

GD-OTS, Inc. First Article Requirements for Design, Material and/or Process Changes					
Codes for Suppliers:	Codes for Internal Operations:	Full Requalification Testing of Process/Gage	Full FAIR per AS9102 or equivalent (Most recent revision)	Tailored (Delta) FAIR per QE*	Validate via First Piece and Process Controls
S - Submit to GD-OTS SQE R - Notify SQE and retain data on file only w/inspection records I - Perform internally & no need to notify GDATP (unless otherwise specified by purchase order)	S - Ops QE to conduct FAT & document through AS9102 form or equivalent R - Ops QE to conduct FAT & document through AS9102 form or equivalent I - Perform internally & no need to notify Ops QE (unless otherwise specified)				
1.0 Changes to Design					
1.1 Design changes resulting in change to system MOD designation		S	S		
1.2 Any change impacting safety or system performance requirements		S	S		
1.3 Changes that affect items requiring outside agency involvement (i.e. Navy weapon system Explosive Safety Review Board (WSRSRB), Army Fuse Board, Etc.)		S	S		
1.4 Changes that impact either system or component level interface requirements		S	S		
1.5 Changes resulting from unexpected events such as part obsolescence		S	S		
1.6 Use of a lower reliability part		S	S		
1.7 Performance data for the new or redesigned item not sufficient to demonstrate that it will perform to the same extent as the item it is replacing		S	S		
2.0 Changes to Manufacturing Facility					
2.1 Manufacturing plant location change			S		
2.2 Out of production over twenty-four months			S		
2.2.1 Castings/Forgings				S	
2.3 Addition of a dedicated production line			S		
2.4 Dismantling and restarting a dedicated production line					R
2.5 Replacing an existing piece of machinery with an identical piece of machinery (same make & model)					R
2.6 Replacing an existing piece of machinery with a machine of a different make & model				S	
2.7 Adding a new machine (relieving bottleneck) - same master code if applicable					R
2.8 Changing the original, allowable sequence of the manufacturing process (including adding / deleting operations)				S	
2.9 Moving equipment/machines within a facility					R
2.10 Replacing an existing piece of machinery with the same model					R
3.0 Changes to Manufacturing Processes					
3.1 Major change in manufacturing process (e.g., casting instead of forging or hog-out, tool path changes, sequence of cuts)			S		
3.2 Minor change in manufacturing process (e.g., New Tool Type, etc)					R
3.3 Replacement or major repairs to a casting and press molds				S	
3.4 Changes in cleaning materials used during coating of components				S	
3.5 Changes early in the manufacturing process such as, cleaning materials which have no effect on contract conformance				S	
3.6 Minor maintenance to casting and press molds to maintain parting lines and reduce flashing				S	
3.7 Replacement of normal machining wear items (saw blades, cutting tools, etc.)					I
3.8 Performing normal machine offsets due to tool wear					I
3.9 Minor changes to work instructions that have no effect on the process					I
3.10 General maintenance of fixtures/lifting devices/handling equipment					I
3.11 Changing the special process (heat treat, plating, time, temp, chemistry, etc.)				S	
3.12 Replacing an existing piece of machinery with a machine of a different type (e.g. lathe to a mill, manual to CNC, etc.)			S		
3.13 Changing same model CNC machines using identical program and identical setup (Tools, fixtures, etc)					I
3.14 Change of inspection test method and/or equipment				R	
3.15 Change or repair to AIE (acceptance inspection equipment) gaging	R				
3.16 Changes to literature or Instructions for Use (IFU)					R
3.17 Changes affecting sterility, bioburden, and/or compatibility				S	
3.18 Any changes that affect the packaging if specified by the print or TDP					R
3.19 Use of new, reworked, modified, relocated, or reactivated manufacturing tooling (e.g. jigs, dies, fixtures, molds, patterns, etc.)				R	
4.0 Changes to Material/Supply					
4.1 Change in supplier of end item part			S		
4.2 Change in supplier of the material				S	
4.3 Change in supplier for component within an end item part				S	
4.4 Change in supplier for off the shelf and MIL-STD parts provided chemical and/or physical properties are maintained					R
4.5 Change from one qualified test laboratory to another qualified laboratory					R
4.6 Change in supplier of special/outside processing services				S	
* In accordance with the instructions or after notification as to extent of change					