



AEROSPACE STANDARD	AS7112™/1	REV. A
	Issued	1997-12
	Cancelled	2017-06
Superseded by PRI AC7112/1		
National Aerospace and Defense Contractors Accreditation Program Hose Manufacturing Requirements		

RATIONALE

AS7112/1A is being cancelled and superseded by PRI AC7112/1.

CANCELLATION NOTICE

This document has been declared "CANCELLED" as of June 2017 and has been superseded by PRI AC7112/1. By this action, this document will remain listed in the Numerical Section of the Aerospace Standards Index noting that it is superseded by PRI AC7112/1. Cancelled specifications are available from SAE.

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1. SCOPE:

This Aerospace Standard (AS) is to be used as a supplement to SAE AS7112. In addition to the requirements contained in AS7112, the requirements contained herein shall apply to suppliers seeking NADCAP Fluid System Components Accreditation for Hose Manufacturer.

Hose may be manufactured as a "Qualified" end item (bulk) or to be qualified as part of an assembly. The corresponding PRI Audit Criteria (AC) is to be applied to ensure the hose is manufactured to the applicable specification(s) and standard(s).

2. REFERENCES:

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AS7112 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Fluid System Components Manufacturing Requirements

2.2 PRI Publications:

Available from Performance Review Institute, 161 Thornhill Road, Warrendale, PA 15086-7527.

AC7112 National Aerospace and Defense Contractors Accreditation Program (NADCAP) - Fluid System Components Manufacturing Requirements

---- NADCAP Fastener Manufacturing Auditor Handbook

2.3 Definitions:

CP: Chemical Processing

GQS: General Quality Systems

HT: Heat Treating

MTL: Materials Testing Laboratories

NDT: Nondestructive testing

WLD: Welding

PROCEDURE: A written document under document control that defines "how-to" implement company policy. Procedures may reference supporting documents that meet this criteria.

3. PTFE INNER EXTRUSION HOSE:

3.1 General:

3.1.1 There shall be a properly identified and referenced procedure to manufacture.

3.1.2 Equipment shall be defined.

3.1.3 Equipment shall be on suitable maintenance schedule.

3.1.4 Instrumentation shall be defined.

3.1.5 Instrumentation shall be on a verifiable calibration schedule.

3.1.6 MSDs shall be on file.

3.2 Raw Material Procedure:

3.2.1 There shall be a properly identified and referenced procurement specification for PTFE that identifies the following:

- a. Lot identification and lot control
- b. Handling precautions
- c. Refrigeration for storage

3.2.2 Requirements for certification by supplier shall be established for:

- a. Particle size distribution
- b. Rheometer pressure
- c. Bulk density.
- d. Standard specific gravity

3.2.3 Requirements for incoming verification shall be established, including:

- a. Packaging
- b. Labeling and identification
- c. Verification of moisture content checked and recorded

3.2.4 Lubricant shall comply with the following:

- a. There shall be a properly identified and referenced procurement specification.
- b. The lubricant shall be received with certifications of conformance to specification.
- c. There shall be a procedure for storage and handling of volatile lubricants. This procedure shall be available in the work area.

3.2.5 Carbon shall comply with the following:

- a. There shall be a properly identified and reference procurement specification.
- b. The material received with certifications of conformance to specification.
- c. There shall be a procedure for handling and storage of carbon. This procedure shall be available in the work area.

3.3 Compounding and Blending:

3.3.1 There shall be a written procedure for compounding, blending and storing blended powder.

3.3.2 The compounding room shall be refrigerated, controlled, and calibrated.

3.3.3 There shall be guidelines for storage and handling of PTFE prior to blending.

3.3.4 There shall be procedures for screening of PTFE in blending.

3.3.5 "Age" limits shall be established for resin, blend preforms, etc., and appropriate records shall be maintained.

3.3.6 Dispensing equipment shall be calibrated and records of calibrations shall be maintained.

3.3.7 Blending time and speed shall specified and monitored.

3.3.8 There shall be adequate cleaning of equipment to eliminate "overworked" particles of PTFE.

3.3.9 "Overage" material shall be properly dispositioned.