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Indice delle revisioni / Revision history

Rev.	Data / Date	Descrizione modifica / Change description
0	08/02/2021	Basic release / Prima emissione
1	06/07/2021	Added the Welding/Additive Manuf. Commodity that was missing / Aggiunta la commodity Welding/Additive Manuf. che mancava
2	26/07/2021	Added AMP for AMS2410 & Technospring per SI 02 018. Suppliers already approved were missing from the list / Aggiunto AMP per AMS 2410 & Technospring per SI 02 018. Fornitori già approvati erano mancanti dalla lista.
3	09/11/2021	Added 3F stampi 0045Z3 in lieu of 3F EDM Sevice 0045Z2/ Aggiunto 3F Stampi con codice 004533 al posto di 3F EDM Sevice 0045Z2
4	01/12/2021	Corrected list of special processes allowed to Coproma Sud. Added HPF, Pietro Rosa, Fucine Umbre, SIFCO and ATI for the MPI and HT on forging. Added the commodity of Forging as special process/ Corretta la lista di processi speciali ammessa per Coproma Sud. Aggiunti HPF, Pietro Rosa, Fucine Umbre, SIFCO and ATI per gli MPI e HT sui forgiati. Aggiunta la commodity di forgiatura come processo speciale
5	30/12/2021	Added Elettrostamperie Poppi as supplier historically qualified for upset forging and for UT on upset forged parts / Aggiunto Elettrostamperie Poppi come fornitore storicamente qualificato per elettroricalcature e controlli UT su elettroricalcati
6	28/03/2022	Aggiunti i fornitori/processi speciali approvati per la supply chain Umbragroup
7	31/03/2022	Aggiunto FUCINE UMBRE per trattamento termico pere AMS 2770
8	11/04/2022	Aggiunto Pietro Rosa per il processo di forgiatura e ricottura secondo SI020021. Aggiunto Tecnomeccanica nella colonna "used by UG subtiers".

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9	30/05/2022	Aggiunto HPF per il processo di ispezione con particelle magnetiche in accordo alla SI 08 023.
10	31/05/2022	Aggiunto GILLIS AEROSPACE per il processo di ispezione dell'attacco acido di sfere in 440C in accordo alla AMS2649.
11	03/08/2022	Aggiunti: SAFEL come fornitore approvato SAFRAN per saldatura laser.
12	19/09/2022	Aggiunto fornitore Pietro Rosa TMB per il processo di Ispezione Magnetica secondo SI 08 023.
13	27/09/2022	Aggiunto fornitore ATI ZKM Forging per SI 08 023 e AMS-2761.
14	18/11/2022	Aggiunti SCI per NDT (Ecrimesa) ed TTT per TT (Ecrimesa)
15	04/01/2023	Aggiunto T.T.N. come fornitore di trattamenti termici (Merletti) Aggiunto Bytest per analisi metallografiche (Mecal/OM4) Aggito Mecal nella colonna "d by UG subtier"
16	15/02/2023	Aggiunte specifiche Collins Aerospace 915-010-004 e HTS-84 nella capability di GRTT (Approvazione cliente n. 182674).
17	22/02/2023	Aggiunto fornitore O.m.p.m. srl come approvato per riporto di Zi-Ni secondo AMS2417 e ispezione magnetica secondo ASTM E1444.
18	02/03/2023	Aggiunto AMP per Nichelatura per AMS2404
19	04/04/2023	Aggiunto G&O SPRING per trattamenti termici e passivazione molle
20	26/04/2023	Aggiunto CENTRO TECNOLOGICO DE MIRANDA DE EBRO come fornitore di ECRIMESA per i controlli NDT
21	17/07/2023	Aggiunto GALVER per controlli NDT
22	11/10/2023	Aggiunto GRTT per AMS 2759/7
23	Intestazione / Header	Aggiunto Elettrostamperie Poppi per Ispezione Magnetica su elettrocalcati secondo EN 10228-1. Aggiunto Bodycote Neully en Thelle per trattamento termico secondo AMS 2759. Aggiunto Controrem per Ispezione magnetica secondo ASTM E1444.



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Legend:

CATEGORY 1=ALL SPECIAL PROCESSES SPECIFIED BY INTERNATIONAL STANDARD (MIL, AMS, ASTM, EN, ETC...) THAT ARE IN THE SCOPE OF THE NADCAP APPROVAL. SUBJECT TO OTHER PARTY (OP) SURVEILLANCE (NADCAP) ACCORDING TO AMC No 2 to 21.A.139(b)(1)(ii)

CATEGORY 2=SPECIAL PROCESSES SPECIFIED BY UMBRAGROUP INTERNAL SPECIFICATIONS

CATEGORY 3= SPECIAL PROCESSES SPECIFIED BY UMBRAGROUP'S CUSTOMER AND/OR DESIGN HOLDER SPECIFICATIONS. SUBJECT TO CUSTOMER AND/OR DESIGN HOLDER SURVEILLANCE

