



DQP

Leonardo Helicopters

Declaration of Qualification of the Process

N° IT15/00025/00

Dichiarazione Qualifica Processo

<input type="checkbox"/> INITIAL QUALIFICATION Qualificazione Iniziale	<input type="checkbox"/> RENEWAL OF QUALIFICATION Rinnovo della Qualifica	<input checked="" type="checkbox"/> REQUALIFICATION Riqualificazione	<input checked="" type="checkbox"/> External / Esterna	<input type="checkbox"/> Internal / Interna
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APPROVED SUPPLIER OR LH PLANT / Fornitore o Sito LH G.R.TRATTAMENTI TERMICI-	RESPONSIBLE LH SITE / Sito LH Responsabile IT15 - Frosinone
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PRODUCTION SITE / Sito Produttivo VIA MARITTIMA II KM 5,700 - 55 - 04014 - PONTINIA (LT) ITALY	DEPARTMENT - BUILDING / Reparto - Edificio
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SPECIAL PROCESS / Processo Speciale

HEAT TREATMENT OF STEEL ALLOYS

PROCESS DETAIL / Dettaglio Processo

APPLICABLE SPECIFICATIONS AND REVISION NUMBER (continue to page 2)
Specifiche Applicabili e Relativo Stato di Revisione (segue a pagina 2)

AWPS001Q - EQUIPMENT CONTROL FOR HEAT TREATMENTS AN Rev.B
AWPS004Q - HARDNESS AND ELECTRICAL CONDUCTIVITY TES Rev.C

EQUIPMENT AND RELEVANT DATA / Impianti e Dati Rilevanti
SEE MOD12PRO6_capability_list_GRTT_LH and RAPPORTO 02/22 REV.1 and RAPPORTO 03/22 – REV.1

APPROVED ACTIVITIES / Attività Approvate
HT SU ACCIAI INDURENTI PER PRECIPITAZIONE E MARAGING HT SU ACCIAI INOSSIDABILI (SERIE 300 E 400)_Normalising, hardening and tempering according to AWPS007T/02. Hardening and stress relieving according to AWPS007T/03. Solution annealing and precipitation hardening according to AWPS007T/04

LIMITATIONS / Limitazioni

THE PROCESS IS APPLICABLE FOR THE PRODUCTION OF PARTS P/N
Specifiche Applicabili e Relativo Stato di Revisione

<input checked="" type="checkbox"/> AgustaWestland	<input type="checkbox"/> Bell	<input type="checkbox"/> Boeing	<input type="checkbox"/> Sikorsky	<input type="checkbox"/> AW609 per BPS spec	<input type="checkbox"/> ICH-47F	<input type="checkbox"/>
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PERSONNEL ASSIGNED TO THE PROCESS / Personale addetto al processo

PRODUCTION RESPONSIBLE / Responsabile Produzione F.MANCINI-M.SULLO	QUALITY RESPONSIBLE / Responsabile Qualità S.RICCIARINI
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ASSIGNED PERSONNEL / Personale addetto FABRIZIO MANCINI; MASSIMO SULLO	INSPECTORS / NDT Personnel / Controllori FABRIZIO MANCINI; MASSIMO SULLO; ALESSANDRO FRASCA
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RESPONSIBILITY: THE APPROVED LH FACILITY / SUPPLIER IS RESPONSIBLE TO PERFORM ALL TESTS REQUIRED BY APPLICABLE PROCESS SPECIFICATIONS
Responsabilità: il Reparto LH / Fornitore approvato è responsabile di eseguire tutte le prove richieste dalle Specifiche Applicabili

TRACEABILITY: RECORDS OF ALL PROCESS CONTROL TESTING PERFORMED AND RELATED RESULTS MUST BE AVAILABLE
Rintracciabilità: deve essere disponibile la registrazione di tutte le prove di controllo processo e relativi risultati

APPROVED DEVIATIONS-RFVAs / Deviazioni-RFVA Approvate
RFVA 402431

QUALIFICATION REPORT No. / Rapporto di Qualifica N° RAPPORTO 02/22 REV.1 & RAPPORTO 03/22 – REV.1 (RAPPORTO 01/22, 02/22, 03/22 del 03/05/2022)	QUALIFICATION REPORT DATE / Data Rapporto di Qualifica 24/04/2024
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DQP INITIAL VALIDITY DATE Data inizio validità DQP	05/05/2022	DQP VALIDITY Validità DQP	3 Years	DQP EXPIRATION DATE Data Scadenza DQP	05/05/2025
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THIS DOCUMENT MUST BE DISPLAYED ON THE EQUIPMENT OR AS CLOSE AS POSSIBLE
Il presente documento deve essere esposto sugli impianti o nelle immediate vicinanze

