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A001 . Issuance and Applicability

HQ Control: 05/06/2022

HQ Revision: 05f

a. These operations specifications are issued to Ace Precision Machining Corp., a Repair Station located in the United States, pursuant to 14 CFR Part 145, § 145.53(a). The repair station certificate holder shall conduct operations in accordance with 14 CFR Part 145 and these operations specifications.

The certificate holder's address:

Fixed Location:
W146 N5714 Enterprise Avenue
Menomonee falls, Wisconsin 53051

b. The holder of these operations specifications is the holder of certificate number QAPR054K and shall hereafter be referred to as the "certificate holder".

c. These operations specifications are issued as part of this repair station certificate and are in effect as of the date approval is effective. This certificate and these operations specifications shall remain in effect until the certificate for a repair station that is located in the United States is surrendered, suspended, or revoked.

d. The repair station specified on these operations specifications performs maintenance and/or an alteration of aircraft and/or aeronautical products under a Bilateral Aviation Safety Agreement (BASA).

e. The certificate holder is authorized to use only the business name which appears on the certificate to conduct the operations described in subparagraph a.

1. Issued by the Federal Aviation Administration.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 8/8/2022, [2] AMENDMENT #: 8
DATE: 2022.08.08 08:48:34 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Handwritten signature of Allen Schneider in black ink.

Allen Schneider, Quality Manager

8-08-2022

Date

A002 . Definitions and Abbreviations

HQ Control: 12/14/2017

HQ Revision: 05d

Unless otherwise defined in these operations specifications, all words, phrases, definitions, and abbreviations have identical meanings to those used in 14 CFR and 49 U.S.C., as cited in Public Law 103-272, as amended. Additionally, the definitions listed below are applicable to operations conducted in accordance with these operations specifications.

BASA	The Bilateral Aviation Safety Agreement (BASA) is an executive agreement concluded between the United States and a foreign country for the purpose of promoting aviation safety; also known as an Agreement for the Promotion of Aviation Safety.
Certificate Holder	In these operations specifications, the term "certificate holder" means the holder of the repair station certificate described in these operations specifications in Part A paragraph A001 and any of its officers, employees, or agents used in the conduct of operations under this certificate.
CAAS	Civil Aviation Authority of Singapore
CFR	Code of Federal Regulations
Class Rating	As used with respect to the certification, ratings, privileges of airframes, powerplants, propellers, radios, instruments, and accessories within a category having similar operating characteristics.
EASA	European Aviation Safety Agency
EASA Accountable Manager	The manager who has corporate authority for ensuring that all maintenance required by the customer can be financed and carried out to the standard required by the EASA full-member Authority.
EU	European Union
Exemption	An authorization that permits an alternate means of compliance with a specific CFR. The exemption must meet the procedural requirements of 14 CFR Part 11.
FOCA	Federal Office of Civil Aviation
FAA Accountable Manager	A person designated by the certificated repair station who is responsible for and has authority over all repair station operations that are conducted under 14 CFR Part 145, including ensuring that the repair station's personnel follow the regulations and serving as the primary contact with the FAA.

Geographic Authorization	Authorization provided to a repair station located outside the United States to perform maintenance support under contract for a U.S. air carrier (or an operator of U.S.- registered aircraft under 14 CFR Part 129) at a location other than the repair station's main facility. A geographic authorization is issued by the FAA to respond to a U.S. air carrier's or Part 129 foreign operator's need for maintenance at a station where the frequency and scope of that maintenance does not warrant permanently staffing and equipping the station for its accomplishment.
Limited Rating	A rating issued to repair stations for the performance of maintenance on particular makes and models of airframes, powerplants, propellers, radios, instruments, accessories, and/or parts.
Limited Ratings - Specialized Services	Rating issued for a special maintenance function when the function is performed in accordance with a specification approved by the Administrator.
Line Maintenance	Any unscheduled maintenance resulting from unforeseen events, or scheduled checks where certain servicing and/or inspections do not require specialized training, equipment, or facilities.
MAG	The Maintenance Annex Guidance (MAG) defines the process that the FAA and EASA undertake in the inspection, findings of compliance certification, and monitoring of repair stations, as well as their joint cooperation in quality assurance and standardization activities in support of the EASA Agreement, Annex 2, Maintenance. The term Maintenance Agreement Guidance (MAG) defines the processes and activities applicable to a specific country under an MIP, and is not associated with the EASA Agreement.
Maintenance	The inspection, overhaul, repair, preservation, and replacement of parts, but excludes preventive maintenance.
U.S./EU Aviation Safety Agreement, Annex 2, Maintenance	Annex 2 covers the reciprocal acceptance of findings of compliance, approvals, documentation and technical assistance regarding approvals and the monitoring of repair stations/maintenance organizations.
MIP	Maintenance Implementation Procedures (MIP) are procedures for implementing the provisions of a BASA that apply to maintenance performed under 14 CFR Part 145, Section 145.53(b).
MOE	A maintenance organization exposition (MOE) pertains to procedural manuals used by maintenance organizations certificated by a foreign country. The MOE along with the FAA Supplement, sets forth the structure and procedures of the repair station to meet the requirements of 14 CFR Part 145 under a MIP.