UMBRA GROUP'S SUPPLIER CAN ONLY USE THE SOURCES LISTED HEREIN FOR PROCESSES OF CATEGORY 1,2 & 3



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					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
TRATTAMENTI TERMICI	ADVANCED HEAT TREAT.	0045A5	USA	NADCAP	ION NITRIDING	AMS2759/8		WOODWARD 9U9346
	GRTT		Italy	NADCAP	BONIFICA PRECIPITAZIONE	AMS 2759/1 AMS 2759/2 AMS2759/3 AMS2759/7 AMS-H-6875		Collins Aerospace 915-010-004 e HTS-84
	T.A.G. SRL	0045B2	Italy	NADCAP	HT TITANIUM	AMS-T-9047		
				NADCAP	ION NITRIDING		SO 02 012	
				NADCAP	BONIFICA	AMS 2759		
	HIGH TECHNOLOGY CENTER SPA	004587	Italy	NADCAP	BON S.VUOT		SO 02 231	
	TECHNOSPING	001301	Italy	NADCAP	TRATTAMENTO TERMICO MOLLE		SI 02 018	
	G&O SPRING	00645I	Italy	NADCAP	TRATTAMENTO TERMICO MOLLE	AMS 2759/3		
FUCINE UMBRE	005105	Italy	NADCAP	NORM., SOLUB. & TEMPER (solo su forgiati)	AMS2759/1/3/7			

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				NADCAP	NORMALIZZAZIONE (solo su forgiati)	AMS-H-6875* *superseeds MIL-H-6875		
				NADCAP	TT ALLUMINIO	AMS 2770		
HPF	005133	Italy		NADCAP	RICOTTURA CRONIDUR (solo su forgiati)	AMS2759	SI 02 007	
PIETRO ROSA TBM	005130	Italy		NADCAP	RICOTTURA CRONIDUR (solo su forgiati)		SI 02 007 SI 02 021	7905420 LINEAR MOTION 79030010QPL
SIFCO	005117	USA		NADCAP	NORMALIZZAZIONE (solo su forgiati)	AMS-H-6875* *superseeds MIL-H-6875 AMS 2761		
ATI ZKM Forging Sp. z o.o.	005125	Poland		NADCAP	NORMALIZZAZIONE (solo su forgiati)	AMS2759/7 AMS2759/1 AMS-H-6875* *superseeds MIL-H-6875 AMS 2761		
TRATTAMINETOS TERMICOS TTT S.A	N/A	Spain		NADCAP	PRECIPITAZIONE (su microfusioni)	AMS2759/3		
T.T.N. SPA	0045E9	Italy		NADCAP	PRECIPITAZIONE	AMS2759/3		



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	Bodycote Neully en Thelle	N/A	France	Nadcap	Hardening & Tempering (Only on bearing rings)	AMS 2759		
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Commodity	Supplier Name	Supplier Code	Country	NADCAP Approved	Scope of Approval			
					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
PROCESSI CHIMICI	GALVANICA CEDRATESE	000319	Italy	NADCAP	PASSIVAZIONE	AMS2700		
				NADCAP	CONV. CHIMICA ALLUMINIO	MIL-DTL-5541		
				NADCAP	PAINTING	MIL-DTL-18264 MIL-PRF-85582 MIL-PRF-85285		
	FUCINE UMBRE	005105	Italy	NADCAP	PASSIVAZIONE	AMS2700		
				NADCAP	CONV. CHIMICA ALLUMINIO	MIL-DTL-5541		
				NADCAP	PAINTING	MIL-DTL-18264 MIL-PRF-85582 MIL-PRF-85285		
	COPROMA SUD	0045H8	Italy	NADCAP	PASSIVAZIONE	AMS2700		
	GALVAIR	N/A	Italy	NADCAP	OSSIDAZIONE NERA	MIL-DTL-13924		

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	MODERTECH INDUSTRIES	0045D1	FRANCE	NADCAP	PASSIVAZIONE			SAFRAN 3300257388
	O.m.p.m. srl	N/A	Italy	NADCAP	Zi-Ni Plating	AMS 2417		
	G&O SPRING	00645I	Italy	NADCAP	PASSIVATION	AMS 2700		
	ALL METAL PROCESSING	001306	USA	NADCAP	Ti-CAD PLATING	AMS2419-5		
NADCAP				NICHEL PLATING	AMS2404			
NADCAP				SILVER PLATING	AMS2410			



