

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

NSN: IRM 5310-01-146-8166, P/N: (78286) 65122-11270-102
NOMENCLATURE: Nut, Stack, Bearing

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65122-11270, REV. "F", and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I- 45208 applies: Refer to contract section E.
- B. First Article Testing applies: Refer to contract section I.
- C. Mandatory Inspection applies: Refer to contract section C.

II. Supplemental Requirements

- A. Additionally, para. 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 apply.
- B. The contractor shall include on the detailed process/operation sheets developed, all in house manufacturing processes and the identity of 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 the approval from the basic design engineering activity via the PCO.
- 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. In addition, the contractor is responsible for providing completed Inspection Method Sheets showing the actual dimensions taken.
- D. Markings should be I/A/W MIL-STD-130 REV. "G" 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. ZONE 3-B

NOTE 6

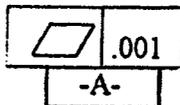
2. ZONE 3-B

NOTE 7

3. ZONE 3-B

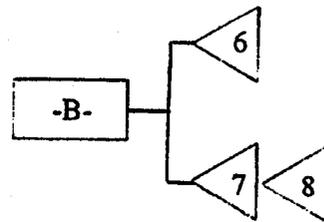
NOTE 8

4. ZONE 4-B



5. ZONE 5-A

5.000 - 12 UNJ - 3B THD
 .002
CHAMFER $90^\circ \pm 2^\circ$ INCL TO
5.000 - 5.030 DIA
PER SPEC MIL-S-8879



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-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. Dimensional Check 100%
- B. Form/Fit
- C. "Compliance with drawing (78286) 65122-11270, REV. "F", and specifications referenced therein.
- D. 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 which will demonstrate that the article(s) comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Sample(s) during testing.

II. Special Instructions

- 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.
- B. Sample(s) will be returned to the contractor, if not destroyed in testing.
- C. Sample(s) is to be unpainted. Corrosive areas are to be coated with a light preservative.

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, Attn: . 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 Code , with duplicate copies to Code and to the designated test facility. The envelopes shall be clearly marked. "DO NOT OPEN IN MAILROOM".

Within 90 days after receipt of sample(s) the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to Code

I-964

FIRST ARTICLE APPROVAL (GOVERNMENT TESTING)

A. The Contractor shall deliver 2 unit(s) of lot/item 0001 within 252 calendar days from the date of this contract to the Government at:

Nadep Cherry Point
Attn: Betty Lupton
Code: 71400
M.C.A.S. Cherry Point, N.C. 28533-5030

Marking of test sample(s) shipping container: "FOR FIRST ARTICLE TESTING. NOT RFI MATERIAL. DO NOT TAKE UP IN STOCK. CONTRACT NUMBER:
_____"

For First Article Test, 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. Within 120 calendar days after the Government receives the First Article, the contracting officer shall notify the contractor, in writing, of the conditional approval, approval or disapproval of the First Article. The notice of conditional approval or approval shall not relieve the contractor from complying with all requirements of the specifications and all other terms and conditions of this contract. A notice of conditional approval shall state any further action required of the contractor. A notice of disapproval shall cite reasons for the disapproval.

C. 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 a disapproval. The contractor shall furnish any additional First Articles to the Government under the terms and conditions and within the time specified by the Government.

The Government shall act on this First Article within the time limit specified in paragraph B above. 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, the contractor -

1) May deliver the approved First Article as a part of the contract quantity, provided it meets all contract requirements for acceptance and was not consumed or destroyed in testing and;

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 or C 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. The contractor is responsible for providing operating and maintenance instructions, spare parts support, and repair of the First Article during any First Article Test.

H. 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.

I. 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.

J. The contractor shall provide specific written notification to the procuring contracting officer informing him of the shipment of any article(s) furnished in accordance with this clause. Such notification must be addressed to the attention of code with copies to code 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.

