

# Northrop Grumman Specifications

For the F/A – 18CDEF Programs

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Spec.	Rev.	Title	December 19, 2011
74A900003	J	Serialization and Traceability for F/A-18 FC Parts	◀
74A900004	M	Control of Fracture & Maintenance Crit. Parts for F/A-18	◀
74A900053	H	Serialization and Traceability Requirements for F/A-18EF Parts	◀
74A900054	H	Control of Fracture and Maintenance Critical Parts for F/A-18EF Aircraft	◀
PS 11217	AY	Sealing Methods, Aircraft F97875, H01351	◀ #
PS 12010	U	Cleaning, Solvent, Hand or Immersion F95555, F97876	◀
PS 12020	AA	Cleaning, Solvent Vapor Degreasing F86318, F97876	
PS 12030	AA	Alkaline Cleaning F97252, F97876	
PS 12040	AB	Cleaning, Abrasive H01057, F97876	
PS 12045	M	Liquid Hone Cleaning F97876	#
PS 12050	U	Pickling F97876	
PS 12050.1	AA	Pickling Aluminum Alloys F96420, F97876	
PS 12050.2	D	Pickling Copper and Brass Alloys F97876	
PS 12050.5	J	Pickling Stainless Steel F97876	
PS 12050.6	L	Pickling Titanium and Titanium Alloys F73637, F97876	
PS 12100	N	Stripping of Organic Coating - Brush or Spray Application F97876, F76054	
PS 13001	T	Passivation of Corrosion and Heat Resistant Alloys F96483, F97877	
PS 13143	T	Aluminum, Ion Vapor Deposited (IVD) of F97877, F97976, F97889	

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PS 13145	K	Vacuum Metalizing of Cadmium on Metals F97877	
PS 13201	AL	Anodizing Aluminum Alloys F81064, F66514, F97877	#
PS 13204	AF	Chromate Conversion Coating (Brush Treat) F74074A, F97877	
PS 13209	W	Multi Colored Chemical Conversion Coating F96419, F97877	
PS 13300	R	General Painting Methods and Techniques F93237, F97877	
PS 13375	AC	Application of Epoxy Primer F97251, F97877	#
PS 13525	AB	Polyurethane Corrosion Resistant Coating F97877, H00319	
PS 13555	W	Coating, Anti-Chafe H00318, F97877	
PS 13630	AC	Painting of F/A-18 and AV-8 Aircraft F97877, H00693	
PS 13630.1	AB	Painting at Detail and Assembly Level F97877, H01113	
PS 14007	AB	Forming Aluminum Alloy Wrought Products F93240, F97878A	
PS 14017	V	Forming of Titanium F97878A, F97720	
PS 14023	R	Peening F73836, F97878A	
PS 14094	C	Shot Peen Forming F97878A	
PS 15000	V	General Heat Treating Criteria for Ferrous Materials F97879, F96430	
PS 15000.5	A	Hardening of Alloy Steels to 180 ksi Minimum and Under	
PS 15000.6	C	Hardening of Alloy Steels to 200 ksi Minimum and Over F94730	#

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Spec.	Rev.	Title	December 19, 2011
PS 15000.11	C	Hardening of PH Grade Stainless Steel to the H Cond. F95559	
PS 15063	K	Stress Relief and Embrittlement Relief	
PS 15130	(A)	Hardening 4330V to 220,000 - 240,000 PSI ** Cancelled -- Use PS 15000.6 **	
PS 15227	(A)	Hardening 17-4PH and 15-5PH (Condition. A) to H1025 Cancelled -- Use PS 15000.11	
PS 15500	Y	General Heat Treating - Aluminum Alloys F95572, F97879	
PS15500.8	A	Heat Treating of Aluminum Alloys to the -T73 Condition	
PS 15558	(B)	Hardening of 7049 & 7149 to T-73 Condition ** Cancelled, use PS15500.8 **	
PS 15800	F	General Heat Treating Criteria for Titanium Alloys F97879	
PS 15807	L	Stress Relief Procedure - Titanium Alloys F55075, F48473	#
PS 15935	J	Heat Treatment of Beryllium Copper Alloys F97879	
PS 16001	BR	Marking of Fabricated Parts F97879, F98977	◀
PS 17031	U	Bearings/Bushings, Grooved Outer Race, Staking of F97083, F97880	◀
PS 17034	L	Bushings, Installation of F97880	◀
PS 17035	AA	Bushings, Installation of, Force Mate Method F95181, F97880	◀
PS 17169	AG	Bonding and Grounding; Electrical F97880, H01181	◀ #
PS 18015	E	Lubricant, Cetyl Alcohol, Application to Parts F97879	
PS 18021	AB	Lubricants, Bonded Dry Film, Application of F97879	
PS 18022	E	Application of Air Drying Solid Film Lubricant F97879	