Preventive Maintenance	As defined in 14 CFR part 1 and part 43 appendix A, subparagraph (c).
QCM	Quality Control Manual
Repair Station located in the United States	A FAA certificated repair station located in the United States.
Repair Station located outside the United States	A FAA certificated repair station located outside of the United States.
RSM	Repair Station Manual

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1. Issued by the Federal Aviation Administration.
 2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 2/21/2020, [2] AMENDMENT #: 8
DATE: 2020.02.21 07:09:17 -06:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Michael J Peterson

2-21-2020

Michael J Peterson, Quality Engineer

Date

A003 . Ratings and Limitations

HQ Control: 04/03/2017

HQ Revision: 01a

The certificate holder is authorized the following Ratings and/or Limitations:

Class Ratings

None Authorized

Limited Ratings

<u>Rating</u>	<u>Manufacturer</u>	<u>Make/Model</u>	<u>Limitations</u>
PowerPlant	Honeywell	TFE731 Series.	As listed on the accepted Capabilities List as amended.
	Honeywell	TPE331 Series.	As listed on the accepted Capabilities List as amended.
	Pratt-Whitney	PT6A-65 & 67 Series.	As listed on the accepted Capabilities List as amended.
	Rolls-Royce	AE3007 A & C Series	As listed on the accepted Capabilities List as Amended.
	Rolls- Royce	Trent 900 Series	As listed on the accepted Capabilities List as Amended.
Accessories	Honeywell	GTCP 36, 85, 331, 660 and 700 Series APU's.	As listed on the accepted Capabilities List as amended.
	Honeywell	GTCP 131-9 Series APU's.	As listed on the accepted Capabilities List as amended.
	Honeywell	RE220 APU's	As listed on the accepted Capabilities List as amended.
	Hamilton Sundstrand	Gemini, T-20G Series APU's.	As listed on the accepted Capabilities List as amended.
	Hamilton	APS 500, T-40 Series APU's.	As listed on the accepted Capabilities

<u>Rating</u>	<u>Manufacturer</u>	<u>Make/Model</u>	<u>Limitations</u>
	Sundstrand		List as amended.
	Hamilton Sundstrand	APS 3200	As listed on the accepted Capabilities List as amended.
	Honeywell	RE100 APU's	As listed on the accepted Capabilities List as amended.

Limited Ratings - Specialized Services

<u>Rating</u>	<u>Specifications</u>	<u>Limitations</u>
Non Destructive Inspection	Liquid Penetrant. In accordance with ASTM E-1417.	Or as otherwise specified by the manufacturer's procedures. See Note 1.
Electron Beam Welding	In accordance with AMS 2681, latest revision.	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Heat Treating.	In accordance with Honeywell specification HT 5088,	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Pressure Testing.	In accordance with Honeywell specification EMS 52310.	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Brazing	In accordance with Honeywell specification WBS 5027	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Plasma Spray Coating.	In accordance with Honeywell specification EMS 52432.	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Fusion Welding	In accordance with AWS D17.1, latest revision.	Or as otherwise specified by the manufacturer's procedures. See note 2.
Resistance Welding	In Accordance with AWS D17.2, latest revision.	Or as otherwise specified by the manufacturer's procedures. See Note 2.
Non-Conventional Machining	In accordance with Honeywell specifications 91547-P6063, EMS52571 and EMS52572	Or as otherwise specified by the manufacturer's procedures. See note 2.

Note 1. N.D.I. will be conducted in accordance with the referenced standard. The inspection mediums used may be more sensitive than specified by the manufacturer, but under no circumstances, less sensitive.

Note 2. The following applies and must be observed regarding any and all Specialized Service ratings. 1. Subcontracting as a whole and/or a portion of the service is not authorized. 2.

Overhauls of any kind shall not be permitted under this rating.

