

GENERAL DYNAMICS

Ordnance and Tactical Systems

Weapons Systems Supplier Quality Requirements Site 21-Quality – Williston VT / Saco ME

Quality Clause	Revision	Phase In Date
Q111	0	04/03/2019

Q111–First Article Inspection AS9102 - 2 Year Req

Requirements

First Article Inspection Report (FAIR) must be submitted to Supplier Quality Assurance and approval received before shipping material. Do not include the FAIR with the first material shipment. GD-OTS approval of the FAIR locks the process and it shall not be modified without written approval by GD-OTS in advance. For SEP suppliers the more restrictive requirement of QSP-INS-53.13 or Q111 applies. FAI will be performed on a part from the initial production lot provided by the supplier.

Any modifications to these requirements shall be specified within the Purchase Order.

The FAIR includes all of the following:

- 1) First Article Inspection and any required test results submitted per AS9102;
- 2) process flow diagrams generated to include manufacturing, inspection and special process operations;
- 3) manufacturing process (e.g., routing sheets, manufacturing/quality plans, manufacturing work instructions, etc.).
- 4) evidence that indicators of process control are established. These may include but are not limited to monitoring specific characteristics, process capability studies, key characteristics identified, functional checks, and required frequency of gage calibration or gage R&R.
- 5) If part marking is required per drawing, a photo of the part marking as applied on the part must be included with First Article package. Photo must clearly depict marking content and location.

Clarifying information and instructions:

- 1) AS9102 forms, or equivalent, shall be used to document the results of the first article inspection as required in the specification. These forms may be generated by any media, but must contain all the information required by AS9102.
- 2) Report actual dimensions/results for all characteristics as well as applicable drawing notes.
- 3) Multi-cavity molds/dies require each cavity to be qualified.
- 4) The supplier shall forward the FAIR along with applicable material or test data/certifications (e.g., NDT, painting, plating, composition, X-ray, functional testing, etc.) with the lot. The completed routers supporting the FAIR must be available upon request.
- 5) The supplier is required, unless permission is granted contractually, to use the same unit of measure as specified in the technical data package when reporting inspection.

Printed copy for reference only.

For current version, see: www.gd-ots.com/Williston/QC/

- 6) A representative of the supplier's Quality Department shall review, sign, and date the report.
- 7) The exclusion for unique single run production orders not intended for ongoing production (AS9102 Rev B, Section 1.3 Applicability), shall not apply.
- 8) At the discretion of GD-OTS, during the performance of the FAI, the part and its required systems, procedures, and facilities are subject to surveillance by purchaser representatives.
- 9) Seller shall notify Supplier Quality Assurance before production begins for the coordination and planning of the FAI. FAI may include the witnessing of in-process inspections to be accomplished during performance of FAI.

Following GD-OTS review and approval of the initial FAIR, resubmission is required in the event of changes as delineated in QSP-TMP-10.0.1

A FAIR is required for all products except for the following:

- 1) standard catalog items (ref. AS9102 Standard Catalog Hardware, FAR 2.101 Commercial Item definitions);
- 2) raw material; or,
- 3) product covered by a military/industry standard or specification.