

To Beverly
256-876-7147
Fm Tony C

14153 QAP-C5111

*** QUALITY ASSURANCE PROVISIONS**

NSN: 5315-01-126-9487 P/N:(78286) 70351-08404-103
NOMENCLATURE: Pin, Dowel

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 70351-08404-103 REV. "H" PL 70351-08404-103 REV "J" or latest revision and all details and specifications referenced therein.

I. QUALITY/INSPECTION REQUIREMENTS

- A. MIL-I-45208 or ISO 9000 Equivalent applies:
- B. First Article Testing applies:
- C. Production Lot Testing applies:
- D. Mandatory Inspection applies:

II. SUPPLEMENTAL REQUIREMENTS

A. Additionally, para. 3.1, 3.5, 5.1, 5.2, 6.1, 6.2 of MIL-Q-9858 or ISO 9000 equivalent applies.

B. The contractor shall include on the detailed process operation sheets developed, a tracking method that is traceable to the contract, all in-house manufacturing processes and the identity of all manufacturing sources performing process/operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of FIRST ARTICLE OR PRODUCTION LOT TESTING without the approval from the basic design engineering activity via the P.C.O..

C. The inspection method sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging. The tracking method used on the inspection/method sheets shall be traceable to the contract. In addition, the contractor is responsible for providing completed inspection method sheets showing the actual dimensions taken of all critical characteristics.

D. Markings should be I/A/W MIL-STD-130 REV."K" para. 5.3.3(a),(b),(c),(g). Method and location shall be I/A/W the drawing.

III. MANDATORY INSPECTION REQUIREMENTS:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

A. LEVEL OF INSPECTION (L.O.I.)

- 1) Critical Characteristics: 100% inspection and documentation of dimensions taken shall apply
- 2) Major and Minor Characteristics: L.O.I. shall be I/A/W a sampling plan acceptable to the Q.A.R..

B. CRITICAL CHARACTERISTICS FOR:

Sikorsky Aircraft P/N: (78286) 70351-08404-103

- 1) Zone 4 B
Dia. "B" .7507/.7503
- 2) Zone 2 F
Note #1
- 3) Zone 2 C
Note #13
- 4) Zone 2 C
Note #15

C. MAJOR AND MINOR CHARACTERISTICS:

- 1) Shall be defined by the contractor subject to Q.A.R. concurrence, unless defined on applicable drawings and associated specifications.

IV. Unless expressly provided for elsewhere in this clause, equipment such as **FIXTURES, JIGS, DIES, PATTERNS, TEMPLATES, MYLARS, SPECIAL TOOLING, TEST EQUIPMENT**, or any other manufacturing aid required for the manufacture and/or testing of the subject item will not be provided by the government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

FIRST ARTICLE TEST REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

The tests to be performed under the contract approval clause of the contract are:

- A. Dimensional Check 100%
- B. Form/Fit
- C. Identification
- D. NDI
- E. Material Analysis to include verification of heat treat, carburizing, & nital etch
- F. Visual: Verification of the overall workmanship
- G. Compliance with drawing, (78286) 70351-08404-103 REV. "H", P/L 70351-08404-103 REV "J" and associated drawings, latest revisions, and specifications referenced therein.
- H. Packaging and Preservation: Verification that the parts have been preserved and packaged per the requirements of the contract.
- I. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Articles are to be delivered hereunder shall also be subjected to those tests which will demonstrate that the articles comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Samples during testing.

II. Samples to be submitted for testing: Quantity: Two (2)

- A. Estimated cost: TBD
- B. Waiver of First Article Testing Requirements may be granted for:
(78286) Sikorsky Aircraft

III. Testing shall be performed at the Government Designated facility listed below:

NADEP Cherry Point (N65923)
F.A.T. Control Center
Attn: Mr. Steve Lundberg, Code: 3.3.2
PSC BOX 8021, Bldg# 159R-4
MCAS Cherry Point, NC 28533

IV. Special Instructions:

- A. Contractor shall provide Two samples, corrosive areas are to be coated with a light preservative.**
- B. Samples may be considered as production items under the contract provided that the samples can be refurbished to ready for issue (RFI) condition and that the samples have inspection approval of the cognizant Q.A.R.. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.**
- C. In lieu of destroying a FAT sample to verify Metalurgical make-up and carburizing depth, a test coupon may be provided along with the FAT test pieces. This Test Coupon will be of the same material and will have been subjected to the same processes as the FAT samples. Certification statements for these processes will be provided with the Test Coupons**
- D. Samples will be returned to the contractor if not destroyed in testing**
- E. Estimated Production Lead-Time Schedule:**
 - 1. Submission of the First Article samples by the contractor: 140 days**
 - 2. Analysis of FAT report and notification to contractor: 45 days**
 - 3. Production delivery after First Article acceptance: 140 days**
 - 4. Total accumulated calendar days 325 days**

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Samples, the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the P.C.O.. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

Upon shipment of First Article Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the designated test facility. The envelopes shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.