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					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
NDT	COPROMA SUD	0045H8	Italy	NADCAP	MPI	ASTM E1444	SI 08 023	
					LPI	ASTM E1417	SI 08 049	
	BYTEST	002051	Italy	NO	ETCH INSPECTION	AMS2649	SI 08 119	
				NADCAP	MPI	ASTM E1444		
	FUCINE UMBRE	005105	Italy	NADCAP	MPI	ASTM E1444 *supersedes AMS2640	SI 08 023	
				NADCAP	LPI	ASTM E1417		
	GALVANICA CEDRATESE	000319	Italy	NADCAP	MPI	ASTM E1444		
				NADCAP	LPI	ASTM E1417		
	HPF	005133	Italy	NO	MPI (solo su forgiati)	ASTM E1444	SI 08 023	
	PIETRO ROSA TBM	005130	Italy	NADCAP	MPI (solo su forgiati)	ASTM E1444	SI 08 023	



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SIFCO	005117	USA	NADCAP	MPI (solo su forgiati)	ASTM E1444* *superseeds AMS2640	SI 08 023	
ATI ZKM Forging Sp. z o.o.	005125	Poland	NADCAP	MPI (solo su forgiati)	ASTM E1444	SI 08 023	
ELETTROSTAMPERIE POPPI	004521	Italy	NO	UT (solo su elettropicalcati)	EN-10228-3		
				MPI (solo su elettropicalcati)	EN 10228-1		
O.m.p.m. srl	N/A	Italy	NADCAP	MPI	ASTM E1444		
GALVER	N/A	Italy	NADCAP	MPI	ASTM E1444		
SERVICIO de CONTROL e INSPECTION S.A. (SCI)	N/A	Spain	NADCAP	ANALISI RX	ASTM E 1742		
CENTRO TECNOLOGICO DE MIRANDA DE EBRO	N/A	Spain	NADCAP	LPI	MIL-STD-6866		
GILLIS AEROSPACE	006474	France	NO	ETCH INSPECTION	AMS2649		
CONTROREM	N/A	France	Nadcap	MPI	ASTM E1444		



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					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
FORGING	HPF	005133	Italy	NO	FORGING	AMS 6400 AMS-F-7190* *superseded MIL-F-7190	SI 02 007	
	PIETRO ROSA	005130	Italy	NO	FORGING	AMS 6400 AMS-F-7190*	SI 02 007 SI 02 021	7905420 LINEAR MOTION 79030010QPL
	FUCINE UMBRE	005105	Italy	NO	FORGING	AMS 6400 AMS-F-7190* *superseded MIL-F-7190		
	SIFCO	005117	USA	NO	FORGING	AMS-F-7190* *superseded MIL-F-7190		
	ATI ZKM Forging Sp. z o.o.	005125	Poland	NO	FORGING	AMS-F-7190 *superseded MIL-F-7190		
	ELETTROSTAMPERIE POPPI	004521	Italy	NO	UPSET FORGING		SI 02 010 SI 02 012 SI 02 014 SI 02 021	7905420 LINEAR MOTION 79030010QPL

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					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3	
NON CONVENT. MACH.	3F STAMPI	0045Z3	Italy	NADCAP	EDM		SI 01 003	PARKER BPS4706	NO

Commodity	Supplier Name	Supplier Code	Country	NADCAP Approved	Scope of Approval				USED BY UG SUBTIERS
					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3	
SURFACE ENHANCEMENTS	A. ABETE SRL	00450A	Italy	NADCAP	SHOT PEENING			BOEING BAC5730	NO



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					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
WELDING	BEAM - IT	006467	Italy	NADCAP	ADDITIVE MAN.	TBD	/	/
	SAFEL	N/A	FRANCE	NADCAP	LASER WELDING			SAFRAN 3300522541

Commodity	Supplier Name	Supplier Code	Country	NADCAP Approved	Scope of Approval			
					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
COATING	STS	004541	Italy	NO	PVD		SI 02 016 processi APX0004 (IAW I-07.4/13 n1) & APX0005 (IAW I-07.4/13 o1)	
	OERLIKON UK	0045F2	UK	NO	PVD			GOODRICH 914-038-034



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								914-038-033
	HIGH TECHNOLOGY CENTAR SPA	004587	Italy	NADCAP	HVOF		SI 02 015	
	DICRONITE UTE POHL GMBH	0045H9	Germany	NO	DICRONITE	AMS2530		

Commodity	Supplier Name	Supplier Code	Country	NADCAP Approved	Scope of Approval			
					Process	CATEGORY 1	CATEGORY 2	CATEGORY 3
TESTING LABORATORIES	FUCINE UMBRE	005105	Italy	NADCAP	DUREZZA	ASTM E18	SI 08 117	
				N/A	CONDUCIBILITA' ELETRTICA ALLUMINIO		SI 08 117	
	BYTEST	002051	Italy	NADCAP	TRAZIONE	ASTM E8		
				NADCAP	DUREZZA	ASTM E18	SI 08 117	
				NADCAP	METALLOGRAFIA		SI 08 089	
	AQM	002056	Italy	NADCAP	DUREZZA	ASTM E18 ASTM E10 ASTM E92		