

QUALITY ASSURANCE PROVISIONS

SPECIFICATION:

NSN 5306-01-140-3063, P/N: (76301) 74A410548-2005
NOMEN: F-18 MLG Bolt, Close Tolerance-Planning Link

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (76301) 74A410548-2005 REV. "J ", and all details and specifications referenced therein as supplemented by Boeing.

The contracting officer must approve incorporation of any supplemental changes to the configuration of the item. Any successful offeror is required to demonstrate at time of contract award, intent to secure a bilateral agreement with Boeing. Contracting officer must receive a copy of the bilateral agreement **within 60 days** after contract award.

Failure of the contractor to provide the contracting officer with a copy of the bilateral agreement within 60 days of contract award is justification for termination under default clause of this contract.

The bilateral agreement with Boeing shall provide for the following:

1. Boeing Certification, in accordance with the appropriate CDRL, that the offeror has in its possession, complete technical data representing the latest configuration including all engineering orders, changes in design, etc., and that such data are used in manufacture of the part, purchased under this contract.
2. Boeing review, disposition and certification of all Material Review Board actions, requests waivers and deviations and any requests for acceptance of material non-conformities.
3. Boeing review and approval of Process/Operation Sheets -Manufacturing Planning for all fracture and maintenance critical items.
4. Boeing participation, performance, review and approval of First piece inspection for all contract items as required.

Certification is required that all critical processes to include acquisition of forging/castings have been procured from Boeing approved source(s) in accordance with the appropriate CDRL.

I. Quality Assurance /Inspection Requirements

- A. MIL-I-45208 applies:
- B. First Article/ First Production Lot Inspection/Test applies:
- C. Mandatory Inspection applies:

II. Supplemental Requirements

- A. Additionally, Para. 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 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 Piece/ First 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.
- D. Markings should be I/A/W MIL STD 130 latest Rev applies. Method and location shall be I/A/W drawing.
- E. 300 M Steel is highly susceptible to corrosion. Proper preservation of this material before, during and after the machining process is essential.

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 I/A/W a sampling plan acceptable to the QAR.

B. Critical Characteristics:

Diametrical and liner dimensions having a total tolerance of .001 or less.

Surface finishes having a 16 value or less.

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

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

Threads specified to class three (3).

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 item(s) will not be provided by 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 or referenced specification.

Markings should be I/A/W MIL-STD-130 latest Rev applies. Method and location shall be I/A/W drawing.

FIRST ARTICLE TESTS REQUIRED (Contractor Testing)

. First Article Inspection/Test Criteria

The tests to be performed under the First Article approval clause of the contract are:

A. Dimensional Check: to ensure proper form

B. Compliance with drawing, (76301) 74A410548-2005 Rev "J" and specifications referenced therein. This inspection shall be performed at the contractor's facilities using the same testing facilities and equipment as will be used for production.

a. Parts having dimensions prior to and after processing such as plate, shall be available in both conditions when presenting for First Article.

1. Dimensional check of detailed parts prior to assembly to include forging prior to machining.

2. Review of documentation as provided under CDRL (DD1423) requirements

3. Review of the following documentation:

(Note: All documentation required under this contract shall be provided in English.)

Process/Operation sheets. Manufacturing planning and travelers.

Critical Process Certification

Completed Inspection Method documents. (Note: First Piece inspection requires all characteristics to be listed with actual recorded measurements.)

Material certifications: Documentation certifying that the material used in manufacture of the items is in accordance with the applicable drawing and material specification including test results.

4. Boeing is required to participate, witness and review First Article and provide certification in accordance with the applicable CDRL.

5. When specified on the drawing, the contractor will be responsible for having the First Article Engineering Examination (FAEE) be performed by Boeing Engineering personnel and witnessed by the government. **Note:** FAEE is to be performed by a Boeing Senior Strength Engineer.

In addition to the above tests, the First Article Sample(s) to be delivered hereunder shall also be subjected to those tests, which will demonstrate that the sample(s) comply with contract requirements.

C. Review documentation as provided under DD 1423 requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article (s) during testing.

II. Testing Facility:

A. Testing shall be performed in-house by the DCM/QAR, at the contractor's facility.

III. Notification of Testing: The contractor shall notify the PCO, ACO, and QAR prior to conducting First Article Tests so the Government may witness such testing.

A. The QAR shall be present to witness all First Article Tests.

IV. Test Report: The test report shall be in accordance with MIL-STD-831 and shall be submitted (2 copies) via the Cognizant CAO/QAR to the PCO. CAO/QAR shall provide comments on form DD 1222 (2 copies) which shall be forwarded with the test report. Approval of the test report is the PCO's responsibility. Upon notification of approval/conditional approval, the ACO shall execute the DD 250 to indicate Government acceptance of the test report.

V. Disposition of First Article Sample (s):

A. Samples may be considered as production items under the contract provided the samples can be refurbished to ready for issue (RFI) condition and provided the samples have inspection approval of the cognizant QAR. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

FIRST ARTICLE APPROVAL (CONTRACTOR TESTING)

A. The contractor shall test 5unit (s) of lot/item 0001 as specified in this contract. At least 15 calendar days before the beginning of First Article Testing, the contractor shall notify the contracting officer, in writing, of the time and location of the testing so the Government may witness the tests.