Within 105 days after receipt of the samples, the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to the P.C.O..

Disposition instruction must be provided to NADEP Cherry Point First Article Coordinator.

**PRODUCTION LOT TESTING REQUIREMENTS
(WITNESSED AND ACCEPTED AT THE CONTRACTORS FACILITY)**

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

The Production Lot Samples shall be inspected at the Contractors Facility... Witnessed and accepted by the DCMA/QAR. A written Test report shall be forwarded to the Contracting Officer. All 1423 Requirements apply.

I. Production Lot Test Sampling Requirements:

- A. The cognizant CAO/QAR shall select two (2) items at random from the first production lot produced. In addition the QAR shall select one (1) item at random from each successive lot or portion thereof.
- B. Production Lot Testing to be completed during production after First Article approval.
- C. Production Lot samples are to be unpainted, samples shall have corrosive areas coated with a light preservative.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

- A. Compliance with drawing, (78286) 70351-08404-103 REV. " H ", PL 70351-08404-103 REV " J " and associated drawings, latest revisions, and specifications referenced therein.
- B. Dimensional Check 100%
- C. Visual: Verification of the overall workmanship
- D. Packaging and Preservation: Verification that the parts have been preserved and packaged per the requirements of the contract.
- E. Review of documentation as provided under CDRL, DD1423

In addition to the above tests, the Production Lot Samples to be delivered hereunder shall also be subjected to those tests which will demonstrate that the samples comply with contract requirements.

III. Testing Location, Cost and Estimated Lead-time:

- A. The Production Lot inspection shall be performed at the contractor's plant by the contractor and witnesses and accepted by the DCMC/QAR. Within 15 days of completion of Production Lot Testing the CAO/QAR shall prepare and submit two (2) copies of their test report with conclusions and recommendations to the contracting officer. All DD1423 requirements apply.
- B. Samples may be considered as production items under the contract provided samples can be refurbished to Ready For Issue (RFI) condition and provided samples have inspection approval of the cognizant DCMC/QAR. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

Within fifteen days of completion of Production Lot Testing, the CAO/QAR shall prepare and submit two copies of the test report with conclusions and recommendations to the contracting officer.

CONTRACT DATA REQUIREMENTS LIST

Form Approved
OMB NO. 0704-0188

Public reporting burden for this collection of information is estimated to average 440 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (04-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send complete form to the Government Issuing Contracting Officer for the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO. _____ B. EXHIBIT _____ C. CATEGORY
IDP _____ TM _____ OTHER _____

D. SYSTEM/ITEM
5315-01-126-9487 E. CONTRACT/PR NO. _____ F. CONTRACTOR _____

1. DATA ITEM NO. 1 2. TITLE OF DATA ITEM
CERTIFICATION DATA REPORT 3. SUBTITLE
COMPLETE PROCESS OP SHEETS

4. AUTHORITY (Data Acquisition Document No.)
DI-MISC-80678/T1 5. CONTRACT REFERENCE _____ 6. REQUIRING OFFICE
DSC PHILADELPHIA

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	DISTRIBUTION	
		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE	b. COPIES
8. APP CODE A				Draft	FINAL
				Reg	Repro

16. REMARKS
PARA. 10.1, 10.2, 10.2.2, 10.2.4, 10.2.5 SHALL APPLY
* UPON SUBMISSION OF FIRST ARTICLE/PRODUCTION LOT TEST SAMPLE(S)
** IF PROCESS OPERATION SHEETS CHANGE AFTER SUCCESSFUL COMPLETION OF FAT/PLT.

DCMC	*	1/0	
NADEP/CHRYPT	**	1/0	
CODE: 3.3.2			
15. TOTAL		2/0	

1. DATA ITEM NO. 2 2. TITLE OF DATA ITEM
CERTIFICATION DATA REPORT 3. SUBTITLE
COMPLETE INSPECTION METHOD SHEETS

4. AUTHORITY (Data Acquisition Document No.)
DI-MISC-80678/T2 5. CONTRACT REFERENCE _____ 6. REQUIRING OFFICE
DSC PHILADELPHIA

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	DISTRIBUTION	
		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE	b. COPIES
8. APP CODE A				Draft	FINAL
				Reg	Repro

16. REMARKS
PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 SHALL APPLY
* UPON SUBMISSION OF FIRST ARTICLE/PRODUCTION LOT TEST SAMPLE(S)
** AT TIME OF CONTRACT COMPLETION.