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Spec.	Rev.	Title	December 19, 2011
PS 19000	W	Installation of Fasteners F97881, H01092	◀ #
PS 19110	U	Fasteners, Solid Rivets, Installation of F98148, F97881	◀
PS 19121	V	Installation of blind rivets, fasteners G03245, F97881	◀
PS 19135	Y	Fasteners, Jo-Bolt Type Blind Bolts; Installation of G00198, F97881, H00709	◀ #
PS 19145	AA	Installation of hi-lok fasteners F97881, H00708	◀
PS 19180	J	Cold Working Holes: Split Sleeve Method G00133, F97881, Supp. 2 (Rev. J)	◀
PS 19402	AM	Hole Preparation - Feeds and Speeds EO HO1284, F92860A	◀ #
PS 20001	V	Protection of Parts During Fabrication & Temp. Storage F93235, F97882	◀ #
PS 20004	J	Rework of Scratched, Abraded, or Corroded Surfaces F97882	◀
PS 20009	J	Straightening of Metallic Materials and Parts F97882	◀
PS 20018	F	Surface Finish Requirements for Round Holes EO F97882	◀
PS 20024	P	Deburring, Blending and Sanding of Metal Parts F97882, F98976	◀
PS 20707	ORG	Grinding of Titanium Alloys F97882	
PS 21201	AC	Magnetic Particle Inspection H00987, H00988	
PS 21202	AP	Penetrant Inspection H00946, H00956	
PS 21203	J	Hardness Testing of Parts and Materials F97883	
PS 21205	K	Temper Etch Inspection (Hardened Steel Parts) F96641	

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Spec.	Rev.	Title	December 19, 2011
PS 21206	J	Radiographic Inspection - General F73910A, F74776, H00521	
PS 21207	G	Eddy Current Determination of Electrical Conductivity for Aluminum Alloys F96120, G03268	
PS 21211	K	Ultrasonic Inspection of Wrought Metals G01496, F96433	
PS 21211.3	G	Ultrasonic Inspection of Machined Parts F94216A, F94833	
PS 21217	(G)	Eddy Current Inspection of Holes; General Requirements F94717 This specification is now replaced by PS 21219.1	
PS 21219	B	Eddy Current Inspection, General F94756, F94757	
PS 21219.1	F	Eddy Current Inspection and Measurements G01346	
PS 21239	D	Coating Thickness Measurement F87813A, F94744	
PS 21239.2	A	Coating Thickness Measurement by Direct Readout Eddy Current Instruments F94766	
PS 21240	E	Nondestructive Testing -- Personnel Qualification F82949A, F94217A, G01351, H00607	
PS 22240	L	Arc Fusion Welding Titanium and Titanium F97037, F97882	
PS 22241	H	Salvage of Machined Titanium Parts by Welding F97230, F97882	
PS 22300	H	Electronic Beam Fusion Welding F73880, F97882	
PS 23023	R	Hardness and Electrical Conductivity Inspection Acceptance Criteria for Metals F97883, G00172	◀
PS 23041	V	Requirements and Acceptance Criteria for Machined Parts F98620, F97883	◀

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Spec.	Rev.	Title	December 19, 2011
MMS-332	P	High Temperature Resistant Fuel Tank Filleting and Fay Surface Sealant Add 1 (rev. J)	
MMS-420	R	Aliphatic Polyurethane Finish System Add. 1 (Rev. BB), F95624	#
MMS-423	D	Low V.O.C. - Low Density Epoxy Primer Add. 1 (rev. J), F96507, F96508	
MMS-425	(F)	Low V.O.C. - Low Density Epoxy Primer F96506 (see cancellation notice)	
MMS-436	B	High Temperature Epoxy Primer Add. 1 (rev. A)	
MMS-1233	F	Titanium Alloy Forgings, Standard Grade Ti-6Al-4V, Recrystallation Annealed EO F96428 ADD. 1 (Rev. K)	
MMS-1420	G	Aluminum Alloy Plate, 7050-T73651 EO F09070A ADD. 1 (Rev. P)	
MMS-1439	E	Aluminum Alloy Plate, 7050-T7451, Fatigue Tested ADD. 1 (Rev. H)	