QUALITY ASSURANCE PROVISIONS

NSN: 2840-00-085-9083
P/N: (99207) 37C302228P103
NOMEN: Bearing Housing and Seal T-64 Engine
Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number 37C302228P103 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. Mandatory Inspection applies: Refer to contract section C.
D. Production Lot Testing Applies
E. Site Survey required

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 apply.

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 and/or Production Lot Testing without approval from the Engineering Support Activity (ESA), 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 in accordance with MIL-STD-130 Rev. "J" paragraph 5.3.3(a), (b),(c), and (g). Method and location shall be in accordance with the 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 in accordance with a sampling plan acceptable to the QAR.

B. Critical Characteristics:

Critical Characteristics:

Drawing zone C-4 1.7741 / 1.7736
Magnetic particle inspection IAW note 8 and GE Specification P3TE1 and table location on zone E-4

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 items 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

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 % of finished part
B. Form / Fit
C. Compliance with all drawings, and specifications referenced therein.
D. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Articles 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 (s) during testing.
The contractor shall be responsible for providing necessary parts and repair of the First Article Sample (s) during testing.

II. **Special Instructions:**
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:
A. 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, ACO, and QAR The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

B. 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 fowarded to the PCO / ACO and the designated test facility. The envelopes shall be clearly marked, "DO NOT OPEN IN MAILROOM".

FIRST ARTICLE APPROVAL (GOVERNMENT TESTING)

A. The contractor shall deliver two (2) units of lot / item 001 within 250 days from the date of this contract to the government designated facility listed below.

NAVAL AVIATION DEPOT CHERRY POINT
ATTENTION: MS ANNIE THOMAS CODE 6.1.523
PSC BOX 8021 / BUILDING 137
MCAS CHERRY POINT, N.C. 28533-5030
252-464-7748

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

A. For First Article Test, the shipping documentation shall contain this contract number and the lot/item indentification. The characteristics that the First Article must meet and the testing requirements that 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 a 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.
The government shall act of 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.

C. 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.

D. 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 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.

E 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.

F. 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.

G 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.

H. The contractor shall provide specific written notification to the procuring contractor 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 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.

PRODUCTION LOT TESTING REQUIREMENTS
[WITNESSED AND ACCEPTED AT THE CONTRACTORS FACILITY]

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

I. **Production Lot Test Requirements**

A. The cognizant CAO/QAR shall select two (2) item (s) at random from the production lot. In addition the QAR shall select one (1) item (s) at random from each successive lot or portion thereof.

B. Production Lot Testing to be completed during production after First Article Approval.

C. Sample (s) are to be unpainted. Corrosive areas to be 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 drawings and all specification referenced therein.
B. Dimensional Check

In addition to the above tests, the Production Lot Sample(s) to be delivered hereunder shall also be subjected to those tests, which will demonstrate that the sample(s) comply with contract requirements.

III. **Testing location**

A. The Production Lot inspection shall be performed at the contractor's plant, by the contractor and witnessed and accepted by the DCMC/QAR. Within fifteen (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 1423 requirements apply.

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

PRODUCTION LOT TESTING (CONTRACTOR TESTING)

A. If the contractor fails to provide any Production Lot Samples for testing within the time or times specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.

B. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such event, the government may, at its option and at no additional cost to the government, (I) terminate all or any portion of this contract for default, (II) require the manufacture of a new Production Lot, or a rework of the rejected Production Lot if the means and procedures by the contractor for rework are acceptable to the government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked Production Lots in the same way as they did to the original Production Lot.

C.For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting and the contractor and his sureties (if any) shall be liable for the amount of such costs.

D.Nothing contained in the foregoing provisions of this clause. and no action of the government in accordance herewith, shall in any way prejudice the right of the government under the clause of this contract entitled default.

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 pe 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 of the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY: TOP _____ TM _____ OTHER _____
D. SYSTEM/ITEM 00-085-9083 SEAL	E. CONTRACT/PR	F. CONTRACTOR

1. DATA ITEM	2. TITLE OF DATA ITEM	3. SUBTITLE
5	**CERTIFICATION DATA / REPORTS**	

4. AUTHORITY (Data	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-MISC-80678/T3		

7. DD 250 REQ	9. DIST STATEMENT	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		**AS REQ**	**SEE BLOCK 16***
8. APP CODE		11. AS OF DATE	13. DATE IF SUBSEQUENT
A		**AS REQ**	**SEE BLOCK 16***

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

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

BLOCK #5 - CONTRACT REFERENCE: P/N: 37C30228P103

Certification of material AMS-6382
Certification of:
1. Magnetic Particle Inspection IAW P3TE1 and table in zone E-4
2. Endurion treat IAW P16TE5
3. **ECCENTRICITY OF DIAMETER -Y- RELATIVE TO THE AXIS OF DIAMETER - X- NOT TO EXCEED .00025**

These certifications are required at First Article Testing , Production Lot Inspection, or contract completion if testing is waived.

