



Peeling Coatings

Supplier Bulletin

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F-35 Supplier Quality Engineer
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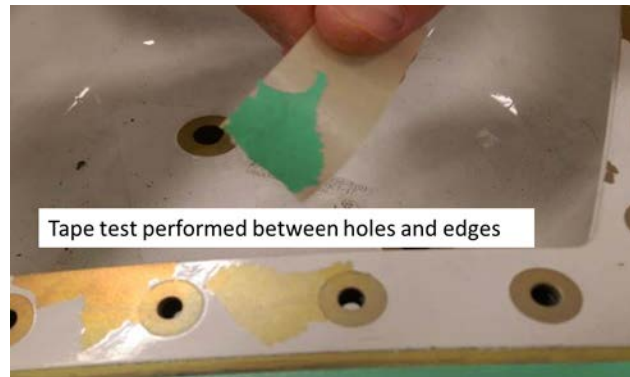
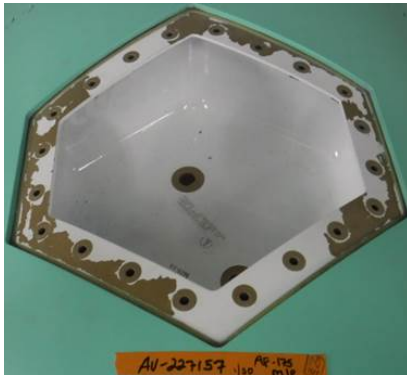
Document Change History

Revision	Description of Revision/Change	Date
Original Issue	Original release	Mar 15, 2018



Dear Valued Supplier,

We continue to be plagued with primer/topcoat adhesion failures on our production line. In 2017 we sent representatives from our Materials and Processes engineering team along with an auditor from the NGC Quality team to finish houses that delivered parts that subsequently exhibited primer adhesion failures. We had requested information from you regarding what finish houses your parts were processed at and you provided us the feedback to drive these audits.



The findings from those audits included, but were not limited to, the following process violations:

- An anodized part surface failed a required water break test and the supplier technician failed to recognize the failure
 - Test failure indicates surface contaminants have not been fully removed.
- The supplier technician attempted to clean the surface using an acetone wipe
 - An incorrect wiping technique was observed
 - NGC M&P had to instruct the technician on proper part cleaning technique
- A dry tape test was performed by a supplier technician on a primed aluminum part
 - The test was not performed correctly
 - Dwell time was not being followed – the tape was not left adhered to the part surface for the required 60-120 second dwell time
 - The same piece of tape was used for multiple tests
 - NGC M&P had to instruct the technician on proper tape test procedures
 - Some parts failed the tape test when it was performed properly

We have been issuing SCAR's for these failures and are receiving pushback stating that the tape test was performed. When we perform a proper tape test on suspect parts



using the proper procedures, the parts fail the test, indicating to us that the proper test procedure may not have been used by the finish supplier.

We recommend that you begin performing verification tape testing on parts yourself after they have been finished by your sub-tier suppliers, at least on a random sampling basis, to confirm that your finish supplier is following proper adhesion verification procedures. Refer to specification LMA-PJ264, Application and Control of Organic Finishes, for tape testing requirements.

We will be sending our audit team out again to the paint houses that we are seeing failures from but our audit is only a point in time so we ask you to do your part in ensuring your paint houses provide consistently compliant part finishes.

Sincerely,

Troy Conwell
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