

QUALITY ASSURANCE PROVISIONS

NSN: 9G 1650 00-940-9329

P/N: (78286) 65651-06013-101

NOMEN: Shaft, Swivel Hyd. SyS- Tail Rotor Servo

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65651-06013-101 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:
- C. Mandatory Inspection applies:
- 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 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 processes/operations outside of their said facility. These sheets shall not be revised or altered after successful completion of First Article/Production Lot Testing without the approval from the Basic Design Activity (BDE) 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 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: 65651-06013-101 Rev. "L"

Critical Characteristics: (Shall be defined as below, unless defined by the prime contractor(Sikorsky Aircraft)

Diametrical and linear dimensions having a total tolerance of 0.001 or less.

Surfaces finishes having a 16 vaue or less.

Any geometric feature control requirement with a total tolerance range of 0.002 or less.

Angular tolerances with a total range less than one (1) degree.

Threads specified to class 3 or greater.

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.

