 RETAINER
VS910011		OBSOLETE — 03/03/08 (ECN 32242)
VS910012	-	MATCH DRILLING AND RIVETING PROCESS FOR VC1922-2 BRACKET WITH VC1922-3 RETAINER
VS910013	C	MATCH DRILLING AND RIVETING PROCESS FOR VC1932-2 OR VC1932-4 BRACKET WITH VC1932-3 OR VC1932-5 RETAINER (ASSY.VC1932-11); OR ASSY. VC1932-21 IF VS2870 (FOIL SHIM) IS UTILIZED (09/26/08)
VS910014	B	BRAZE/RE-SOLUTION AND PRECIPITATION AGE PROCESS (10/29/08)
VS910015	J	PROTECTION, PACKAGING & LABELING REQUIREMENT, ROLLS-ROYCE SABRE, GER 0102, ISSUE 26 (09/26/08)
VS910016	A	V-RETAINER COUPLING WELDING CRITERIA (02/12/09)
VS910017	-	GOODRICH LOCK RING REWORK METHOD (04/16/09)
VS910018	-	HIGH VOLUME SILVER PLATE STRIP PROCEDURE (05/08/09)
VS910019	-	CHEMICAL PROCESSING EQUIPMENT TYPES & LOCATIONS (12/18/09)
VS910020	-	BUSHING INSTALLATION PROCEDURE FOR MF1193 (HAMILTON SUNDSTRAND) (01/03/11)
VS910021	-	FIXTURING PROCEDURE FOR RE-SOLUTION HEAT TREATMENT OF VFS143429-750 & -900 TITANIUM SHEET METAL FLANGES (IAW VS901037) (06/08/11)
VS910022	B	PACKAGING IAW LOCKHEED MARTIN PM-5010 (01/26/12)
VS910023	-	PACKAGING PROCEDURE FOR MICRO-TRONICS SHIPMENTS — VOSS P/Ns: VC1095A-768-Z, VC1375A-767-Z, 724202A-947-ZB (03/29/12)
VS910024	C	HF1032 ASSEMBLY PROCEDURE (08/07/12)
VS910025		MATCH DRILLING AND RIVETING PROCESS FOR VC1932-2 OR VC1932-4 BRACKET WITH VC1932-3 OR VC1932-5 RETAINER WITH VS2870 BRAZE FOIL OBSOLETE—12/05/13 (ECN 34901), SEE VS910013
VS910026	-	APPLICATION AND ACCEPTANCE CRITERIA OF NYLOCK PATCH ON BC1357B BARREL NUT (09/23/13)
VS910027	-	HANDLING AND STORAGE OF 2024-T3 ALUMINUM ALLOY DURING FORMING OPERATIONS (AFTER SOLUTION HEAT TREATMENT) (11/01/13)
VS910028	-	IN-PROCESS HANDLING AND PACKAGING REQUIREMENTS FOR TUBES, TUBE ASSEMBLIES, AND SUB-COMPONENTS (02/28/14)
VS910029	-	ST1721 CLEANING, PACKAGING AND LABELING REQUIREMENTS (05/27/16)
VS910030	-	PACKAGING PROCEDURE FOR ALIGN AEROSPACE SHIPMENTS (1/31/17)

VS911 PLATING SPECIFICATIONS

VS SPEC	REV.	DESCRIPTION
VS911001	-	CADMIUM PLATING SPEC. FOR BARREL HARDWARE VS2222-1 & VS2222-2
VS911002	A	CADMIUM PLATING IAW AMS-QQ-P-416F CI T2
VS911003	-	CHEMICAL CONVERSION TOUCH-UP IAW MIL-A-8625 F