

# GENERAL DYNAMICS

## Ordnance and Tactical Systems

### Healdsburg Supplier Quality Requirements

QR-0047

Revision	Date
-	02/27/2019

## Electronic Equipment Workmanship

### Revision History

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

### Requirements

The following workmanship requirements shall apply for Electronic Equipment (ref MIL-HDBK 454B Guideline 9):

- Work Environment: Work/inspection area where product is handled, assembled and tested shall be clean in order to prevent FOD (Foreign Object Debris) or cross contamination.
- Cleaning: Only pre-approved cleaning processes will be used. After fabrication, parts and assembled equipment should be cleaned of smudges; loose, spattered, or excess solder; weld metal; metal chips and mold release agents; or any other foreign material which might detract from the intended operation, function, or appearance of the equipment (an example is residual masking material).
- Machined (and threaded) parts or devices: Show no evidence of cross threading, mutilation, or burrs, and are free of oils and films unless specified in requirements document(s).
- Bearing assemblies: Bearing assemblies should be free of rust, discoloration, and imperfections of ground, honed, or lapped surfaces. Contacting surfaces should be free of tool marks, gouge marks, nicks, or other surface type defects. There should be no detrimental interference, binding, or galling.
- Wiring: Wires and cables should be positioned or protected to avoid contact with rough or irregular surfaces and sharp edges and to avoid damage to conductors or adjacent parts.

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- Shielding: Shielding on wires and cables should be secured in a manner that will prevent it from contacting or shorting exposed current-carrying parts. The ends of the shielding or braid should be secured to prevent fraying.
- Insulation: There should be no evidence of burns, abrasions, cuts or pinch marks.
- Clearance: The clearance between wires or cables and heat generating parts should be sufficient to minimize deterioration of the wires or cables.