1. The Certificate Holder applies for the Operations in this paragraph.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 5/19/2020, [2] AMENDMENT #: 20
DATE: 2020.05.19 10:11:21 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Handwritten signature of Allen Schneider in black ink.

Allen Schneider, Quality Manager

Handwritten date "5/19/20" in black ink.

Date

A004 . Summary of Special Authorizations and Limitations

HQ Control: 09/23/1998

HQ Revision: 010

a. The certificate holder, in accordance with the reference paragraphs, is authorized to:

	Reference Paragraphs
Use an acceptable electronic recordkeeping system, electronic/digital signature, and/or electronic media.	A025
Perform work, including continuous operations, at additional locations other than at its primary fixed location.	A101
Perform safety-sensitive functions requiring a drug and alcohol testing program under 14 CFR part 120	A449

b. The certificate holder is *not authorized and shall not:*

	Reference Paragraphs
Use Exemptions.	A005
Perform maintenance with ratings for repair stations located outside the United States under a Bilateral Aviation Safety Agreement with Maintenance Provisions.	A060
Perform maintenance in accordance with foreign repair station geographic authorizations.	B050
Perform work, excluding continuous operations, at additional locations other than at its primary Fixed Location.	D100
Perform line maintenance for cert. holders conducting operations under Parts 121 and 135 and for foreign carriers/persons operating non-U.S.-registered aircraft in common carriage under Part 129, apart from D100 which authorizes that work away from station.	D107

1. Issued by the Federal Aviation Administration.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 8/3/2022, [2] AMENDMENT #: 12
DATE: 2022.08.03 09:56:31 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

A. Schneider

8-03-2022

Allen Schneider, Quality Manager

Date

A007 . Designated Persons

HQ Control: 09/08/2021

HQ Revision: 03a

a. The personnel listed in the following table are designated to officially apply for and receive operations specifications for the certificate holder indicated below.

Table 1 – Designated Persons to Apply for and Receive Authorizations

Title	Name	Parts Authorized	Email Address
Vice President of Engineering and Quality	Choy, Diana	A	diana.choy@aceprecision.com
Quality Manager	Schneider, Allen	A	allen.schneider@aceprecision.com
Vice President of Operations	Eubanks, Sheri	A	Sheri.eubanks@aceprecision.com
Vice President of Supply Chain	Mack, Stacey	A	Stacey.mack@aceprecision.com

b. The following personnel listed in Table 2 are designated by the certificate holder to receive Information for Operators (InFO) messages for the certificate holder as indicated below. A receipt for the information by an operator or person is not required.

Table 2 – Designated to Receive InFO Messages

Name	Email Address	Telephone No.	Type of Information to Receive
Schneider, Allen	allen.schneider@aceprecision.com	262-252-4003	ALL
Choy, Diana	diana.choy@aceprecision.com	262-252-4003	ALL

1. Issued by the Federal Aviation Administration.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)

[1] EFFECTIVE DATE: 8/3/2022, [2] AMENDMENT #: 10

DATE: 2022.08.03 09:56:24 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Handwritten signature of Allen Schneider in black ink.

Allen Schneider, Quality Manager

Handwritten date "8-03-2022" in black ink.

Date

**A025 . Electronic/Digital Recordkeeping System,
Electronic/Digital Signature, and Electronic Media**

HQ Control: 04/03/2017

HQ Revision: 00b

a. The certificate holder is authorized to use an acceptable electronic/digital recordkeeping system, described and/or referenced in this paragraph (if none, enter N/A.)

Authorized to use those functions within the ACE Intranet to include the Enterprise Resource Planning and Calibration Management Software systems and referenced in Chapter 4 and 13 of the Repair Station manual and detailed in the Ace Precision Repair & Overhaul Database User Guide, DWI 9-16.643.

b. The certificate holder is authorized the use of the following electronic/digital signature procedures (if none, enter "N/A").

As identified in the Ace Precision Repair and Overhaul Database system. Reference Department Work Instruction number DWI 9-16.643, the Repair Station Manual Chapter 4, "Document Control" and Chapter 13, "Required Records and Record Keeping System".

c. The certificate holder is authorized to use electronic media for the repair station and quality control manuals, if acceptable (if none, enter "N/A").

"Read only" manuals are available to all repair station personnel via the ACE Intranet. Revision to be performed by Quality Manager or Designee only. Reference Chapter 4, "Document Control", of the Repair Station Manual.

