

1. SQAR Number	SQAR-20
2. SQAR Revision	9
3. SQAR Title	Control Plan
4. SQAR Detail Description	
<p>The Supplier shall prepare a control plan for the items to be delivered under the Purchase Order. The control plan shall be submitted to the General Dynamics OTS Buyer for approval at the time of FAI. The plan shall include at a minimum:</p> <ol style="list-style-type: none">Part Number and NameDrawing Number with RevisionProcess Name/Operation DescriptionCharacteristics/Features to be inspected or testedCharacter class (Major, Minor, Critical, Special, Key)Specification with toleranceEvaluation/Measurement TechniqueSample size and frequencyControl Method (X-MR, Xbar&R, Set-up Sheet, Check Sheet, Lab Report, Record Sheet, Traveler, etc.)Reaction Plan <p>The control plan shall contain all inspection/test points throughout the entire manufacturing process. The Supplier shall only utilize what has been defined in the plan and any changes to the approved plan shall require approval, by the General Dynamics OTS Buyer, prior to implementation. An example is located in PAL 128, Data/Source Inspection Request/Approval Workbook, as well as a template.</p>	
5. Disclaimer	
<p>The following Supplemental Quality Assurance Requirement (SQAR) clause is a requirement when specified by number within the Request for Quote (RFQ), Purchase Order (PO), or Quality Assurance Document (QAD). In the event of conflict between the General Supplier Quality Assurance Requirements document, PAL 164, and a SQAR flowdown, the SQAR will always supersede. Flowdown of this SQAR to sub-tier suppliers is required to ensure final product compliance.</p>	