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO		1/0	
DCMC / QAR	*	1/0	
PCO	**	1/0	
DSCR			
		3/0	

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
Robert Hughes	9 March 2002	*Robert Hughes*	9 March 2002

DD Form 1423-1, JUN 90

Previous editions are obsolete.

1007/183 S/N 0102-LF-010-5500

CONTRACT DATA REQUIREMENTS LIST
(2 Data Items)

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 DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 22202-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDJET, PAPERWORK REDUCTION PROJECT (0704-0188), WASH. 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 TM OTHER
D. SYSTEM/ITEM 00-085-9083 Seal	E. CONTRACT/ PR. NO.	F. CONTRACTOR

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

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-CMAN-80640B		DEFENSE SUPPLY CENTER RICHMOND

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION

16. REMARKS

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO		1/0	
DCMC / QAR		1/0	
PCO		1/0	
DSCR		1/0	
15. TOTAL		4/0	

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

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-CMAN-80641B		DEFENSE SUPPLY CENTER RICHMOND

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION

16. REMARKS

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO		1/0	
DCMC / QAR		1/0	
PCO		1/0	
DSCR		1/0	
15. TOTAL		4/0	

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
Robert Hughes	9 March 2002	Robert Hughes	9 March 2002

CONTRACT DATA REQUIREMENTS LIST
(2 Data Items)

FORM APPROVED
OMB NO. 0704-0188

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A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY: TDP TM OTHER
D. SYSTEM/ITEM 00-085-9083 Seal	E. CONTRACT/ PR. NO.	F. CONTRACTOR

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

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-MISC-80678/T1		DEFENSE SUPPLY CENTER RICHMOND

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	SEE BLOCK #16
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION
A		AS REQ	SEE BLOCK #15

16. REMARKS

PARA. 10.1, 10.2, 10.2.1, 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.

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO	*	1/0	
DCMC / QAR	**	1/0	
PCO		1/0	
15. TOTAL		3/0	

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

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
		DEFENSE SUPPLY CENTER RICHMOND

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	SEE BLOCK #16
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION
A		AS REQ	SEE BLOCK #1`6

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.

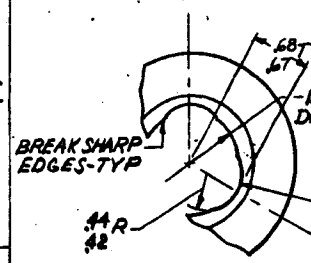
14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO	*	1/0	
DCMC / QAR	**	1/0	
PCO		1/0	
15. TOTAL			

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
Robert Hughes	9 March 2002	Robert Hughes	9 March 2002

