



### **Q618 Inspection and Test Equipment Validation Plans and Reports (Rev 09/04/19)**

The Seller and its suppliers shall maintain and ensure all production and manufacturing related equipment, including inspection and test equipment (ITE); tools; fixtures; jigs are appropriate and capable of the required accuracy and precision for determining conformance to all technical and contractual requirements, design, and performance and process characteristics.

Where a Baseline Qualification FAT is required, inspection and test equipment used to inspect characteristics identified as Safety, Special, Critical or Major are subject to validation. An ITE Validation plan will be authored by GD-OTS with input from the supplier. Suppliers are required to comply with all aspects of the approved plan. ITE Validation is subject to approval by GD-OTS and the validation shall be completed and approved by GD-OTS prior to the execution of the Baseline Qualification FAT. Repeatability and Reproducibility studies are required as part of the ITE Validation for Test Equipment and Inspection Equipment that is new, modified, or relocated. Variable R&R studies shall have a P/T ratio less than or equal to 0.25.

Where new or modified inspection or test equipment is to be used to inspect or test characteristics classified in the Technical Data Package as Safety, Special, Critical, or Major, the Seller shall submit an Inspection and Test Equipment Validation Plan. The Validation Plan shall be submitted in the format of the GD-OTS Gage Validation Plan Template, QS-TP-10.6.8. The template can be obtained on the GD-OTS SharePoint collaboration site.

The Seller is responsible for ensuring that existing inspection and test equipment is capable of performing the required inspection with sufficient accuracy and precision for determining conformance to all technical and contractual requirements in accordance with Q640 -Inspection and Test Measurement Guard Banding.

- i. An Inspection and Test Equipment Validation Plan shall not be executed until approved by GD-OTS, Inc. Should GD-OTS, Inc. reject a Plan submission, a revision to the Plan shall be submitted to GD-OTS, Inc. within ten (10) calendar days of the rejection.
- ii. Provision shall be made for GD-OTS, Inc. and/or Government representatives to witness all or any portion of the execution of the Validation Plan at their discretion. As such a minimum of twenty-one (21) calendar day notice is required prior to beginning execution of the Plan.

Upon completion of the execution of the Validation Plan the Seller shall submit the completed validation data sheets to GD-OTS within five (5) workdays of completion of the execution of the validation. GD-OTS will author the formal validation report for submission to the Government. Use of Inspection and Test equipment shall not be initiated prior to approval by GD-OTS, Inc.