

QUALITY ASSURANCE PROVISIONS**C-321: SPECIFICATION:**

NSN: 9Z 5306-01-317-4315

P/N: (78286) 70209-27007-105

NOMEN: Bolt, Shear

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 70209-27007 REV. "H1", or the latest revision, and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I-45208A applies: refer to contract section E or ISO 9002 equivalent.
- B. First Article Testing applies: contract section I.
- C. Production Lot Testing Applies: contract section C.
- D. Mandatory Inspection applies: contract section C.
- E. ISO 9002 Certification

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.
- 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 process/operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or Production Lot Testing without approval from the basic design 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. 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 of all critical characteristics.
- D. Markings should be I/A/W MIL-STD-130 REV. "J" para. 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.

IV. 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

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1. .8740-.8730 Dia. Drawing (78286) 70209-27007, Rev. "H", Zone C7
2. .7500-16 UNJF-3A THD per Mil-S-8879, Zone C5
3. Drawing note 7 (shot peen)
4. Drawing note 11 (dry film lubricant)
5. Drawing note 12
6. Drawing note 15
7. Protective finish requirement: Passivate per SS 8435
8. Penetrant Inspection per SS 8806

C. Major and Minor Characteristics

- 1) Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.

V. 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 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.

I-961 FIRST ARTICLE TESTS REQUIRED (GOVERNMENT TESTING)

NSN: 9Z 5306-01-317-4315

P/N: (78286) 70209-27007-105

NOMEN: Bolt, Shear

I. First Article Inspection/Test Criteria:

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

A. Dimensional Check 100%

B. Form, Fit and Function

C. Compliance with drawing (78286) 70209-27007 Rev. "H1" and associated drawings, latest revisions, and specifications referenced therein.

D. Review documentation as provided under DD1423 requirements.

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

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

II. Samples to be submitted for testing: Quantity 2 each.

A. Estimated Cost: T.B.D.

B. Waiver of First Article Testing requirements may be granted for (78286) United Technology Sikorsky Aircraft.

III. Testing shall be performed at the Government designated facility listed below.

Nadep Cherry Point (N65923)

F.A.T. Control Center

Attn: Annie Brown, Code 6.1.523

PSC Box 8021

MCAS Cherry Point, NC 28533-5030

IV. Special Instructions

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

B. Sample(s) will be returned to the contractor, if not destroyed in testing.

B. One sample will be destroyed during testing and will not be returned to the contractor, and one sample will not be destroyed during testing and will be returned to the contractor.

C. Waiver of the destruction of the First Article test piece may be granted if the contractor provides a test coupon with certificates that the test coupon is of the same material, and has undergone the same special processes as the F.A.T. test piece.

D. Corrosive areas are to be coated with a light preservative.

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Sample(s), the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

Upon shipment of First Article Sample(s), two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to DSCR Code __, with duplicate copies to NAVICP Code 072 and to the designated test facility. The envelopes shall be clearly marked. "DO NOT OPEN IN MAILROOM".

Within 90 days after receipt of sample(s) the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to the P.C.O.

C-330 PRODUCTION LOT TESTING REQUIREMENTS

NSN: 9Z 5306-01-317-4315

P/N: (78286) 70209-27007-105

NOMEN: Bolt, Shear

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

I. Production Lot Test Sampling Requirements

A. The cognizant CAO/QAR shall select two (2) item(s) at random from the first production lot. In addition the QAR shall select one (1) item(s) at random from each successive lot or portion thereof.

B. Production Lot Testing to be completed during production after First Article approval.

C. Sample(s) are to be unpainted. Corrosive areas are to be coated with a light preservative.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

A. Compliance with drawing (78286) 70209-27007 REV. "H1", or the latest revision, and the specifications referenced therein.

B. Dimensional Check 100% of finished part

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

D. Form/Fit

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

III. Testing Location, Cost and Estimated Leadtime

A. Ship samples/data to NAD, Cherry Point, POC: Annie Brown, Code:6.1.523

B. Shipping container marking: NON RFI

C. Estimated Cost for Inspection/Test is TBD

D. Estimated Lead-time for Inspection/Test is TBD

REQUIREMENTS LIST

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 Department of Defense, Washington Headquarters Service, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed forms to the Government Printing Contracting Officer for the Contract/PR No. listed in Block E.

