

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 140 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 5.

A. CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY: TDP TM OTHER	
D. SYSTEM/ITEM 3G 1620 00-957-7336			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		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #15	a. ADDRESSEE	b. COPIES Draft Final Reg Repro
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.				DCMC / ACO	* 1/0
				DCMC / QAR	** 1/0
				PCO	1/0
				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		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE	b. COPIES Draft Final Reg Repro
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.				DCMC / ACO	* 1/0
				DCMC / QAR	** 1/0
				PCO	1/0
				15. TOTAL	
G. PREPARED BY <i>John D. Leighty</i>		H. DATE	I. APPROVED BY <i>John D. Leighty</i>	J. DATE <i>pg 1 of 2</i>	

QUALITY ASSURANCE PROVISIONS

NSN: 3G 1620 00-957-7336

P/N: (77272) A02L2020-2

NOMEN: Piston Assy, Alighti

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (77272) A02L2020-2 Rev. "D", 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 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. "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: A02L2020-2

Critical Characteristics

Zone B8

.375/.376 dia. 4 places 90 °

Zone B8

.750/.751

Zone B8

Position A .001 dia to be maintained perpendicular to B within .001

P/N: A02L2021-4

.4995 ^{+0.0015} dia. depth .62
 _{-.0000}

Zone B6

3.495/3.496 dia.

Zone C5

.5045/.5075 dia thru both walls, position to be maintained within .002 T.I.R.

Zone C5

1.6263/1.6270 dia. to be maintained perpendicular to B within .002 T.I.R.

Zone C6

Line ream .6867/.6872 dia. press NAS 538-9P-60 bushing in place (2 reqd) face off bushing after press fit. Drill .125 dia. hole thru one wall of bushing at C/L of lubricator hole. After drilling, line ream .5625/.5635 dia thru bushings.

Zone D7

212/218 dia. hole depyh .75, spotface 1.250 dia., CSK 90° X.250 dia.
thread 1/4-28unf-3B per Mil-S-7742 .25 min perfect thd. depth

P/N: 107L1538-1

.5025 ^{+0.0000} dia.
 _{-.0001}

P/N: 107L2023-1

Zone C2

This dimension to have a surface texture of 16 microinch.

View A

Datum B 3.496/3.497 dia. after plating and grinding maintaining a surface texture of 10 microinch.

Datum A 3.490/3.491 dia. before plating (after heat treatment)

P/N: 107L2551-1

.563 ^{+0.001} dia. to be maintained perpendicular to -A- within .002
 _{-.000}

1/4-28 UNF-3B per Mil-S-7742

P/N: 107L2552-1

Note # 1 Applies in its entirety.

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, 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