

GENERAL DYNAMICS

Ordnance and Tactical Systems

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

Quality Clause	Revision	Phase In Date
Q74	1	07/28/2020

Q74–High Strength Fasteners

Requirements

Fastener Quality Act: Any item/material covered under Public Law 101-592 shall conform to all requirements of the Fastener Quality Act and all applicable amendments.

For critical hardware - "plated/coated & Rockwell 'C' 36 min or 160,000 psi min - the producer shall maintain lot traceability and identity through all processes, including but not limited to the following: (1) raw material, (2) thread rolling, (3) heat treatment, (4) test/inspection, (5) finishing (i.e. cadmium plating) (6) pack and ship.

Certification required: Plating - if Cad plated, shall conform to QQ-P-416, Rev F. Cad plated fasteners produced prior to Rev F shall be baked for a minimum of 23 hours at 375+/- 25 degrees F within four hours after plating. Stripping and replating is expressly prohibited. Cadmium plating solutions shall be low luster containing no brighteners or additives which produce brightened deposits.

MIL-STD-1312, Test #5, by the torque method for 23 hours. A minimum of four (4) pieces randomly selected from each lot shall be tested. The failure of any one piece shall reject the lot. In the event the fastener is unable to be tested by the torque method, the notched specimen procedure of paragraph 4.6.4.1 of QQ-P-416F may be used. Samples randomly selected per the procurement specification shall be hardness tested to verify conformance to the applicable specification. Each piece shall be permanently marked with the producer's trademark that is listed in MIL-HDBK-57B (is) except where size of the piece prohibits such marking.

All heat treat, plating, finishing, magnetic particle or penetrant inspection shall be performed by sources approved by General Dynamics. A certificate of compliance from the supplier or manufacturer stating that the material meets all the requirements of the drawing and purchase order shall accompany each shipment.