QUALITY ASSURANCE PROVISIONS

NSN: 1680-00-229-6551
P/N: (26512) 123C10209-501
NOMEN: Cylinder assembly

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (26512) 123C10209-501, 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:
D. Acceptance Test 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:

1) Drawing 123C10209:
   a) Inspect I/A/W Note D1

2) Drawing 123CM10025:
   a) .9002- .9007 Dia.
   b) Holes marked with triangle symbol must be matched to holes on 123CM11225.

3) Drawing 123CM10075:
   a) 100% dimensional before and after cadmium plate.

4) Drawing 123C11212:
   a) 100% inspection I/A/W Notes on Drawing.

5) Drawing 123CM1225:
   a) .2500-.2530 (4 holes)
   b) 2.876/2.874 Dia.
   c) Holes marked with triangle symbol must be matched to holes on 123CM10025.

6) Drawing 123CM11226:
   a) Drill .061-.066 thru both walls.
   b) .098-.093 thickness
   c) .074-.069 thickness
   d) All Class 3 threads
   e) Pitch Diameter .3450-.3479 **C**

7) Drawing 123CM11227:
   a) .879/ .877 Dia. (2) **C**
   b) 1.067/ 1.065 Dia. **C**
   c) .110/.105 Thickness.
   d) 2.606/ 2.604 Dia. **C**

8) Drawing 123CM11228:
   a) .814/.812 Dia. **C**
   b) .110/.105 Depth (2 Places)
   c) .642/ .640 Dia. (2 Places)
   d) .502/.500 Dia. **C**
   e) .7419- .7500 Dia.
   f) .7142- .7175 Pitch Dia.
   g) All Class 3 Threads.

9) Drawing 123CM11229:
   a) .502/ .500 Dia.
   b) .192/ .187 Width.
   c) 1.136/ 1.131 Dia.
   d) P. D. 1.2103 – 1.2139
   e) All Class 3 Threads.

10) Drawing 123CM11230:
   a) 1.236/ 1.231 Dia. (2 Places)
   b) .255/ .250 Dia.
   c) 1.067/ 1.065 Dia. **C**
   d) 1.3663 – 1.3750 Major Dia.
   e) 1.3353- 1.3389 Pitch Dia. **C**
   f) All class 3 Threads

11) Drawing 123CM11231:
   a) Minor Dia. .3299- .3372
   b) .660/ .658 Dia.
   c) .111/ .106 Width
   d) .359/ .354 Width
   e) All Class 3 Threads.

12) Drawing 123CM11232:
   a) .876/ .874 Dia.
   b) .082/ .077 Width
   c) Drill (.045- .050) 2 Holes
   d) Minor Dia. .6959- .7037
   e) All Class 3 Threads.

13) Drawing 123CM11233:
   a) Minor Dia. 1.1899- 1.1980
   b) .121- .116 Width
   c) .110- .105 Width
   d) 2.606/ 2.604 Dia. **C**
   e) .192- .187 (TYP)
   f) Drill (.097- .102) 6 Holes
   g) All Class 3 Threads.

14) Drawing 123CM11234:
   a) Minor Dia. 1.1899- 1.1990
   b) Drill (.097- .102) 3 Holes
   c) All Class 3 Threads.

14) Drawing 123CM11235:
   a) Minor Dia. .6959- .7037
   b) Drill (.045- .050) 3 Holes Equally Spaced.
   c) All Class 3 Threads.

15) Drawing 123CM11236:
   a) Dia. **A,** and Dia. **B** as required.
   b) .104/ .099 Thickness.

16) Drawing 123CM11237:
   a) .255/ .250 Width (2 places)
   b) 2.873/ 2.871 Dia. **C**
   c) Minor Dia. 1.3149-1.3230
   d) P.D. 1.3389- 1.3436 **C**
   e) Ream .2500- .2529 4 Holes
   f) Holes marked with triangle symbol must be matched to holes on 123CM11225.
   g) All Class 3 Threads.

C. Major and Minor Characteristics:

1) To be determined by contractor and acceptable to QAR.

IV. Unless expressly provided for elsewhere in this Clause, equipment such as fixtures, jigs, dies, patterns, templates, Mylar's, 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

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, (26512) 123C10209-501 Latest Rev, and specifications referenced therein.

D. Review documentation as provided under DD 1423 requirements.

E. Acceptance Test Procedures.

In addition to the above tests, the First Articles to be delivered hereunder shall also be subjected to those tests that 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.

II. **Special Instructions:**

Samples will not be considered production items.

III. **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 antisapapated 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".

FIRST ARTICLE APPROVAL (GOVERNMENT TESTING)

I. The contractor shall deliver three (3) units of lot / item 001 within 120 calendar days from the date of this contract to the government designated facility listed below.

