

QUALITY ASSURANCE PROVISIONS

NSN: 1615 01-174-6725

P/N: (78286) 65122-11254-043

NOMEN: Head Assy., Sleeve & Spindle Assy- Rotary Wing Head

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65122-11254-043 Rev. "B", or latest revision and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I-45208 applies: *or ISO 9000 Equivalent. W*
- 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 apply *or ISO 9000 Equivalent. W*
- 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 at the time of inspection.
- D. Markings should be in accordance with MIL-STD-130 Rev. "H" 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 (78286) 65122-11254-043 make from -103 REV. "B"

Zone 3C

After press fitting 65122-11258-104 machine 1.749/1.750 dia. note #6 applies, this dimension is to be maintained concentric to dia. "A" within .003 dia.

Zone 3C

3.998/4.000 dia., this dimension is to be maintained concentric to dia. "A" within .003 dia.

Zone 4B

.250 this dimension is to be maintained perpendicular to dia. "A" within .002

Zone 7D detail "B"

"C" dia 1.754/1.756 this dimension is to be maintained concentric to "A" dia within .004 dia.

Zone 7B

***drill .48 deep to point of drill
tap 10-32 unjf-3BX.32 deep full thread
per Mil-S-8879
to be maintained in true position to dia. "A" within .002 dia.***

65122-11258 rev."C" Bearing (matched set) Blade Fold Rotary Wing Head

Zone 4C

2.0625/2.0635 dia.

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.

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 / FR NO. LISTED IN BLOCK E.

A. CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY: TDP TM OTHER				
D. SYSTEM/ITEM 9G 1615 01-174-6725			E. CONTRACT/ FR. NO.		F. CONTRACTOR			
1. DATA ITEM NO. 1	2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT			3. SUBTITLE COMPLETE PROCESS OP SHEETS				
4. AUTHORITY (Data acquisition document No.) DI-MISC-90678/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-90678/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
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