CONTRACT LINE ITEM NO. **5306-01-317-4315** B. EXHIBIT C. CATEGORY TDP _____ TM _____ OTHER _____
STEM/ITEM
E. CONTRACT/PR NO. F. CONTRACTOR

1. DATA ITEM NO. **0001** 2. TITLE OF DATA ITEM **Certification Data Reports** 3. SUBTITLE **Complete Process Operation Sheets**
4. AUTHORITY (Data Acquisition Document No.) **DI-MISC-80678/T** 5. CONTRACT REFERENCE
6. REQUIRING OFFICE **Nadep Cherry point 3.3.2**
7. DD 150 REQ **LT** 8. APP CODE **A** 9. DIST STATEMENT REQUIRED 10. FREQUENCY **as required** 11. AS OF DATE 12. DATE OF FIRST SUBMISSION **see block 16** 13. DATE OF SUBSEQUENT SUBMISSION **see block 16**
14. REMARKS **10.1, 10.2, 10.2.2, 10.2.4, 10.2.5 apply**
*** upon submission of First Article/Production Lot Test sample(s)**
**** If the process/operation sheets change after successful completion of FAT/PLT**

a. ADDRESSEE	b. COPIES	
	Draft	FINAL
	Req	Repro
dcmo/aco	1/0	*
dcmo/qar	1/0	**
pco	1/0	
15. TOTAL	3/0	

17 PRICE GROUP
18 ESTIMATED TOTAL PRICE

1. DATA ITEM NO. **0002** 2. TITLE OF DATA ITEM **certification data/reports** 3. SUBTITLE **completed inspection method sheets**
4. AUTHORITY (Data Acquisition Document No.) **DI-MISC-80678/T2** 5. CONTRACT REFERENCE
6. REQUIRING OFFICE **Nadep Cherry Point 3.3.2**
7. DD 150 REQ **LT** 8. APP CODE 9. DIST STATEMENT REQUIRED 10. FREQUENCY **as required** 11. AS OF DATE 12. DATE OF FIRST SUBMISSION **see block 16** 13. DATE OF SUBSEQUENT SUBMISSION **see block 16**
14. REMARKS **para. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 apply**
*** upon submission of First Article/ Production Lot Test sample(s)**
**** At time of contract completion**

a. ADDRESSEE	b. COPIES	
	Draft	FINAL
	Req	Repro
dcm/aco	* 1/0	*
dcm/qar	** 1/0	**
pco	1/0	
15. TOTAL	3/0	

17 PRICE GROUP
18 ESTIMATED TOTAL PRICE

1. DATA ITEM NO. **0003** 2. TITLE OF DATA ITEM **Request for Deviation** 3. SUBTITLE
4. AUTHORITY (Data Acquisition Document No.) **DI-CMAN-80641 B** 5. CONTRACT REFERENCE
6. REQUIRING OFFICE **Nadep Cherry Point 3.3.2**
7. DD 150 REQ **LT** 8. APP CODE 9. DIST STATEMENT REQUIRED 10. FREQUENCY **as required** 11. AS OF DATE 12. DATE OF FIRST SUBMISSION **see block 16** 13. DATE OF SUBSEQUENT SUBMISSION **as required**
14. REMARKS **original**

a. ADDRESSEE	b. COPIES	
	Draft	FINAL
	Req	Repro
dcm/aco	1/0	
dcm/qar	1/0	
pco	1/0	
15. TOTAL	3/0	

17 PRICE GROUP
18 ESTIMATED TOTAL PRICE

1. DATA ITEM NO. **0004** 2. TITLE OF DATA ITEM **request for waiver** 3. SUBTITLE
4. AUTHORITY (Data Acquisition Document No.) **DI-CMAN-80640B** 5. CONTRACT REFERENCE
6. REQUIRING OFFICE **Nadep Cherry Point 3.3.2**
7. DD 150 REQ **LT** 8. APP CODE 9. DIST STATEMENT REQUIRED 10. FREQUENCY **as required** 11. AS OF DATE 12. DATE OF FIRST SUBMISSION **see block 16** 13. DATE OF SUBSEQUENT SUBMISSION
14. REMARKS

a. ADDRESSEE	b. COPIES	
	Draft	FINAL
	Req	Repro
dcm/aco	1/0	
dcm/qar	1/0	
pco	1/0	
15. TOTAL	3/0	

17 PRICE GROUP
18 ESTIMATED TOTAL PRICE

PREPARED BY **Greg Witalec 0731.20** H. DATE **9/29/00** I. APPROVED BY J. DATE
JUN 90
FORM 0102-LF-010-5400
Previous editions are obsolete

Within fifteen days of completion of Production Lot Testing the CAO/QAR shall prepare and submit two copies of their test report with conclusions and recommendations to the Contracting Officer.

V. Shipment and Distribution of Samples:

- A. Fourteen (14) days prior to shipment of Production Lot samples, the contractor shall notify the designated test facility in writing, of the anticipated shipping date, with an information copy to the P.C.O. The contractor shall also arrange for preliminary inspection of the test samples by the CAO/QAR.
- B. Upon shipment of Production Lot Samples, two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the P.C.O. and to the designated test facility. The envelope shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.
- C. Samples may be considered as production items under the contract provided the samples can be refurbished to Ready For Issue (R.F.I.) condition and provided the samples have inspection approval of the cognizant CAO/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.
- D. Samples will be returned to the contractor.
- E. The designated test facility and the contracting officer shall be notified as to all shipping data applicable to the samples, such as bill of lading number, method of shipment, etc... 14 days prior to shipment.

