DEFENSE SUPPLY CENTER PHILADELPHIA
CRITICAL ITEM PROCUREMENT REQUIREMENTS DOCUMENT

DOCUMENT NUMBER

MS27576-3-11R

TITLE

BOLT, SELF-RETAINING, IMPEDANCE TYPE, 95 KSI FSU, HEX HEAD, 450°F

APPLICABLE TO: **NSN: 5306-00-460-4870**
PART NUMBER: MS27576-3-11R
COMMERCIAL AND GOVERNMENT ENTITY: 14153

CRITICAL SAFETY ITEM

PREPARED BY:	DATE: 3 June 2005
APPROVED BY:	DATE: 8/22/05

REVISIONS

SYM	DESCRIPTION	DATE	APPROVED

CRITICAL ITEM PROCURMENT REQUIREMENTS DOCUMENT (CIPRD)
MS27576-3-11R

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NSN: 5306-00-460-4870
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1. SCOPE:

This Critical Item Procurement Requirements Document (CIPRD) covers the technical requirements of the item specified in the solicitation or contract. The documents listed in paragraph 2, with current revisions are part of this package to the extent specified herein. All Military, Federal and commercial/industry specifications and standards appearing hereon or on referenced documents, are part of this procurement package to the extent specified and shall be the issue in effect on the date of the solicitation unless otherwise specified. Bolts furnished in accordance with this Critical Item Procurement Requirements Document (CIPRD) shall be products authorized by the qualifying activity.

2. REFERENCE DOCUMENTS:

NASM 27576 – BOLT, SELF-RETAINING, IMPEDANCE TYPE, 95 KSI FSU, HEX HEAD, 450°F.

NASM 83050 – BOLT, SELF-RETAINING, IMPEDANCE TYPE

3. REQUIREMENTS:
   (1) This CIPRD takes precedence over all documents referenced herein.
   (2) All manufacturing processes, dimensional, performance and verification requirements of NASM 27576 and NASM 83050 apply except as noted herein.
   (3) External threads per AS8879 Category 2. Incomplete thread length "X" from drawing NASM 27576 shall be a maximum of 1½ and a minimum of ½ thread pitches in length and major diameter to be 0.001 below minimum shank diameter.
   (4) The thread and shank of each bolt will be protected with a sleeve.
   (5) Hardness shall be verified on a 100% basis, or in accordance with a Statistical Process Control (SPC) program.
   (6) All specifications, standards, quality assurance provisions and/or drawings referenced in this CIPRD shall be of the latest revision at the time of contract award.

4. QUALITY ASSURANCE PROVISIONS:

Quality assurance shall be in accordance with NASM83050. In addition, the following Quality Assurance Provisions (QAPs) are levied by this CIPRD:

QAP EQ001	-	This Quality Assurance Provision will apply when sampling plans are not specified.
QAP EQ003	-	This Quality Assurance Provision establishes requirements for contractors' inspection systems.
QAP 1075	-	This Quality Assurance Provision establishes requirements for Product Verification Testing, Certificate of Quality Conformance and Measuring and Test Equipment.

5. PACKAGING:

(1) In addition to the labeling information specified in the contract, purchase order, and specification, each container (including the outside pack, the internal package and/or the individual unit pack) will display a label on each side of the package containing the following information:

CRITICAL SAFETY ITEM

(2) The words "CRITICAL SAFETY ITEM" will be imprinted on each thread protection sleeve.

6. QUALIFIED SOURCES:

SPS Technologies (CAGE 80539)
2701 S. Harbor Blvd.
Santa Ana, CA 92704

7. QUALIFICATION PROCEDURES:

(1) Companies wishing to qualify their product for listing in this CIPRD shall submit their request to:

Defense Supply Center Philadelphia
Office of Engineering and Technical Support
Attn: DSCP-IT
700 Robbins Avenue
Philadelphia, PA 19111

(2) Application for qualification must comply with the requirements delineated in the Qualification Attachment and the Army Source Approval requirements found at www.redstone.army.mil/cmo/. After page opening, the applicant can then select: CAPSAR (Comprehensive Automated Process for Source Approval Request) & Policy Relating to Source Approval Request (SAR) for Aviation Requirements. The CIPRD identifies the part to be a Category V (A, B, or C) Critical Safety Item. However, since it is an "Installation Critical Item Only" the requirement of QE-STD-1 Compliance is not required. Additionally, do not use Section 1 E: Comprehensive Automated Process Source Approval Request (CAPSAR) Detailed Instructions for submittal of a CIPRD. Refer to paragraph 7. (1) above, of this Instruction, for submitting your request.

(a) Any new source interested in manufacturing this item must submit a qualification test sample and successfully pass testing in accordance with NASM 83050 and instructions provided by the Contracting Officer. In addition, sources that successfully meet qualification test requirements must also meet Production Lot Testing per NASM 83050 and QAP 1075, before they are deemed as an acceptable source for listing in this CIPRD.

(b) Any established source that has manufactured this item within the last 3 years from the date of the contract order must comply with the following:
- Demonstrate that this product is still available from the listed plant, can be produced under the same conditions as originally qualified and meets the requirements of the current issue of this CIPRD and the specifications referenced herein.
- At the request of the qualifying activity, periodically submit new test data.
- At the request of the qualifying activity complete re-qualification testing.

(c) Any established source that has manufactured this item but not within the last 3 years from the date of the contract order are subject to qualification testing in accordance with NASM 83050 and Production Lot Testing in accordance with QAP 1075. However, these requirements are subject to waiver by the Contracting Officer in coordination with the responsible Engineering Support Activity (ESA).

8. CERTIFICATIONS:

(1) Copies of all records of inspection for acceptance shall be certified and shall be supplied for each production lot or portion thereof in accordance with NASM83050 requirements.

(2) The Certified Test Report prepared in conformance with NASM 83050 must be maintained on file at the manufacturer's plant for a minimum of 10 years and be made available to the government upon request.

(3) Upon request, certify that this product is still available from the listed plant and is being produced using the same manufacturing and quality control processes that were used to fabricate the qualification test sample. Documentation of the manufacturing process substantiating this certification must be on file at the manufacturer's plant for a minimum of 10 years and made available to the government upon request.

QUALIFICATION ATTACHMENT

The manufacturer's application shall be made by letter or other appropriate media and addressed to the Defense Supply Center Philadelphia, Attn: DPSC-IT, 700 Robbins Ave., Philadelphia, PA 19114. Each application must contain the number and date of the CIPRD under which tests are desired and the exact location (including complete street address) of the plant at which the product was manufactured.

In addition, the application must include certification that the applicant:

- Is the manufacturer of the product.
- Has determined from actual tests (within the limits of test equipment commonly available, unless otherwise specified) that the product conforms to the applicable CIPRD. (Test reports and data should be furnished with the application.)
- When requested, will supply products for test which are samples from the manufacturer's normal production.
- Will supply products that meet the requirements of the specification in every respect.
- Will overcome deficiencies disclosed by qualification testing.
- Will not apply for a retest of the product until satisfactory evidence is furnished that any defects disclosed by previous tests have been corrected. (Test reports may be required as evidence.)
- Will notify the qualifying activity of any change in design, material, manufacturing processes (including quality control), or plant location after qualification approval. As part of the notification the applicant will state whether he believes the change will prejudice the capability of the product to meet the qualification test requirements and state whether they intend to submit new samples for testing or desire to be removed as a qualified source.
- Will, when requested by the qualifying activity, submit a certification signed by a responsible official attesting that the applicable product is still available from the listed plant, can be produced under the same conditions as originally qualified and meets the requirements of the current issue of the CIPRD.
- Will, include provisions for self-audit of the processing, fabrication, assembly, inspection, and testing of the product. The results of the self-audit program, which promptly reports nonconformance (deviations) and corrective action to management, will be made available upon request.
- Has maintained, and will continue to maintain, effective management for quality, clearly prescribed and documented by the manufacturer. Manufacturer personnel performing quality functions will have sufficient, well-defined responsibility, authority, and the organizational freedom to identify and evaluate product quality problems and to initiate, recommend, and enforce solutions. Management will periodically review the status of the quality program for effectiveness.
- Agrees to provide the government access, upon request, to technical records, personnel, and facilities pertaining to manufacturing, processing, inspection, and testing to assure compliance with all the specification requirements.

In certain cases the government may find the information required above insufficient to justify an authorization for qualification testing. In those cases the preparing activity may request the following information, which is to be provided at no cost to the government:

- The rate at which the applicant can produce the product with his present plant facilities.

- **Sketches, photographs, descriptive booklets, or other technical literature bearing upon the product that will assist the government in obtaining a clear conception of the product or process the applicant is offering.**

- **Such additional information as is required by the applicable specification.**

Data

When requested by the qualifying activity, the applicant will furnish, at no cost to the government for test record purposes, copies of any detailed plans, specification test results, or other data required (number required and the media will be specified by the qualifying activity). If such data includes information which the applicant has determined is proprietary and does not wish disclosed to the public or used by the government for any purpose other than testing the product or process for which qualification is desired, the applicant will identify and mark the data which he considers to be proprietary. He will insert the following legend on each sheet containing proprietary data:

"These data are considered by the supplier to be submitted in confidence and furnished for the purpose of facilitating qualification testing and are not to be disclosed outside the Government nor to be duplicated, used, or disclosed in whole or in part, for any purpose other than to evaluate the product submitted for qualification testing. This restriction does not limit the Government's right to use information contained in such data if it is obtained from another source."

Data Source: USAINFO.COM 8/2/2005 06:15:17

NSN INFORMATION 5306-00-460-4870

INC: 27851 ITEM NAME: BOLT,CLOSE TOLERANCE FIIG: A003B0
CRIT F ISC 2 Status 0 TIIC 4 RPDMRC 4 ADP DEMIL A HMIC N ESDEMI PMI U

MCRL Information 5306-00-460-4870

Part No.	rncc	rnvc	rnfc	sadc	dac	cage	Vendor Name
106467-3-11	5	2	4		5	80539	SPS TECHNOLOGIES
AS194-3-11	5	2	4		5	84256	AVIBANK MFG INC
CA4510-3-11	5	9	4		5	29372	ALCOA GLOBAL FAS
MS27576-3-11	5	9	3		4	96906	MILITARY STANDAR
MS27576-3-11	3	2			E	80205	NATIONAL AEROSPA

ML-C Information 5306-00-460-4870

SA	SOS	mcd	UI	QUP	AAC	SLC	RC	CIIC	eff_date	price
DF	S9I	SF9SX-V	EA	1	D	0	N	U	2004275	10.15
GP	S9I		EA	1	D	0		U	2004275	10.15
DA	S9I	T22BJX-	EA	1	D	0	Z	U	2004275	10.15
DS	S9I		EA	1	D	0		U	2004275	10.15

No ML-C Phrase Statements Found for NSN: 5306-00-460-4870

Major Organizational Entity (MOE) Data 5306-00-460-4870

Moe Rule	Moe Code	pica	amc	amsc	nimsc	imc	imca	aac	Collaborators	Receivers
A187	DA	KZ	1	G		Z	CT			CT
C004	GP	KZ	1	G						
FXKZ	DF	KZ	1	G		Z	SX			
YB01	YB	YB								
YJ01	YJ	YJ								
ZA01	ZA	ZA								
ZH01	ZH	ZH								
ZK01	ZK	ZK								
ZN01	ZN	ZN								
ZU01	ZU	ZU								

Technical Characteristics (ILs) 5306-00-460-4870

mrc	requirement	reply
AAJD	THREAD CLASS	3A
AASA	THREAD LENGTH	0.236 INCHES MINIMUM AND 0.318 INCHES MAXIMUM
AASB	FASTENER LENGTH	1.060 INCHES MINIMUM AND 1.080 INCHES MAXIMUM
AASK	HEAD STYLE	C3 DISHED HEXAGON

AASU	HEAD HEIGHT	0.095 INCHES MINIMUM AND 0.110 INCHES MAXIMUM
AATB	WIDTH BETWEEN FLATS	0.367 INCHES MINIMUM AND 0.376 INCHES MAXIMUM
AAUR	GRIP DIAMETER	0.1885 INCHES MINIMUM AND 0.1894 INCHES MAXIMUM
AAWB	SHANK UNTHREADED HOLE DIAMETER	0.070 INCHES MINIMUM AND 0.080 INCHES MAXIMUM FIRST HOLE
ANEE	GRIP LENGTH	0.688 INCHES MINIMUM AND 0.704 INCHES MAXIMUM
FEAT	SPECIAL FEATURES	RETAINING ELEMENT IN SHANK

Current Procurement History Information 5306-00-460-4870

AwardDate	Contract_No	ContractX	SOS	Qty	Price	Total	UI	cage	Vendor Name
10/28/2004	SP054005M1720	MODF0002	S9I	300	9.18	2,754.00	EA	0UCY9	M.S. AEROSPACE
10/28/2004	SP054005M1720	MODF0001	S9I	800	9.18	7,344.00	EA	0UCY9	M.S. AEROSPACE
8/30/2004	SP054004MT016	MODF0001	S9I	300	15.60	4,680.00	EA	0UCY9	M.S. AEROSPACE
3/14/2002	SP054002MQPR4	MODF0001	S9I	440	6.48	2,851.20	EA	5R386	TPS AVIATION INC
5/31/2001	SP054001MQXJ5	MODF0002	S9I	125	6.48	810.00		5R386	TPS AVIATION INC
5/31/2001	SP054001MQXJ5	MODF0001	S9I	165	6.48	1,069.20		5R386	TPS AVIATION INC
11/28/2000	SP054001MQF01	MODF0001	S9I	300	9.25	2,775.00		1V757	WESCO AIRCRAFT H

Contract Technical Data File: Weapon Systems 5306-00-460-4870

Src	wsdc	crit	ricfm	Definition
S9I	02F	C	OO-ALC	AIRCRAFT, PHANTOM F-4
S9I	41F	C	OO-ALC	AIRCRAFT, T-37
S9I	BYF	C	OC-ALC	ENGINE, AIRCRAFT, J69-T-25 (T-37B)
S9I	61A	A	AMCOM	HELICOPTER, APACHE AH-64
S9I	LBA	C	AMCOM	AH-64-D LONGBOW
S9I	42F	B	OO-ALC	AIRCRAFT, T-38
S9I	YYA	C	AMCOM	AIRCRAFT MH-47E SPECIAL OPERATIONS AIRCRAFT
S9I	05A	A	AMCOM	HELICOPTER, CHINOOK, CH-47

VENDOR INFORMATION CAGE:80539

Co.Name	SPS TECHNOLOGIES INC DIV AEROSPACE - SANTA ANA
Address	2701 S HARBOR BLVD
City /State /Zip	SANTA ANA, CA 92704-5803
Country	UNITED STATES
Phone	714-850-3609
SIC	3452
FLIS Hits	22286
ProcHist Hits	337

Type A **Affil** D **Size** A **Pri. Bus.** J **Woman** N **Type Bus** N

Replaced CAGE: **Assoc. CAGE:** 0EXY1 **OE Status** A **CAO** S0513A **ADPP** HQ0339

VENDOR INFORMATION CAGE:84256

Co.Name	AVIBANK MFG INC
Address	11500 SHERMAN WAY