

# GENERAL DYNAMICS

## Ordnance and Tactical Systems

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

Quality Clause	Revision	Phase In Date
<b>Q92</b>	<b>0</b>	<b>04/02/2019</b>

## Q92 – First Article Inspection (Forwarded to GD-OTS) (MK19 and M2 Programs)

### Requirements

First Article Inspection Report (FAIR) submittal and approval is required prior to the first 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.

A first article inspection report containing a recording of the actual readings on 100% of all characteristics and notes of the drawing/specification on five parts shall be forwarded to GD-OTS.

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.

(If specified by drawing or special process spec that dimensions apply AFTER finish, then five finished parts shall be forwarded to GD-OTS. If dimensions BEFORE finish (e.g. phosphate) or if unspecified when dimensions apply, forward five finished parts AND five unfinished parts with the first shipment. If parts are ordered unfinished, then forward five unfinished pieces with the first article inspection data.)

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

Clarifying information and instructions:

**Printed copy for reference only.**

For current version, see: [www.gd-ots.com/Williston/QC/](http://www.gd-ots.com/Williston/QC/)

- 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.
- 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.
- 6) A representative of the supplier's Quality Department shall review, sign, and date the report

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 which is available through the GD-OTS Supplier Portal ([https://www.secure.GD-OTS.com/main/sign\\_on.asp](https://www.secure.GD-OTS.com/main/sign_on.asp)). Always reference the online document for current requirements.

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.
- Q92T – First Article Inspection, BAE Contract Requirement, 1 year lapse

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:

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- 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.
- 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.
- 6) A representative of the supplier's Quality Department shall review, sign, and date the report.

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 which is available through the GD-OTS Supplier Portal Exception to QSP-TMP-10.0.1 for lapse in production – a lapse in production greater than 12 months will require a new FAI. Contact the Buyer and SQE prior to exceeding the 12month window and prior to submitting the FAI.

([https://www.secure.GD-OTS.com/main/sign\\_on.asp](https://www.secure.GD-OTS.com/main/sign_on.asp)). Always reference the online document for current requirements.

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,
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