

GENERAL DYNAMICS

Ordnance and Tactical Systems

Seattle Supplier Quality Requirements

Quality Note
[6.61]

Revision	Date
-	05/16/2012

STATISTICAL PROCESS CONTROL (SPC)

REVISION HISTORY

REV.	EFFECTIVE DATE	NOTES
-	05/16/2012	Initial Release

The applicable revision of this document is determined by:

- The revision specified on the purchase order, or
- The revision in effect at the time of the purchase order if no revision is listed on the purchase order.

REQUIREMENTS

Supplier shall validate the acceptability of the product being manufactured/processed (at supplier's facility or at a sub-tier supplier's facility) on this order using statistical process control (SPC) techniques which meet the intent of American National Standards Institute (ANSI) Z1.1, Z1.2, and Z1.3. A plan for the implementation of SPC shall be submitted to the GD-OTS buyer for approval at least 2 weeks prior to the start of manufacture and/or processing of the material. As a minimum, all characteristics identified as critical by GD-OTS must be included in the SPC plan. Statistical evidence of product acceptability in the form of control charts shall be prepared for each characteristic identified in the approved SPC plan. The supplier must also demonstrate that the manufacturing process is capable of maintaining a Cpk of 1.33 or greater on all characteristics identified in the SPC plan. Any characteristics identified in the SPC plan which is not shown to be stable with a Cpk of 1.33 or greater must be screened 100% and objective evidence must be provided with each shipment that the order was screened 100% for that characteristic.

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