QUALITY ASSURANCE PROVISIONS

C-321: SPECIFICATION

NSN: 9G 1615 01-125-7098
NOMEN: LINER, MAIN GEARBOX

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 64351-11023-133 Rev."P" or latest revision, and all details and specifications referenced therein.

I. Quality/Inspection Requirements

A. MIL-I-45208 applies:
B. First Article Testing applies:
C. Mandatory Inspection applies: Refer to contract section C.
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.

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 Article or 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 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 64351-11023-133 REV. "P"

1) Zone E5
This surface is to be maintained perpendicular to datum F within .001
2) Zone D4
This dia. 1.833 / 1.838 is to be maintained concentric to datum F within .002 dia.
3) Zone C8 (data block)
Dia. A 2.004 / 2.005 is to be maintained round within .002

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 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.

I-961 FIRST ARTICLE TESTS REQUIRED (Contractor Testing)

I. First Article Inspection/Test Criteria

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

A. 2 ea. Samples to be submitted for First Article Testing

B. Dimensional Check: to ensure proper form

C. Compliance with drawing, (78286) 64351-11023-133 Rev. "P", and specifications referenced therein.

D. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Articles to be delivered hereunder shall also be subjected to those tests which will demonstrate that the articles comply with contract 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 DCMO/QAR, at the contractors 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 (2copies) 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.

C-330 PRODUCTION LOT TESTING REQUIREMENTS **[CONTRACTOR]**

NSN: 9G 1615 01-125-7098 **P/N:** (78286) 64351-11023-133
NOMEN: LINER, MAIN GEARBOX

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

I. Production Lot Test Requirements

A. The cognizant CAO/QAR shall select two (2) item (s) at random from the 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 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) 64351-11023-133 REV "P*** or latest revision and all specification referenced therein.

B. Dimensional Check

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:

A. All testing will be accomplished at the contractors facility.

Within fifteen (15) days of completion of Production Lot Testing the CAO/QAR shall prepare and submit two (2) copies of their test report with conclusions and recommendations to the Contracting Officer.

IV. NOTIFICATION OF TESTING:
The contractor shall notify the PCO, ACO, and QAR prior to conducting Production Lot Tests so the Government may witness such testing.

A. the QAR shall be present to witness all Production Lot Testing.

V. Shipment and Distribution of Samples

A. Sample(s) may be considered as production items under the contract provided sample(s) can be refurbished to ready For Issue (RFI) condition and provided sample(s) have inspection approval of the cognizant DCMAO. 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.

C331 PRODUCTION LOT SAMPLE TESTING [CONTRACTOR TESTING]

A. The Production Lot Samples shall be selected at random by the cognizant government QAR. The samples shall be identified by contract number, lot number, and be clearly marked as follows: PRODUCTION LOT TEST SAMPLES
NOT R.F.I. MATERIAL
DO NOT TAKE UP IN STOCK

B. Such samples shall be tested in sufficient time prior to the delivery 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 Richmond code:*** of the results of the testing, together with the 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 lot within 60 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

D. If the contractor fails to deliver any Production Lot Samples for testing within the time or times 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 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 or 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 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 a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting and the contractor and his sureties (if any) shall be liable for the amount of such costs.

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

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 BUDJET, 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 / PR NO. LISTED IN BLOCK E.

A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY: TDP TM OTHER
D. SYSTEM/ITEM 9G 1615 01-125-7098	E. CONTRACT/ PR. NO.	F. CONTRACTOR

1. DATA ITEM NO.	2. TITLE OF DATA ITEM	3. SUBTITLE
0001	CERTIFICATION DATA REPORT	COMPLETE PROCESS OP SHEETS

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-MISC-80678/T1		DEFENSE SUPPLY CENTER RICHMOND

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	SEE BLOCK #16
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION
A		AS REQ	SEE BLOCK #15

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.

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO	*	1/0	
DCMC / QAR	**	1/0	
PCO		1/0	
15. TOTAL		3/0	

1. DATA ITEM NO.	2. TITLE OF DATA ITEM	3. SUBTITLE
0002	CERTIFICATION DATA REPORT	COMPLETE INSPECTION METHOD SHEETS

4. AUTHORITY (Data acquisition document No.)	5. CONTRACT REFERENCE	6. REQUIRING OFFICE
DI-MISC-80678/T2		DEFENSE SUPPLY CENTER COLUMBUS

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		AS REQ	SEE BLOCK #16
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION
A		AS REQ	SEE BLOCK #1`6

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.

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO	*	1/0	
DCMC / QAR	**	1/0	
PCO		1/0	
15. TOTAL			

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
John D. Leighty		John D. Leighty	

CONTRACT DATA REQUIREMENTS LIST
(1 Data Item)

Form Approved
OMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 110 hours pe 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, 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 addressess. Send completed form to the Government Issuing Contracting Officer of the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY: TOP _____ TM _____ OTHER _____
D. SYSTEM/ITEM **9G 1615 01-125-7098**	E. CONTRACT/PR	F. CONTRACTOR
1. DATA ITEM 0003	2. TITLE OF DATA ITEM **CERTIFICATION DATA / REPORTS**	3. SUBTITLE
4. AUTHORITY (Data Acquisition **DI-MISC-80678/T3**	5. CONTRACT REFERENCE	6. REQUIRING OFFICE **DEFENSE SUPPLY CENTER RICHMOND**

7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION
LT		**AS REQ**	**SEE BLOCK 16***
8. APP CODE **A**		11. AS OF DATE **AS REQ**	13. DATE IF SUBSEQUENT **SEE BLOCK 16***

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 APPLY

BLOCK#12 -UPON SUBMITTAL OF FIRST ARTICLE SAMPLE (S) AND/OR PRODUCTION LOT SAMPLE.

BLOCK #3-SEPERATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUB TITLES. CERTIFICATION REPORTS FOR PRIME PROCESS AND MATERIAL SPECIFICATIONS SHALL INCLUDE CERTIFICATION THAT ALL VENDORS PREFORMING THESE PROCESSES ARE PRIME (OEM) (78286) Sikorsky Afct. APPROVED SOURCES.

BLOCK #5 - CONTRACT REFERENCE: P/N: (78286) 64351-11023-132 rev."P"
Material: Timken Tube 4320 or 8620 (alternate material AMS 6371-4130 stl., ASTM A534-8620 stl. tube.
Mag Particle Insp. per SS8805
After rough machineing heat treat to 125,000 PSI min UTS rockwell C26-33 per Mil-H-6875.
black oxide CL I per Mil-C-13924

14. DISTRIBUTION

a. ADDRESSEE	b. COPIES Draft	Final Reg	Final Repro
DCMC / ACO		1/0	
DCMC / QAR	*	1/0	
PCO	**	1/0	
		3/0	

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
John. D. Leighty		John. D. Leighty	

DD Form 1423-1, JUN 90 *Previous editions are obsolete.*

1007/183 S/N 0102-LF-010-5500