DCMC	*	1/0	
NADEP/CHRYPT	**	1/0	
CODE: 3.3.2			
15. TOTAL		2/0	

1. DATA ITEM NO. 3 2. TITLE OF DATA ITEM
REQUEST FOR WAIVER 3. SUBTITLE _____

4. AUTHORITY (Data Acquisition Document No.)
DI-CMAN-80640C 5. CONTRACT REFERENCE _____ 6. REQUIRING OFFICE
DSC PHILADELPHIA

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES
8. APP CODE				Draft	FINAL
				Reg	Repro

16. REMARKS

DCMC/ACO		1/0	
DCMC/QAR		1/0	
PCO		1/0	
15. TOTAL		3/0	

1. DATA ITEM NO. 4 2. TITLE OF DATA ITEM
REQUEST FOR DEVIATION 3. SUBTITLE _____

4. AUTHORITY (Data Acquisition Document No.)
DI-CMAN-80640C 5. CONTRACT REFERENCE _____ 6. REQUIRING OFFICE
DSC PHILADELPHIA

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES
8. APP CODE				Draft	FINAL
				Reg	Repro

16. REMARKS

DCMC/ACO		1/0	
DCMC/OAR		1/0	
PCO		1/0	
15. TOTAL		3/0	

G. PREPARED BY *[Signature]* H. DATE *5/16/03* I. APPROVED BY *[Signature]* J. DATE *6/27/03*

CONTRACT DATA REQUIREMENTS LIST

(1 Data Item)

Form Approved
OMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 110 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these offices.

Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these offices.

A. CONTRACT LINE ITEM NO. 5315-01-126-9487	B. EXHIBIT	C. CATEGORY: TOP _____ TM _____ OTHER _____
---	------------	--

D. SYSTEM/ITEM	E. CONTRACT/PR NO.	F. CONTRACTOR
----------------	--------------------	---------------

1. DATA ITEM NO.	2. TITLE OF DATA ITEM 5 CERTIFICATION DATA / REPORTS	3. SUBTITLE
------------------	---	-------------

4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T3	5. CONTRACT REFERENCE	6. REQUIRING OFFICE DSC RICHMOND
--	-----------------------	-------------------------------------

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK 16*	14. DISTRIBUTION		
8. APP CODE A		11. AS OF DATE AS REQ	13. DATE IF SUBSEQUENT SUBMISSION SEE BLOCK 16**	a. ADDRESSEE	b. COPIES	
						Draft
					Reg	Repro

PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 APPLY

*BLOCK#12- UPON SUBMITTAL OF FIRST ARTICLE SAMPLE (S) AND/OR PRODUCTION LOT SAMPLE.

**BLOCK#13- THESE CERTIFICATIONS ARE REQUIRED AT TIME OF PRODUCTION LOT TESTING (PLT) OR CONTRACT COMPLETION IF TESTING IS WAIVED.

BLOCK #3- SEPERATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUB TITLES. CERTIFICATION REPORTS FOR PROCESS AND MATERIAL SPECIFICATIONS SHALL INCLUDE CERTIFICATION THAT ALL VENDORS PERFORMING THESE PROCESSES ARE (OEM) SIKORSKY AIRCRAFT APPROVED SOURCES FOR SAID PROCESS.

BLOCK #5 - CONTRACT REFERENCE:
MATERIAL CERTIFICATION AND ANALYSIS DOCUMENTATION FOR:P/N: (78286) 70351-08404-103, NOMEN: PIN, DOWEL MATERIAL: 9310 SAE AMS-6265

- Certifications for the following:
- Heat Treat & Carburizing Per SS 8015
 - Surface Temper Etch Insp Per SS 8705
 - Magnetic Particle Insp Per SS 8805
 - Nondestructive Insp Plan Per SS 8813

a. ADDRESSEE	b. COPIES	
	Draft	Final
	Reg	Repro
DCMC/ACO	1/0	
DCMC/QAR	*	1/0
PCO	**	1/0
NADEP CHRYPT		1/0
CODE: 3.3.2		
TOTAL		4/0

G. PREPARED BY 	H. DATE 5/6/03	I. APPROVED BY 	J. DATE 6/27/03
--------------------	-------------------	--------------------	--------------------

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE