

FTI Specification List



Information Page

-- Notice of Document Update and Review --

This document is to be reviewed by the supplier every 90 days on Fatigue Technology's website. It is the Suppliers responsibility to verify they are using the current revision level of this document.

This document contains the approved lists of specifications revisions for use by external providers of Fatigue Technology, Inc. This most current version of this list is available from Fatigue Technology's website at <http://www.fatiguetechnology.com/>.

It is the external provider's responsibility to obtain Industry Standard (AMS, AS, EN, ASTM, etc.) and Military / Government Specs (MIL, FED, etc.).

It is the external provider's responsibility to obtain current versions of customer specifications.

Raw Material: Unless otherwise specified, the material producer shall work to the current revision level of the specification on the date of order placement unless otherwise specified on the purchase order or drawing. The applicable specification may be stated on the FTI Drawing and / or FTI Specification (FTI-8701).

Processors of customer specific specification (Boeing, Airbus, Lockheed Martin, Sikorsky, etc.) are required to hold valid approval, as applicable, from the customer certifying body. **In cases of conflict between this document and the current revision level available from customer, the customer document revision level takes precedence.**

Lockheed Martin QCS-001 Note: If the external provider is performing a process identified by QCS-001, the supplier is required to identify specification(s) title, specific revision level(s) and drawing(s) requirement(s) being performed by the QCS-001 source.

If the external provider has a question on the revision level or the specification is not listed, please contact your purchasing focal at Fatigue Technology for clarification. If there is a conflict between an Industry Standard revision level and the revision level listed here, contact your purchasing focal at Fatigue Technology for clarification. If the external provider has any questions or concerns, please contact your purchasing focal at Fatigue Technology.

The following shows the order or precedence of documents:

1. Purchase Order
2. Current Customer Specifications (Boeing, Airbus, Lockheed Martin, Sikorsky, etc.)
3. This Document

Sections:

Section 1.0	Process Industry / MIL / FED Standards
Section 2.0	FTI Specifications
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Section 1.0: Process Industry / MIL / FED Standards

Specification	Document Title	Revision	Comments
AMS2417	Plating, Zinc-Nickel Alloy	K	
AMS2418	Plating, Copper	K	
AMS2426	Coating, Cadmium Vacuum Deposition	F	
AMS2658	Hardness and Conductivity Inspection of Wrought Aluminum Alloy Parts	D	
AMS2700	Passivation of Corrosion Resistant Steels	G	
AMS2759	Heat Treatment of Steel Parts, General Requirements	G	
AMS2759/3	Heat Treatment, Precipitation-Hardening Corrosion-Resistant and Maraging Steel Parts	J	
AMS2759/9	Hydrogen Embrittlement Relief (Baking) of Steel Parts	E	
AMS QQ-P-35	Passivation Treatments for Corrosion-Resistant Steel	A	Cancelled, See AMS 2700
AMS QQ-P-416	Plating, Cadmium (Electrodeposited)	G	
AMS2761	Heat Treatment of Steel Raw Materials	-	Replaces AMS-H-6875 for raw material. Contact FTI for questions when to use this.
AMS-H-6875	Heat Treatment of Steel, Process for	C	Rev B is acceptable for products before release of Rev C. See AMS2761
AMS-STD-595	Colors Used in Government Procurement	A (A3)	Supersedes FED-STD-595
AS5272	Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting, Procurement Specification	G	
AS87132	Lubricant, Cetyl Alcohol, 1-Hexadecanol, Application to Fasteners	A	
AS9102	Aerospace First Article Inspection Requirement	C	

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Section 1.0: Process Industry / MIL / FED Standards

Specification	Document Title	Revision	Comments
AS9103	Variation Management of Key Characteristics	B	
AS9138	Quality Management Systems Statistical Product Acceptance Requirements	-	2018-01
ASTM A967 / A967M	Standard Specification for Chemical Passivation Treatments for Stainless Steel Parts	25	
ASTM B254	Standard Practice for Preparation of and Electroplating on Stainless Steel	92(2020)e1	
ASTM B571	Standard Practice for Qualitative Adhesion Testing of Metallic Coatings	23	Last Updated: Nov 03, 2023
ASTM B700	Standard Specification for Electrodeposited Coatings of Silver for Engineering Use	20	
ASTM B849	Standard Specification for Pre-Treatments of Iron or Steel for Reducing Risk of Hydrogen Embrittlement	02(2023)	Last Updated: Nov 07, 2023
ASTM B850	Standard Guide for Post-Coating Treatments of Steel for Reducing the Risk of Hydrogen Embrittlement	98(2022)	
ASTM E1417 / E1417M	Standard Practice for Liquid Penetrant Testing	21e1	
ASTM E1444 / E1444M	Standard Practice for Magnetic Particle Testing	25	
BS EN 4473	Aluminium pigmented coatings - Coating methods	2024	
FED-STD-595	Federal Standard: Colors Used in Government Procurement	C	Superseded by AMS-STD-595
MIL-A-8625	Anodic Coatings For Aluminum and Aluminum Alloys	F	Superseded by MIL-PRF-8625
MIL-PRF-8625	Anodic Coatings For Aluminum and Aluminum Alloys	F	Superseds MIL-A-8625
MIL-C-5541	Chemical Conversion Coatings on Aluminum and Aluminum Alloys	E	Superseded By MIL-DTL-5541F
MIL-C-81706	Chemical Conversion Materials For Coating Aluminum and Aluminum Alloys	B	Superseded By MIL-DTL-81706
MIL-DTL-18264	Finishes: Organic, Weapons System, Application and Control of	F	Superseds MIL-F-18264
MIL-DTL-5541	Chemical Conversion Coatings on Aluminum and Aluminum Alloys	F	Superseds MIL-C-5541
MIL-DTL-81706	Chemical Conversion Materials For Coating Aluminum and Aluminum Alloys	B	Superseds MIL-C-81706