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 (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed 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: TDP <u>ENGINEERING</u>	
D. SYSTEM/ITEM IRM 5310-01-146-8166		E. CONTRACT/PR NO.		F. CONTRACTOR	
1. DATA ITEM NO. 001		2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORT		3. SUBTITLE COMPLETE PROCESS/OPERATION SHTS	
4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP CHERRY POINT	
7. DD 250 REQ LT	8. DIST STATEMENT REQUIRED A	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION *SEE BLOCK 16	14. DISTRIBUTION	
		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION **SEE BLOCK 16	b COPIES	
				a. ADDRESSEE	Final
				NADEP CHERRY POINT	Draft
				CODE: 6.3.674	Reg
				CAO	Repro
					*1/0
					*1/0
					*1/0
				15. TOTAL	3/0
16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 apply *UPON SUBMITTAL OF FIRST ARTICLE/PRODUCTION LOT SAMPLE **IF PROCESS/OPERATION CHANGE AFTER APPRVL OF F.A.T.					
1. DATA ITEM NO. 002		2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORT		3. SUBTITLE COMPLETED INSPECTION METHOD SHEETS	
4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP CHERRY POINT	
7. DD 250 REQ LT	8. DIST STATEMENT REQUIRED A	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION *SEE BLOCK 16	14. DISTRIBUTION	
		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION *SEE BLOCK 16	b COPIES	
				a. ADDRESSEE	Final
				NADEP CHERRY POINT	Draft
				CODE: 6.3.674	Reg
				CAO	Repro
					*1/0
					*1/0
					*1/0
				15. TOTAL	3/0
16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 apply *UPON SUBMITTAL OF FIRST ARTICLE/PRODUCTION LOT SAMPLE **AT TIME OF CONTRACT COMPLETED					
1. DATA ITEM NO. 003		2. TITLE OF DATA ITEM REQUEST FOR DEVIATION		3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-CMAN-80640		5. CONTRACT REFERENCE		6. REQUIRING OFFICE	
7. DD 250 REQ LT	8. DIST STATEMENT REQUIRED A	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION *SEE BLOCK 16	14. DISTRIBUTION	
		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	b COPIES	
				a. ADDRESSEE	Final
					Draft
					Reg
					Repro
					*1/0
					*1/0
				15. TOTAL	1/0
16. REMARKS ORIGINAL					
1. DATA ITEM NO. 004		2. TITLE OF DATA ITEM REQUEST FOR WAIVER		3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-CMAN-80641		5. CONTRACT REFERENCE		6. REQUIRING OFFICE	
7. DD 250 REQ LT	8. DIST STATEMENT REQUIRED A	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION *SEE BLOCK 16	14. DISTRIBUTION	
		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	b COPIES	
				a. ADDRESSEE	Final
					Draft
					Reg
					Repro
					*1/0
				15. TOTAL	1/0
16. REMARKS ORIGINAL AND TWO (2) COPIES					
PREPARED BY TIMOTHY J. MOSSER 0534.18		H. DATE		I. APPROVED BY	
				J. DATE	

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE

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 addresses. Send completed 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: TOP _____ TM _____ OTHER ENGINEERING	
D. SYSTEM/ITEM IRM 5310-01-146-8166		E. CONTRACT/PR NO.		F. CONTRACTOR	
1. DATA ITEM NO. 005	2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORT			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-MISC- 80678/T			5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP CHERRY POINT
7. DD 250 REQ LT	8. 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 OF SUBSEQUENT SUBMISSION * SEE BLOCK 16	b. COPIES	
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 apply BLOCK #12 UPON SUBMITTAL OF FIRST ARTICLE/PRODUCTION LOT SAMPLE(S) BLOCK # 3 SEPARATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUBTITLES AND SHALL INCLUDE CERTIFICATION THAT ALL SUBVENDORS PERFORMING THESE PROCESS ARE SIKORSKY APPROVED SOURCES TO PERFORM SAID PROCESSES. BLOCK #5 CONTRACT REFERENCE: MATERIAL CERTIFICATION AND ANALYSIS DOCUMENTATION FOR: (78286) 65122-11270-102 AMS 6414 4340 SMLS TUBING MIL-S-8844 4340 BAR, ANL AMS 6415 4340 SMLS TUBING MIL-S-5000 4340 BAR, ANL AMS 6371 4130 SEAMLESS				a. ADDRESSEE	
				NADEP CHERRY CODE: 6,3,674 CAO	
				TOTAL 3/0	
CERTIFICATION FOR THE FOLLOWING					
1) HEAT TREATMENT TO 150,000 PSI MINIMUM U.T.S. ROCKWELL C34-38 PER MIL-H-6875					
2) INSPECTION OF INTERNAL THREADS BY GAGING METHOD "C" of MIL-S-8879 or MIL-S-7742, as APPLICABLE. IN ADDITION, THE MINOR DIAMETER SHALL BE CHECKED FOR CONFORMANCE TO DIMENSIONAL LIMITS.					
3) SILVER PLATING per QQ-S-365					
4) TIN CAD PLATING PER MIL-P-23408					
5) MAGNETIC PARTICLE INSPECTION PER SS8805					
G. PREPARED BY MOTHY J. MOSSER 0534.18		H. DATE	I. APPROVED BY		J. DATE
				15. TOTAL →	

17. PRICE GROUP
18. ESTIMATED TOTAL PRICE