

QUALITY ASSURANCE PROVISIONS

NSN: 9G 1560 00-761-9472
P/N: (78286) S6110-33406-1
NOMEN: Spindle, Rotary Rudder

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) S6110-33406-1 Rev. "L", or 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: (For all contracts and contractors)
- C. Mandatory Inspection applies: Refer to contract section C.
- D. Production Lot Testing Applies (For all contracts and contractors)

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 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:

DRAWING S6110-33406-1

Critical Characteristics:

Sheet #1

1) Zone 4D

1.5741/1.5746 dia.

2) Zone 4C

Thread 1^{3/8}-18 NEF-3A per Mil-S-7742 chamfer to be maintained after threading .060/.080x45°

3) Zone 7D

3.0005/3.00015 inside faces to be parallel within .001 T.I.R.

4) Zone 8B

(Detail B) 1.124/1.125 dia.

5) Zone 6B

Line ream .6875/.6883 dia

reamed holes to be concentric within .0005 T.I.R. and square with inside faces of lugs within .0005/in and square with 1.5746/1.5741 dia. within .0005/in

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.

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) *S6110-33406-1 "L"*, 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".

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:

NAVANDEPOT CHERRY POINT
Attn: Betty Lupton, code 6.3.674
PSC Box 8021
MCAS Cherry Point, NC 28533

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.

F. 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.

G. 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

(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 BUDGET, 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 9G1560 00-761-9472	E. CONTRACT/PR. NO.	F. CONTRACTOR
---	----------------------------	----------------------

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

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

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	14. DISTRIBUTION		
8. APP CODE A	9. DIST STATEMENT REQUIRED	11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #15	a. ADDRESSEE	b. COPIES	
					Draft	Final

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.	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">15. TOTAL</td> <td style="width: 15%;">3/0</td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> </table>	15. TOTAL	3/0		
15. TOTAL	3/0				

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

4. AUTHORITY (Data acquisition document No.) DI-MISC-80678/T2	5. CONTRACT REFERENCE	6. REQUIRING OFFICE DEFENSE SUPPLY CENTER RICHMOND
--	-----------------------	--

7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	14. DISTRIBUTION		
8. APP CODE A	9. DIST STATEMENT REQUIRED	11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE	b. COPIES	
					Draft	Final

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.	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">15. TOTAL</td> <td style="width: 15%;">1/0</td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> </table>	15. TOTAL	1/0		
15. TOTAL	1/0				

G. PREPARED BY <i>John D. Leighty</i>	H. DATE	I. APPROVED BY <i>John D. Leighty</i>	<i>pg 1 of 3</i>	J. DATE
--	---------	--	------------------	---------

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 BUDGET, 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 9G 1560 00-761-9472			E. CONTRACT/PR. NO.		F. CONTRACTOR		
1. DATA ITEM NO. 3	2. TITLE OF DATA ITEM REQUEST FOR WAIVER				3. SUBTITLE		
4. AUTHORITY (Data acquisition document No.) DI-CMAN-80640B			5. CONTRACT REFERENCE		6. REQUIRING OFFICE DEFENSE SUPPLY CENTER RICHMOND		
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION		14. DISTRIBUTION		
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION		a. ADDRESSEE	b. COPIES	
						Draft	Final
						Reg	Repro
16. REMARKS					DCMC / ACO	1/0	
					DCMC / QAR	1/0	
					PCO	1/0	
					NAVICP-P 073	1/0	
1. DATA ITEM NO. 4	2. TITLE OF DATA ITEM REQUEST FOR DEVIATION				3. SUBTITLE		
4. AUTHORITY (Data acquisition document No.) DI-CMAN-80641B			5. CONTRACT REFERENCE		6. REQUIRING OFFICE DEFENSE SUPPLY CENTER RICHMOND		
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION		14. DISTRIBUTION		
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION		a. ADDRESSEE	b. COPIES	
						Draft	Final
						Reg	Repro
16. REMARKS					DCMC / ACO	1/0	
					DCMC / QAR	1/0	
					PCO	1/0	
					NAVICP-P 073	1/0	
G. PREPARED BY <i>John D. Leighty</i>		H. DATE		I. APPROVED BY <i>John D. Leighty</i>		J. DATE <i>2of3</i>	