C 37C302228 J

PART IDENT NO.	NOTE APPLICATION
37C302228P102	1-8
37C302228P103	1-6 & 8,9



OTHERWISE SAME AS PART P101

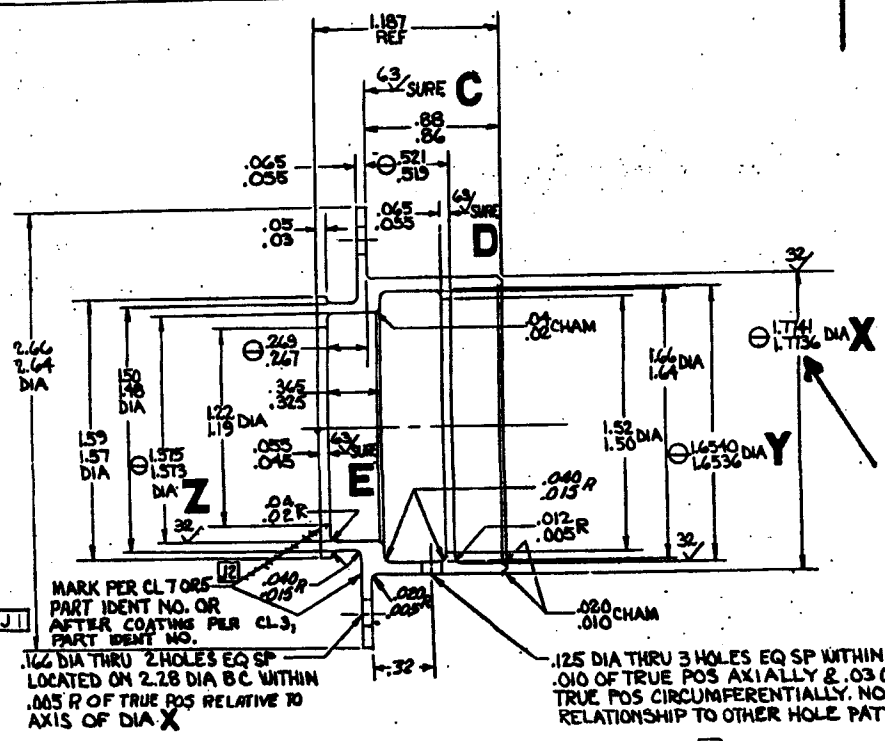
MAGNETIC PARTICLE INSPECTION REQUIREMENTS

CURRENT REQUIREMENTS: CIRCULAR AMPS: 800 LONGITUDINAL AMP TURNS: 8000

AREA	ALLOWABLE INDICATIONS					
	SURFACE			SUBSURFACE		
	MAX LG	MAX NO.	OTHER REQUIREMENTS	MAX LG	MAX NO.	OTHER REQUIREMENTS
ALL	—	20	NO INDICATIONS TO BREAK OVER CORNERS			MAX LENGTH ON TRANSVERSE FACE TO BE .03

REVISIONS

SYM	ZONE	DESCRIPTION	DATE	APPROVED
E	1	RETRACED-NO CHG NOTE 51-50165	5/1/64	
F	1 (E6) P103 ADDED 2 (C3) NOTE 9 ADDED 3 (A4) & (E5) NOTE APPLICATION COLUMN ADDED NOTE 30-22410		SEPT 4 1964	
H	1	(C3) WAS "---.0002-.0004. DIMENSIONS APPLY---" DCID 30-22602	SEPT 21 1965	
J	1 (B7) OR AFTER ---IDENT NO- ADDED TO NOTE 2 (B6) LEADER DELETED CID 25475		MAR 28 1968	G. EISENER



PART IDENT NO.	NOTE APPLICATION
37C302228P101	1-8

W1 F2 9. ENDURION TREAT PER P16-TE5 CLASS 1 TO A THICKNESS OF .0002-.0004 EXCEPT DO NOT COAT DIA Y, WHICH IS TO BE BLACKOXIDED PER AMS 2485. DIMENSIONS APPLY BEFORE COATING.

8. MAGNETIC PARTICLE INSPECT PER P3-TE1 ⊕. SEE TABLE (ZONE E-4).

7. BLACK OXIDE FINISH PER AMS 2485.

6. PRIOR TO FINISH MACHINING WITH .030 MINIMUM ENVELOPE ALL OVER, AUSTENITIZE AT 1550° F ONE HOUR AND OIL QUENCH. TEMPER TO HARDNESS OF R_C 24-32.

5. PART MAY VARY FROM TRUE SHAPE IN FREE STATE WITH A MAXIMUM OUT OF ROUNDNESS OF .005. WHEN DIAMETER X AND SURFACE C ARE RESTRAINED, DRAWING DIMENSIONS MUST BE MET.

⊖ 4. FACE RUNOUT OF SURFACES C, D AND E RELATIVE TO AXIS OF DIAMETER X NOT TO EXCEED .001 TIR.

⊖ 3. ECCENTRICITY OF DIAMETER Z RELATIVE TO AXIS OF DIAMETER X NOT TO EXCEED .001.

⊖ 2. ECCENTRICITY OF DIAMETER Y RELATIVE TO THE AXIS OF DIAMETER X NOT TO EXCEED .00025.

1. 250/ UNLESS OTHERWISE SPECIFIED.

SEE P23-TE1 FOR MARKING INSTRUCTIONS
SEE P9-TE10 FOR QUALITY CONTROL REQUIREMENTS CL B MAT'L RELEASE
SEE P1-TE1 FOR INTERPRETATION OF DRAWING
PRODUCT MUST CONFORM TO THE REQUIREMENTS OF THE ABOVE SPEC

665
627
FAA
308-7

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES. TOLERANCES ON FRACTIONS ± DECIMALS ± ANGLES ± ALL SURFACES 125

MATERIAL: AMS 6382

DRAWN D. Zwicke 10-29-60
APPROVED: E. KAHN 11/3/60
T. LUKES 11/4/60
J.E. NSIA 11/4/65

DETAIL DRAWING
HOUSING, SEAL & BEARING, FLANGED ACCESSORY DRIVE GEARBOX

GRAPHIC SCALE .25
CHKD: 11/4/60
WT 20 lb.
20-10332

GENERAL ELECTRIC
SMALL AIRCRAFT ENGINE DEPARTMENT
LYNN RIVER WORKS
AF33 657-67-C-1428
SIZE C 37C302228
CODE IDENT NO. 99207

U[redacted] J 99207. UNCONTROLLED DOCUMENT WHEN PRINTED - ZED532L 09-MAR-2002