

# GENERAL DYNAMICS

## Ordnance and Tactical Systems

### Healdsburg Supplier Quality Requirements

QR-0024

Revision	Date
-	02/27/2019

## Baseline Inspection

### Revision History

REV.	CN #	DATE INCORP.	NOTES
-	40764	02/27/2019	Initial Release

### Requirements

The Supplier shall maintain complete documentation of all procurement, manufacturing, subcontracted processes, and inspection/test processes to assure that the production baseline can be established at any point in time. The purpose of Baseline Inspection (BI) is to verify hardware is compliant when manufactured to specified controlled documents such as work instructions, material processing systems and controls, tools & fixtures, inspection/test equipment, and personnel capability. These documents form the product baseline. Additionally, the Baseline Inspection shall assure that all identified and related documentation is controlled in a manner that precludes any GD unapproved change to the process and/or product. This Baseline Inspection procedure is based on the requirements of SAE AS9102. Supplier is to evaluate processes and verify that all process elements are identified and under control. This is to include verification that all planning, software programs and tooling are in place and under configuration control, and all required inspections as identified below.

Required inspections:

1. KC data (as required)
2. Variable sample data from the delivered lot, or a 3 piece minimum sample when base line is a separate PO delivery.

Baseline Inspection Report to include:

1. Inspection data (from above)
2. Process configuration elements (as applicable):
  - Certificate of Conformance (CoC)
  - Outside process certificates
  - Material certificates

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- List of all special tooling, with tool identifier and revision
- List of all process documents (work instructions, travelers, CNC/CMM/other software, etc. with revision).
- List of all subcontracted processors

The Supplier shall assure that changes in any item listed in the Baseline Report require a GD-approved Process Change Request (VF094) prior to incorporation into the manufacturing process defined by the baseline documentation. The Supplier shall provide either appropriate technical documentation demonstrating, or a plan documenting their approach to assuring, that the new condition has not degraded the safety, quality, reliability, or long-term storage of the product provided. If in doubt, ask before implementing any change. GD-OTS Healdsburg shall review the items submitted, the corresponding data and the report, and provide written approval of the BI Report. In the event that the BI Report is not approved, specific details of Corrective Actions (CA) shall be provided for the Supplier to address. GD's approval must be in writing before you proceed.

If the Supplier has a GD-OTS Healdsburg approved BI Report and there has been no change in configuration, manufacturing process, procedures, location, source of processing, and the item has been manufactured within the last 12 months, a new Baseline Inspection is not required for subsequent orders. Changes to any of the above listed conditions will require a Delta Baseline Inspection ( $\Delta$  BI).