

QUALITY ASSURANCE PROVISIONS

NSN: 9C-1615-00-215-0121

P/N: (78286) 65358-07046-44

NOMEN: Shaft Assy., Gear Box

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65358-07046-044 Rev. "Z", or latest revision and all details and specifications referenced therein.

Forging(s) (78286) 65358-07046-006 shall be procured from a Sikorsky approved source.

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

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. "K" 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:

THE FOLLOWING STATEMENTS PERTAIN TO THE BELOW LISTED DRAWINGS
CRITICAL CHARACTERISTICS:

65385-07046-044
65358-07050-101
65358-07047-104
65358-07043-102
65358-07064-101
65358-07033-101

(SHALL BE DEFINED AS BELOW, UNLESS DEFINED BY THE PRIME CONTRACTOR)

(DIAMETRICAL AND LINER DIMENSIONS HAVING A TOTAL TOLERANCE OF 0.001
OR LESS)

SURFACE FINISHES HAVING A 16 VALUE OR LESS)

(ANY GEOMETRIC FEATURE CONTROL REQUIREMENT WITH A TOTAL
TOLERANCE RANGE
OF .002 OR LESS)

(ANGULAR TOLERANCES WITH A TOTAL RANGE LESS THAN 1 DEGREE)
THREADS SPECIFIED TO CLASS 3 OR GREATER)

DRAWING

(78286) 65358-07046-044

Critical Characteristics:

MANDATORY INSPECTION REQUIREMENTS (STANDARD)

DWG. 65358-07046-102

ZONE B5 4.6875-12N BUTT -3THD.

ZONE B5 4.753/4.754 DIA AFTER SHOTPEEN AND TO BE CONCENTRIC WITHIN
.002 T.I.R.

ZONE B5 6.0033/6.0043 DIA -D- AFTER SHOTPEEN AND TO BE CONCENTRIC WITHIN
.002 T.I.R.

*ZONE B6.3765/3775 DIA 24HOLES EQ. SP. AND IN TRUE POSITION TO DATAM A
WITHIN .002*

ZONE A6 EXTERNAL SPLINE DATA TO BE MAINTAINED IN ITS ENTIRETY.

ZONE B3 1.803/1.804 DIA TO BE MAINTAINED CONCENTRIC TO B WITHIN .002 T.I.R.

ZONE B3 3.000-16 N. BUTT-3 THD.

THE COGNIZANCE DCMAO/QAR SHALL INSPECT THESE CHARACTERISTICS 100%

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 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

PRODUCTION LOT TESTING (GOVERNMENT TESTING)

A. The Production Lot Samples shall be:

1. Selected at random by the cognizant government QAR. Such sample(s) shall be submitted via the cognizant government inspector, all transportation charges prepaid by the contractor to:

NADEP Cherry Point
F.A.T. Control Center
Attn: Annie Brown, code: 6.1.523
PSC Box 8021
MCAS Cherry Point, NC 28533-5030

2. The samples shall be identified by contract number, lot number, and be clearly marked as follows:

**PRODUCTION LOT TEST SAMPLES
NOT R.F.I. MATERIAL
DO NOT TAKE UP IN STOCK**

B. Such samples shall be delivered to the testing facility in sufficient time prior to the delivery date of the production articles to allow a 60 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 90 days of the receipt of the samples, the testing facility shall notify contracting officer, PCO /ACO of the results of the testing, together with the recommendation for approval or disapproval.

C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular lot within 60 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

D. If the contractor fails to deliver 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.

E. 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.

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 drawing, (78286) 65358-07046-044 Rev. "Z" , 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 forwarded to the PCO / ACO and the designated test facility. The envelopes shall be clearly marked, "DO NOT OPEN IN MAILROOM".

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 9C-1615-00-215-0121			E. CONTRACT/ PR. NO.		F. CONTRACTOR					
1. DATA ITEM NO. 1	2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORTS			3. SUBTITLE COMPLETED PROCESS/OPERATION SHT						
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T1		5. CONTRACT REFERENCE		6. REQUIRING OFFICE DSCR						
7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ.	12. DATE OF FIRST SUBMISSION SEE BLOCK 16		14. DISTRIBUTION					
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK 16		a. ADDRESSEE					
16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4, 10.5 APPLY * UPON SUBMISSION OF PRODUCTION LOT SAMPLES ** UPON SUBMISSION OF PRODUCTION LOT SAMPLES AND AT TIME OF CONTRACT COMPLETION FOR 100% OF CONTRACT QUANTITY					b. COPIES					
							Draft		Final	
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									Repro	
									CAO	
									ACO	
									PCO	
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1. DATA ITEM NO. 2	2. TITLE OF DATA ITEM CERTIFICATION DATA /REPORTS			3. SUBTITLE COMPLETED INSPECTION METHOD SH						
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T2		5. CONTRACT REFERENCE		6. REQUIRING OFFICE DSCR						
7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK 16 *		14. DISTRIBUTION					
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G. PREPARED BY VINCENT LOISEAU 0731.14		H. DATE 7/8/00		I. APPROVED BY		J. DATE				