1. Issued by the Federal Aviation Administration.

2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 2/21/2020, [2] AMENDMENT #: 5
DATE: 2020.02.21 07:34:33 -06:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Michael J. Peterson

2-21-2020

Michael J Peterson, Quality Engineer

Date

A101 . Additional Fixed Locations

HQ Control: 12/11/2020

HQ Revision: 01b

a. The certificate holder is authorized to perform work at the following additional fixed location(s) listed in Table 1 below, provided it has the facilities, materials, equipment, and technical personnel to perform the work authorized.

Table 1

Additional Location Address(es)				
Address	City	State	Country	Postal Code
977 Blue Ribbon Circle	Oconomowoc	Wisconsin	UNITED STATES	53066

b. This authorizes the certificate holder to use multiple locations to perform its operations under a single certificate.

c. With the exception of the provisions of subparagraph g below, this authorization does not constitute work performed at additional location(s) outside the domiciled country.

d. The certificate holder may perform continuous operations at the facilities listed in Table 1 above.

e. All the authorizations and exemptions authorized for the certificate holder apply at these locations, as applicable.

f. Repair stations located outside the United States covered by the U.S./European Union (EU)-Safety Agreement must be under the surveillance of an aviation authority (AA), hold a European Aviation Safety Agency (EASA) line station approval, and must be located within the EU Member States.

g. Repair stations with their principal place of business located within the United Kingdom of Great Britain and Northern Ireland (UK) operating under the Maintenance Implementation Procedures (MIP) are authorized additional fixed locations outside of the UK. The repair station must hold a UK Civil Aviation Authority (CAA) approval, be under direct surveillance by the UK CAA for that location, and must not be located within the United States.

The following Repair Station functions are performed at the Oconomowoc facility: raw material receiving, machining, expanding, wire EDM, electron beam welding, fusion welding, resistance welding, heat treatment and NDT. The "Ace Precision Organizational Chart" depicts the management and inspection personnel breakdown for this facility.

1. Issued by the Federal Aviation Administration.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 8/3/2022, [2] AMENDMENT #: 5
DATE: 2022.08.03 09:56:39 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Handwritten signature of Allen Schneider in black ink.

Allen Schneider, Quality Manager

8-03-2022

Date

A449 . Drug and Alcohol Testing Program

HQ Control: 08/30/2021

HQ Revision: 00b

- a. The 14 CFR Part 145 repair station certificate holder has implemented a drug and alcohol testing program because the certificate holder performs safety-sensitive functions for a 14 CFR Part 121, 121/135, and/or 135 certificate holder, and/or for a 14 CFR Part 91 operator conducting operations under § 91.147.
- b. The certificate holder certifies that it will comply with the requirements of 14 CFR Part 120 and 49 CFR Part 40 for its drug and alcohol testing program.
- c. Drug and alcohol testing program records are maintained and available for inspection by the FAA's Drug Abatement Compliance and Enforcement Inspectors at the location listed in Table 1 below:

Table 1

Location & Telephone of Drug and Alcohol Testing Program Records	
Telephone Number:	A1 (262) 252-4003
Address:	W146 N5714 Enterprise Avenue
Address:	
City:	Menomonee Falls
State:	WI
Zip code:	53051

d. Limitations and Provisions.

(1) The FAA's Drug Abatement Division is responsible for oversight and enforcement of the DOT/FAA-mandated drug and alcohol testing program. Questions regarding the program requirements or regulations must be directed to the Drug Abatement Division at 202-267-8442 or drugabatement@faa.gov.

(2) The certificate holder is responsible for updating this operations specification when any of the following changes occur:

(a) Phone number and address where the drug and alcohol testing program records are kept.

(b) If the certificate holder's number of safety-sensitive employees goes to 50 and above, or falls below 50 safety-sensitive employees.

(3) The certificate holder with 50 or more employees performing a safety-sensitive function on January 1 of the calendar year must submit an annual report to the Drug Abatement Division of the FAA.

(4) The certificate holder with fewer than 50 employees performing a safety-sensitive function

on January 1 of any calendar year must submit an annual report upon request of the Administrator.

e. The certificate holder has 50 or more safety-sensitive employees.

1. Issued by the Federal Aviation Administration.
2. These Operations Specifications are approved by direction of the Administrator.



Digitally signed by Todd Davis, Principal Maintenance Inspector (GL13)
[1] EFFECTIVE DATE: 8/3/2022, [2] AMENDMENT #: 4
DATE: 2022.08.03 09:56:47 -05:00

3. I hereby accept and receive the Operations Specifications in this paragraph.

Handwritten signature of Allen Schneider in black ink.

Allen Schneider, Quality Manager

8-03-2022

Date