

EXHIBIT F Generic Inspection Guidance for Product Acceptance

The following generic inspection guidance has been provided for DCMA Quality Assurance Representatives (QARs) to use when specific instructions have not been provided by the procuring activity. Government Source Inspection shall not be limited to these guidelines if part number specific contract requirements or other instructions have been provided to the QAR.

The following provides guidance regarding typical critical characteristics for determining inspections of CSIs. Additionally, Government quality assurance shall be provided in areas involving assurance of required destructive and nondestructive tests (e.g. proof load, pressure, leakage, operational/functional, etc) & inspections; special processes (e.g. welding; bonding and curing for composite and honeycomb assemblies, surface coatings and platings, etc.); item markings, fabrication and assembly; and special packaging or handling (e.g. control of electrostatic discharge).

Typical Critical Characteristics for CSIs (if not otherwise specified):

- Diametrical and linear dimensions having a total tolerance of .001” or less.
- Surface finishes having a 16 value, or less.
- Any other (not diametrical and linear dimensions) geometric features with a total tolerance of .002” (e.g. runout, perpendicularity, parallelism, concentricity) or less.
- Threads specified to class 3 or greater.
- Angular dimensions with total tolerance range of 1 degree (60 minutes), or less.
- Heat Treating, Stress Relieving, and Surface Hardening requirements.
- Test Methods & Acceptance Criteria for Nondestructive Testing (e.g. magnetic particle, liquid penetrant, radiographic inspection, etc.).
- Material physical properties and material certifications.
- Dynamic balancing of rotating units and static balancing of flight control surfaces.
- Flow checks for blades and vanes.
- Spray pattern requirements for fuel nozzles (incl. afterburner rings).
- Weight checks.