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Section 1.0: Process Industry / MIL / FED Standards

Specification	Document Title	Revision	Comments
MIL-DTL-83488	Coating, Aluminum, High Purity	D	
MIL-F-18264	Finishes: Organic, Weapons System, Application and Control of	D	Superseded by MIL-DTL - 18264
MIL-P-23377	Primer Coatings: Epoxy, High-Solids	K	Superseded by MIL-PRF-23377
MIL-PRF-23377	Primer Coatings: Epoxy, High-Solids	K	Superseds MIL-P-23377
MIL-PRF-85285	Coating: Polyurethane, Aircraft And Support Equipment	F	
MIL-PRF-85582	Primer Coatings: Epoxy, Waterborne	E	
MIL-STD-1907	Inspection, Liquid Penetrant and Magnetic Particle, Soundness Requirements for Materials, Parts and Weldments	03-2025	
MIL-STD-6866	Inspection, Liquid Penetrant	11-1996	Surperseded by ASTM E1417
prEN 6118	Aluminium Base Protection for Fasteners	P3	
TT-C-490	Chemical Conversion Coatings and Pretreatments for Metallic Substrates (Base for	G	

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Section 2.0: FTI Specifications

Specification	Document Title	Revision	Notes
FTI-8403	Application of Bonded Dry Film Lubricants to Flying Parts	AJ	
FTI-8701	Requirements for Raw Materials Used in the Production of Flying Parts	BT	
FTI-8705	Hose Assemblies for FTI Hydraulic Puller Units and Hydraulic Pumps	D	
FTI-8706	Split Sleeve Raw Material Requirements	T	
FTI-8707	Procedure for Heat Treating Mandrel Material for Use in the Cold Expansion System	AA	
FTI-8901	Heat Treatment of Alloy Steels	C	
FTI-9002	Heat Treatment of Tool Steels (AISI A2, AISI D2, AISI H13, M4)	G	
FTI-9101	Raw Materials Specification	S	
FTI-9103	Heat Treatment of Puller Jaws	K	
FTI-9302	Mandrel Material Specification	F	
FTI-9409	Procedure for Case-Hardening 1018 Steel	A	
FTI-9508	Coating of Mandrels with Molydisulfide	C	
FTI-9602	Gage Pin Heat Treatment	-	Original Release
FTI-2001-05	Quality Assurance Sampling Procedure	E	Only use if called out on Purchase order or drawing
FTI-2001-07	Isolated Lot Sampling Plan	H	Only use if called out on Purchase order or drawing
FTI-2007-01	Cosmetic Defect Inspection Criteria for Machined Parts	H	
FTI-2013-01	Application of Black Oxide Coating to Iron and Steel Metals	F	Use this document if FTI Purchase order just calls out Black Oxide

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Section 3.0: Customer Specifications

Specification	Document Title	Revision	Notes
AIPS 02-04-006	Electrolytic Zinc-Nickel Plating	Issue 3	
AITM6-1001	Airbus Test Method For Inspection Processes Penetrant Testing	Issue 12	
BAC 5423	Penetrant Methods of Testing	See D1-4426	*Current revision defined by Boeing D1-4426 at time of PO
BAC 5424	Magnetic Particle Inspection	See D1-4426	*Current revision defined by Boeing D1-4426 at time of PO
BAC 5748	Abrasive Cleaning, Deburring, and Finishing	See D1-4426	*Current revision defined by Boeing D1-4426 at time of PO
BAC 5811	Application of Bonded Solid Film Lubricants	See D1-4426	*Current revision defined by Boeing D1-4426 at time of PO
BMS 10-85	Aluminum Pigmented Coating for Fasteners	See D1-4426	*Current revision defined by Boeing D1-4426 at time of PO
BPS 4465	Application of Powdered Coatings	F	
PS 18015	Lubricant, Cetyl Alcohol, Application to Parts	E	
PS 18021	Lubricants, Bonded Dry Film, Application of	AE	
SS8805	Inspection Process, Magnetic Particle	16*	*Current revision defined by SS7777 at time of PO
SS8806	Inspection, Liquid Penetrant	18*	*Current revision defined by SS7777 at time of PO
LMA-PC201	Requirements for Fluorescent Penetrant Inspection of Metallic Parts and Materials	Current Revision	QCS-001 Process Code 113
LMA-PC003	Inspection, Acceptance Criteria for Metal Parts	Current Revision	