BELDEN universal	ISSUED 10/11/2022
Document No.: ASF742-1-AMS QQP 416-MOD	Revision: L
Document Title: CAD Plating Supplemental	Rev Date: 10/4/2022
Approval: CMCB	Created: 10/27/14

Rev	Date	Rev description
C	9/1/15	Added Finish choices
D	10/4/16	MIL CAD scrubbing process
E	10/18/16	Added reference BEL-QS-0004
F	1/9/18	Adding hub plating thickness requirements
G	2/6/18	Adding inspection report requirement
H	4/27/18	Removing address from header; Removing inspection reporting requirement for hub plating thickness; updated footer.
I	11/2/2018	Removed Finish section; adding requirements for MPI, notch bar handling, packaging and handling of plated parts, plating thickness certification and inspection reporting requirements
J	1/29/2019	Revising inspection frequency and location; added Hydrogen embrittlement reporting requirements
K	3/16/2020	Revised plating inspection requirements to be more general for all plated components
L	10/4/2022	REVISED FORMAT TO MAKE IT EASIER TO COPY INTO SYSPRO PO ENTRY COMMENT SECTION

PURCHASE ORDER INFORMATION

Process per attached print for class and type.

1. PLEASE NOTE: HT SCALE TO BE REMOVED PRIOR TO PLATING [ADD THIS NOTE ONLY FOR PARTS when part was induction hardened by IHT SINCE THEY DO NOT DESCALE PARTS]
2. POST-BAKE HYDROGEN EMBRITTLEMENT RELIEF: For HRc 33 and above – 375 degrees F +/-25 degrees F for 46 hr minimum
3. NON-DESTRUCTIVE TESTING – as specified on drawing
4. Lot traceability must be maintained.
5. PLATING APPEARANCE - Acceptable plating appearance in accordance with BEL-QS-0004. Refer to Belden's website for details at http://www.beldenuniversal.com/about/quality-assurance/suppliers
6. PACKAGING AND HANDLING - Plated parts must be returned to Belden packaged in such a manner that protects the integrity of the plating.

INSPECTION REPORT REQUIREMENTS

7. PROCESS CERTIFICATION
8. [ADD NON-STOCKED LINE ON PO- REVIEW SYSPRO BOM FOR TRIGGER] HE REPORT – Applicable monthly tank hydrogen embrittlement test report or test report for notch bars run with the order to be provided when available as required per SAE AMS-QQ-P-416.
    1. In instances of failed hydrogen embrittlement tests, the supplier shall be liable for rework (stripping and re-plating) and expediting costs.
9. THICKNESS INSPECTION REPORT
    1. Inspection frequency – per SAE-AMS-QQ-P-416 or four samples; whichever sample size is greater.
    2. Measurement Technique – ASTM B659 if specified on drawing or default to SAE-AMS-QQ-P-416
    3. ADD THIS NOTE ONLY For MIL spec yokes and derivatives ONLY: Plating thickness to be measured in locations 3, 4, and 5. Average thickness will not be acceptable. Any thickness reading outside of drawing requirements shall be cause for rejection. Refer to Belden's website for details at http://www.beldenuniversal.com/about/quality-assurance/suppliers. Contact Belden if part geometry prohibits plating thickness inspection when required.