

QUALITY ASSURANCE PROVISIONS**C-321: SPECIFICATION:**

NSN: 9Z 5306-00-809-8797 P/N: (78286) S65135-20707
NOMEN: BOLT, TEE HEAD

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) S65135-20707 REV. "T", 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. 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 identify on the process/operation sheets all manufacturing sources performing processes/ 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 approval from the Engineering Support Activity (ESA) via the PCO.
- C. The Inspection Method Sheets that list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging.
- D. Markings should be I/A/W MIL-STD-130 REV. "J" para. 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.

III. Mandatory Inspection Requirements:

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

- A. Level of Inspection (LOI).
 - 1. Critical Characteristics: 100% inspection shall apply.

2. Major and Minor Characteristics - LOI shall be I/A/W a sampling plan acceptable to the QAR.

B. Critical Characteristics

1. .3120/ .3115 Diameter
2. Thread 5/16-24 UNF-3A P.D. .2854/.2827
3. Heat Treat to 800,000 P.S.I. MIN. T.S. Rockwell C39-43 at location specified is a critical characteristic.
4. 100% hardness check required in area shown (either side) drawing note 8.
5. Magnetic Particle Inspection Per MIL-I-6868.
6. Bolt Weight to be 16.50/16.60 IAW note 5.
7. Dull Luster Cad Plate IAW drawing note 6.

C. Major and Minor Characteristics

1. Shall be defined by the contractor subject to QAR 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(s) 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.

I-964 FIRST ARTICLE APPROVAL (GOVERNMENT TESTING)

A. The contractor shall deliver (2) units of lot/item 001 within 180 calendar days from the date of this contract to the government designated facility listed below

**COMMANDING OFFICER
NAVAL AVIATION DEPOT
Attn: A. Thomas Code 6.1.523
PSC Box 8021, Building 137
MCAS Cherry Point, NC 28533-0021**

1. The test samples shipping container shall be clearly marked:

**FOR FIRST ARTICLE TESTING
NOT FOR RFI
DO NOT TAKE UP IN STOCK
CONTRACT NUMBER:**

2. the shipping documentation shall contain this contract number and the lot/item identification. The characteristics that the First Article must meet and the testing requirements are specified elsewhere in this contract.

B. If the First Article is disapproved, the contractor, upon Government request, shall submit an additional First Article for testing. After each request, the contractor shall make any necessary changes, modification, or repairs to the First Article or select another First Article for testing. All costs related to these tests are to be borne by the contractor, including any and all costs for additional tests following disapproval. The contractor shall furnish any additional First Article to the Government under the terms and conditions and within the time specified by the Government.

C. The Government shall act on this First Article within the time limit as agreed upon at time of re-submission. The Government reserves the right to require an equitable adjustment of the contract price for any extension of the delivery schedule or for any additional costs to the Government related to these tests.

D. If the contractor fails to deliver any First Article on time, or the contracting officer disapproves any First Article, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract.

E. Unless otherwise provided in the contract, and if the approved First Article is not consumed or destroyed in testing, the contractor:

1) May deliver the approved First Article as a part of the contract quantity, if it meets all contract requirements for acceptance.

2) Shall remove and dispose of any First Article from the Government test facility at the contractor's expense.

F. If the Government does not act within the time specified in paragraph B., C., and/or D. above, the contracting officer shall, upon timely written request from the contractor, equitably adjust under the changes clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.

G. Before First Article approval, the acquisition of materials or components for, or the commencement of production of, the balance of the contract quantity is at the sole risk of the contractor. Before First Article approval, the costs thereof shall not be allocable to this contract for 1) progress payments, or 2) termination settlements if the contract is terminated for the convenience of the Government.

H. The contractor shall produce both the First Article and the production quantity at the same facility and shall submit a certification to this effect with each First Article.

I. The contractor shall provide specific written notification to the procuring contracting officer informing him/her of the shipment of any articles furnished in accordance with this clause. Such notification must be addressed to the attention of the ACO with copies to NAVICP 072 and to the testing activity. Failure to provide such notification shall excuse the Government from any delay in performing First Article Testing and informing the contractor of the results thereof.

I-961 FIRST ARTICLE TESTS REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

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

- A. 100% Dimensional Check: To insure proper form.
- B. Compliance with drawing (78286) S6135-20707 REV. "T", and specifications referenced therein.
- C. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Article(s) to be delivered hereunder shall also be subjected to those tests that will demonstrate whether the article(s) comply with contract requirements.

II. Samples to be submitted for testing: Quantity 2.

- A. Testing shall be performed at the Government designated facility listed below.

**COMMANDING OFFICER
NAVAL AVIATION DEPOT
Attn: A. Thomas Code 6.1.523
PSC Box 8021, Building 137
MCAS Cherry Point, NC 28533-0021**

- A. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to ready for issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Sample(s), the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR. Upon shipment of First Article Sample(s), 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 PCO with duplicate copies to NAVICP Code 0731 and to the designated test facility. The envelopes shall be clearly marked. "DO NOT OPEN IN MAILROOM".

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PRODUCTION LOT TESTING REQUIREMENTS [14]

NSN: 5306-00-809-8797 P/N: (78286) S6135-20707

NOMENCLATURE: BOLT, SQUARE DRIVE INPUT MAIN GEAR BOX ASSY

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

I. Production Lot Test Sampling Requirements

- A. The cognizant CAO/QAR shall select 2 items at random from the first produced.
- B. Production Lot Testing to be completed during production after First Article approval.

II. Production Lot Sample testing provisions

- A. Compliance to be per drawing (78286) REV. "T."
- B. Dimensional Check
- C. Review of documentation as provided under CDRL (DD1423)

In addition to the above tests, the Production Lot Samples 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 Leadtime

- A. Testing may be accomplished at contractors facility or at the following testing facility.

**NAVAL AVIATION DEPOT
Attn: A. Thomas Code 6.1.523
PSC Box 8021, Building 137
MCAS Cherry Point, NC 28533-0021**

Within fifteen days of completion of Production Lot Testing, NAVAVNDEPOT, Cherry Point, NC and/or CAO/QAR shall prepare and submit two copies of their test report with conclusions and recommendations to the NAVICP-PHIL Code 0731.

IV. NOTIFICATION OF TESTING:

The contractor shall notify the PCO, ACO and QAR prior to conducting Production Lot Tests so that the Government may witness such testing.

A. The QAR shall be present to witness all Production Lot Tests.

V. Inspection of Samples

A. Upon shipment of Production Lot 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 NAVICP-PHIL Code 0731 with duplicate copies to NAVANDEPOT, Cherry Point NC, Code 6.1.523 and to the designated test facility. The envelope shall be clearly marked. "DO NOT OPEN IN MAILROOM".

B. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to Ready for Issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant CAO/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.

