

GENERAL DYNAMICS

Ordnance and Tactical Systems

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

Quality Clause	Revision	Phase In Date
Q86	1	07/28/2020

Q86–Soldering

Requirements

Suppliers who choose to solder in accordance with ANSI/IPC/J-STD-001 Class 3 shall provide General Dynamics with written confirmation to this effect no later than 60 days prior to manufacture of first article test samples or the first production lot.

Suppliers who choose to solder in accordance with detailed, soldering process plan that is generated by the supplier shall provide the plan to General Dynamics for review and approval no later than 60 days prior to manufacture of first article test samples or the first production lot.

Detailed soldering process plans generated by the supplier shall include the procedures to be used for all soldering and soldering-related operations including: hand soldering, tinning, solderability testing or verification, automated soldering, inspection, and process controls. Each procedure shall describe the operation in sufficient detail to ensure that the performance requirements for the item being manufactured are being met. As a minimum, each procedure shall include the process, tools, equipment, materials and acceptance criteria for the operation. In all cases, Procedures and requirements for preparation and soldering of electrical connections shall meet the requirements of ANSI/J-STD-001, Class 3 (except as otherwise directed by the Technical Data Package (TDP)).