

*** QUALITY ASSURANCE PROVISIONS**

SPECIFICATIONS:

NSN: 2995-00-003-6605 P/N:(26512) A51B92079-12

NOMENCLATURE: Aft Outboard Engine Mount

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (26512) A51B92079-12 REV. "G" to include ECN: 98-12 & 98-13, MESR 98JX00298, 98JX00351, 98JX00796, 98JX00980, and all details and specifications referenced therein.

- I. Forging P/N: (26512) A51B92080 shall be procured from (29784) Fan Steel Forge, 1033 Alhambra Ave. Los Angeles CA. 90012.

Aermet 100 Barstock shall be procured from (9M366) Carpenter Technology, 610 Lockhaven Drive, Houston TX, 77073.

Material certifications for the above listed forging and barstock shall be I/A/W NADEP Jacksonville Engineering requests: 98JX00796, 98JX00980, and Grumman Forging DWG# A51B92080

II. 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

III. 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.

IV. 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:

Grumman P/N: (26512) A51B92079-12

- 1) Zone 3-G
.50 RAD (2 Places)
- 2) Zone 3-E
.300
- 3) Zone 3-D
3.450
- 4) Zone 3-D
.500 RAD

5) Zone 3-D

II Y .002

I X .002

6) Zone 3-D

.230

7) Zone 4-E

.25 RAD

8) Zone 4-D

.500 Rad (4 places)

9) Zone 4-C

.670 Rad (4 places)

10) Zone 4-E

.420 (upper flange thickness)

11) Zone 5-G

--Z--

I X .002

12) Zone 4-D

.180

13) Zone 5-C

1.00 Rad (2 places)

14) Zone 5-G

.135 Rad

(3)

15) Zone 5-E

1.875 Rad

16) Zone 6-D

** 2.003

2.001 Dia

17) Zone 6-C

.330

.320

18) Zone 6-B

II X .002

19) Zone 7-G

.135 Rad

20) Zone 7-E

.25 Rad constant

21) Zone 6-E

2.450 Rad

22) Zone 7-C

3.15 Rad

23) Zone 8-B

.25 Rad constant

24) Zone 7-B

.25 Rad constant

25) Zone 8-A

.213

26) Zone 7-A

1.00 Rad

27) Zone 7-A

.260

28) Zone 4-E

.260 (upper flange thickness)

29) Zone 4-E

5.220 (this is the start of the taper .300 to .420)

30) Zone 5-C

1.00 (this raised area is used as a reference point when installing the engine mount spool)

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. Compliance with drawing, (26512) A51B92079-12 REV." G ", and associated drawings, latest revisions, and specifications referenced therein.
- D. 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 (26512) Grumman Aerospace.

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

NADEP JACKSONVILLE
F.A.T. Office
Door 16
NAS Jacksonville, FL 32212-0016

IV. Special Instructions:

A. Samples may be considered as production items under the contract provided that the samples can be refurbished to ready for issue (RFI) condition and provide 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.

B. Samples will be returned to the contractor, if not destroyed in testing.

C. Samples are to be un-painted per drawing. Corrosive areas are to be coated with a light preservative.

D. Estimated Production Leadtime Schedule:

1. Submission of the First Article samples by the contractor 180 days.
2. Analysis of report and notification to contractor 105 days.
3. Production delivery after First Article acceptance 90 days.
4. Total accumulated calendar days 375 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 90 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..

PRODUCTION LOT TESTING REQUIREMENTS

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 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. Samples are to be unpainted. Corrosive areas are 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 drawing, (26512) A51B92079-12 REV " G " and associated drawings, latest revisions, and specifications referenced therein.
- B. Form/Fit
- C. Dimensional Check 100%
- D. 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 Leadtime:

- A. Ship samples/Data to NADEP, Jacksonville, Fat Office, Door 16
- B. Shipping container marking: **NON RFI**
- C. Estimated Cost for Inspection/Test is TBD.
- D. Estimated Leadtime for Inspection/Test is TBD.

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

IV. Shipment and Distribution of Samples:

- A. Fourteen (14) days prior to shipment of production lot 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 the test samples by the CAO/QAR.

- B. 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 the P.C.O.. and to the designated test facility. The envelope shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.

- C. Samples may be considered as production items under the contract provided the samples can be refurbished to Ready For Issue (R.F.I.) condition and provided the samples 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.

- D. Samples will be returned to the contractor.

- E. The designated test facility and the contracting officer shall be notified as to all shipping data applicable to the samples, such as bill of lading number, method of shipment, etc... 14 days prior to shipment.

CONTRACT DATA REQUIREMENTS LIST

Form Approved
OMB NO. 0704-0188

Prints reporting burden for this collection of information is estimated to average 600 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 Service, 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 Printing Contracting Officer for the Contract#97-16-0188 in block 2.

A. CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY TDP _____ TM _____ OTHER _____	
D. SYSTEM/ITEM 9G 2995-00-003-6605			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 RICHMOND	
7. DD 130 REQ LT	8. DUTY STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	DISTRIBUTION	
9. APP CODE A	11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESS	b. COPIES	
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.			CAO/QAR	*	1/0
			NADEP/JAX	**	1/0
			CODE:6.3.424		
			K. TOTAL		2/0
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