NADEP North Island
Customer Service Bldg. 341
Attn: Debbie Rodr Code: 93001
NAS North Island
San Diego, CA 92135-7058

Marking of test sample (s) shipping container:
"FOR FIRST ARTICLE TESTING. NOT FOR RFI, 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 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 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. 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. If the Government does not act within the time specified the contracting officer shall, upon timely written request from the contractor, equitably
Adjust under the change clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.

E. 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.

F. 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.

G. 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.

CONTRACT DATA REQUIREMENTS LIST
(2 Data Items)

Form Approved
OMB No. 0704-0188

The public reporting burden for this collection of information is estimated to average 220 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 (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. Please DO NOT RETURN your form to the above address. 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 1680-00-229-6551	**E. CONTRACT/PR NO.**	**F. CONTRACTOR Competitive**

1. DATA ITEM NO.	2. TITLE OF DATA ITEM	3. SUBTITLE	
001	Certification Data Reports	Process operation Sheets	1

4. AUTHORITY (Data Acquisition Document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE	
DI-MISC-80678/T1		NADEP	1

7. DD250 REQ	9. DIST STATEMENT REQUIRED	10 FREQUENCY	12 DATE OF FIRST SUBMISSION	14. DISTRIBUTION
LT		as required	see blk 16	
8. ADP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	
A			see blk 16	

16. REMARKS
Paragraphs 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 of DI-Misc_80678 apply.
Block 12: With First Article Sample.
Block 13: To be submitted only if changed.

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCAS/ QAR	0	1	0
PCO	0	1	0
NADEP	0	1	0
15. TOTAL	0	3	0

1. DATA ITEM NO.	2. TITLE OF DATA ITEM	3. SUBTITLE	
002	Certification Data Reports	Inspection Method Sheets	1

4. AUTHORITY (Data Acquisition Document No.)	5. CONTRACT REFERENCE	6. RE2QUIRING OFFICE	
DI-MISC-80678/T2		NADEP	1

7. DD 250 REQ	9. DEST STATEMET REQUIRIED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION	14 DISTRIBUTION
LT		As required	see blk. 16	
8. ADP CODE		11 AS OF DATE	13 DATE OF SUBSEQUENT SUBMISSION	
A			see blk 16	

16. REMARKS
Block 12: With First Article Sample.
Block13: To be submitted only if changed
Paragraphs 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 of DI-Misc_80678 apply.

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCAS/ QAR	0	1	0
PCO	0	1	0
NADEP	0	1	0
15. TOTAL	0	3	0

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
David Gross	1/11/03	D. Gross	1/11/03

CONTRACT DATA REQUIREMENTS LIST
(2 Data Items)

Form Approved
OMB No. 0704-0188

The public reporting burden for this collection of information is estimated to average 220 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 (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. Please DO NOT RETURN your form to the above address. 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 1680-00-229-6551	**E.CONTRACT/PR NO.**	**F.CONTRACTOR** Competitive

1.DATA ITEM NO.	2.TITLE OF DATA ITEM	3.SUBTITLE
003	Certification Data Report	Material, and Process Sources*

4.AUTHORITY (Data Acquisition Document No.)	5.CONTRACT REFERENCE	6.REQUIRING OFFICE
DI-MISC-80678/T3		NADEP

7.DD250 REQ	9.DIST STATEMENT REQUIRED	10FREQUENCY	12DATE OF FIRST SUBMISSION
LT		As Req.	See blk. 16
8.ADP CODE		**11.AS OF DATE**	**13.DATE OF SUBSEQUENT SUBMISSION**
A			See blk. 16

16.REMARKS

Paragraphs 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 of DI-Misc_80678 apply.

Blk 12: With First Article Sample.

Blk 13: Required only if sources change.

Blk. 3: Separate Reports shall be submitted for the below listed subtitles:

Certification that all outside sources performing to Northrop-Grumman Specification are recognized as approved by Nrthrop-Grumman.

Material/ Process Certifications are required.

14.DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCAS/ QAR	0	1	0
PCO	0	1	0
NADEP	0	1	0
15.TOTAL	0	3	0

1.DATA ITEM NO.	2.TITLE OF DATA ITEM	3.SUBTITLE
004	Test Procedures	Acceptance Test

4.AUTHORITY (Data Acquisition Document No.)	5.CONTRACT REFERENCE	6.RE2QUIRING OFFICE
DI-NDTI-80603		NADEP

7.DD 250 REQ	9.DEST STATEMET REQUIRIED	10.FREQUENCY	12.DATE OF FIRST SUBMISSION
LT		One Time	With First Article Sample
8.ADP CODE		**11AS OF DATE**	**13DATE OF SUBSEQUENT SUBMISSION**
A			If Procedure Changes

16.REMARKS

Develop and submit acceptance test procedures for approval with First Article.

14 DISTRIBUTION

a.ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCAS/ QAR	0	1	0
PCO	0	1	0
NADEP	0	1	0
15.TOTAL	0	3	0

G.PREPARED BY	H.DATE	I.APPROVED BY	J.DATE
David Gross	1/11/03	D. Gross	1/11/03