Prepared By Preparato Da Campoli Daniele	Date Data 03/05/2024 09:54:56	Laboratory Responsible Responsabile di Laboratorio Folcarelli Vincenzo	Date Data 03/05/2024 14:02:19	QUALITY CONTROL MANAGER Responsabile Quality Control Mille Fabio	Date Data 10/05/2024 18:15:17
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PROCESS CONTROL TESTS AND INSPECTIONS TO BE PERFORMED	FREQUENCY	REFERENCE DOCUMENTS
Prove di Controllo Processo e Ispezioni da Eseguire	Frequenza	Documenti di Riferimento
INSTRUMENTS	QUARTERLY	AWPS001Q / AMS2750
TUS	MONTHLY	AWPS001Q / AMS2750
SAT	WEEKLY	AWPS001Q/AMS2750
HARDNESS CHECK	EACH LOT	AWPS004Q
TENSIL TEST	EACH LOT, WHEN APPLICABLE	AWPS007T
EFFICIENCY OF PROTECTIVE ATMOSPHERE	MONTHLY	AWPS007T
OIL QUENCHING	QUARTERLY	AWPS007T
METALLOGRAPHIC TESTS	EACH LOT, WHEN APPLICABLE	AWPS007T
REVISIONS / Revisioni		
Equipment change or relocation of one or more equipment (includes new equipment, equipment move and facility change) - QUALIFICATION AFTER TEST OF NEW HT OVENS (AWPS007T/03 AND AWPS007T/04)		
REMARKS / Note		
COMMODITY / Commodity		
HT		

Continued from page 1 / Segue da pagina 1

APPLICABLE SPECIFICATIONS AND REVISION NUMBER / Specifiche Applicabili e Relativo Stato di Revisione	
AWPS007T/05 - ACCIAI AD ALTA RESISTENZA E PER CUSCINET Rev.A	
AMS2750 - PYROMETRY Rev.G	
AMS-H-6875 - HEAT TREATMENT OF STEEL RAW MATERIALS Rev.C	
SAE AMS2769 - HEAT TREATMENT OF PARTS IN A VACUUM Rev.D	
AMS2759 - HEAT TREATMENT OF STEEL PARTS GENERAL REQUIREMENTS Rev.G	
AMS2759/1 - Rev.J	
AMS2759/3 - HEAT TREATMENT PRECIPITATION-HARDENING CORROSION-RESISTANT AND M Rev.J	
AMS2759/7 - CARBURIZING AND HEAT TREATMENT OF CARBURIZING GRADE STEEL PARTS Rev.E	
AMS2759/11 - STRESS RELIEF OF STEEL PARTS Rev.A	
SAE AMS2773 - HEAT TREATMENT CAST NICKEL ALLOY AND COBALT ALLOY PARTS Rev.F	
AWPS007T - HEAT TREATMENT OF STEELS Rev.D	
AWPS007T/01 - GENERAL REQUIREMENTS Rev.B	
AWPS007T/02 - CARBON AND LOW ALLOY STEEL Rev.B	
AWPS007T/03 - ACCIAI INOSSIDABILI(SERIE 300 E 400) Rev.A	
AWPS007T/04 - ACCIAI INDURENTI PER PRECIPITAZIONE E MA Rev.A	
AMS2759/2 - HEAT TREATMENT OF LOW-ALLOY STEEL PARTS MINIMUM TENSILE STRENGTH Rev.K	
AMS2759/4 - HEAT TREATMENT OF AUSTENITIC CORROSION-RESISTANT STEEL PARTS Rev.D	
AMS2759/6 - GAS NITRIDING AND HEAT TREATMENT OF LOW-ALLOY STEEL PARTS Rev.C	
SAE AMS2774 - HEAT TREATMENT NICKEL ALLOY AND COBALT ALLOY PARTS Rev.G	
AMS2759/5 - HEAT TREATMENT MARTENSITIC CORROSION-RESISTANT STEEL PARTS Rev.F	
ASSIGNED PERSONNEL / Personale addetto	INSPECTORS / NDT Personnel / Controllori