B. If the First Article is disapproved, the contractor, upon Government request, shall submit an additional First Article for testing. After each request, the contractor shall make any necessary changes, modification, or repairs to the First Article or select another First Article for testing. All costs related to these tests are to be borne by the contractor, including any and all costs for additional tests following disapproval. The contractor shall furnish any additional First Article to the Government under the terms and conditions and within the time specified by the Government. The Government shall act of this First Article within the time limit specified. The Government reserves the right to require an equitable adjustment of the contract price for any extension of the delivery schedule or for any additional costs to the Government related to these tests.

C. If the contractor fails to deliver any First Article on time, or the contracting officer disapproves any First Article, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract.

D If the Government does not act within the time specified, the contracting officer shall, upon timely written request from the contractor, equitably adjust under the changes clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.

E. Before First Article approval, the acquisition of materials or components for, or the commencement of production of, the balance of the contract quantity is at the sole risk of the contractor. Before First Article approval, the costs thereof shall not be allocable to this contract for 1)-progress payments, or 2) termination settlements if the contract is terminated for the convenience of the Government.

F. The contractor shall produce both the First Article and the production quantity at the same facility and shall submit a certification to this effect with each First Article.

G The contractor shall provide specific written notification to the procuring contractor officer informing him/her of the shipment of any articles furnished in accordance with this clause. Such notification must be addressed to the attention of the ACO with copies to the testing activity. Failure to provide such notification shall excuse the government from any delay in performing First Article Testing and informing the contractor of the results thereof.

B.

PRODUCTION LOT TESTING (CONTRACTOR TESTING)

A. The cognizant CAO/QAR shall select the applicable number of items at random from the production lot per the ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes. In addition the QAR shall select the applicable number of items at random from each successive lot or portion thereof per the ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes.

The Production Lot Test shall be performed at the contractor's facility and be witnessed and accepted by the DCMA QAR. A written test report shall be forwarded to the PCO IAW DD1423 requirements.

B. Such samples shall be tested in sufficient time prior to the delivery date of the production articles to allow a 45 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 15 days of the receipt of the samples, the CAO shall notify the contracting officer, *Defense Supply Center Philadelphia code*: of the results of the testing, together with a recommendation for approval or disapproval.

C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular production lot within 120 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

The samples shall be identified by contract number, lot number and be clearly marked as follows:

PRODUCTION LOT TEST SAMPLES
NOT RFI MATERIAL
DO NOT TAKE UP IN STOCK

D. If the contractor fails to deliver any Production Lot Samples for testing within the time specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.

E. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all of the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such event, the Government may, at its option and at no additional cost to the Government, (I) terminate all of any portion of this contract for default, (II) require the manufacture of a new production lot, or a rework of the rejected Production Lot if the means and procedures proposed by the contractor for rework are acceptable to the Government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked production lots in the same way as they did to the original Production Lot.

F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of the failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the Government the costs of re-inspection, shipping, examination and retesting by the Government, and the contractor and his sureties (if any) shall be liable for the amount of such costs.

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G. Nothing contained in the foregoing provisions of this clause, and no action of the Government in accordance herewith, shall in any way prejudice the right of the Government under the clause of this contract entitled Default.

CONTRACT DATA REQUIREMENTS LIST

(2 Data Items)

Form Approved
OMB No. 0704-0188

The public reporting burden for this collection of information is estimated to average 220 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 Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. Please DO NOT RETURN your form to the above address. Send completed form to the Government Issuing Contracting Officer for the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY:	
		TDP <input checked="" type="checkbox"/>	TM <input type="checkbox"/> OTHER <input type="checkbox"/>

D. SYSTEM/ITEM	E. CONTRACT/PR NO.	F. CONTRACTOR
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1. DATA ITEM NO. 0001	2. TITLE OF DATA ITEM Certification Data/ Reports	3. SUBTITLE CRITICAL PROCESS SOURCE VERIFICATION	17. PRICE GROUP
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4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T	5. CONTRACT REFERENCE	6. REQUIRING OFFICE NAVICP-PHILA	18. ESTIMATED TOTAL PRICE
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7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQUIRED	12. DATE OF FIRST SUBMISSION SEE BLK 16	14. DISTRIBUTION	
8. ADP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLK 16	a. ADDRESSEE	b. COPIES

16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4 AND 10.5 APPLY UPON SUBMISSION OF TEST SAMPLES----INCLUDE WITH TEST REPORT	DCMC-ACO	1/0	
	DCMC-QAR	1/0	
	PCO	1/0	

1. DATA ITEM NO. 0002	2. TITLE OF DATA ITEM Certification Data/ Reports	3. SUBTITLE FORGING SOURCE VERIFICATION	17. PRICE GROUP
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4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T	5. CONTRACT REFERENCE	6. REQUIRING OFFICE NAVICP-PHILA	18. ESTIMATED TOTAL PRICE
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	DCMC-QAR	1/0	
	PCO	1/0	

G. PREPARED BY ROBERT J NEJMAN	H. DATE 10-10-04	I. APPROVED BY ROBERT J NEJMAN	J. DATE 10-10-04
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