

GENERAL DYNAMICS

Ordnance and Tactical Systems

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

Quality Clause	Revision	Phase In Date
Q113	2	03/19/2021

Q113–Supplier Part & Process Approvals

Requirements

First Article and Process Approval submittal is required prior to the first production shipment of product. The following requirements shall be completed by the supplier and submitted to GD-OTS for review, retention and approval. The original data package is to be retained by the supplier in accordance with the purchase order. Product shall not be shipped prior to FAI and Process approval. Any modifications to these requirements shall be specified within the Purchase Order.

Required elements shall be follows:

1. Master Part Sample(s) shall be permanently identified as “Master” adjacent to the area defined by drawing for part marking via engraving, die stamping, or other method prior to finish processing, suitable for visible identification after processing. A photograph of the master part, displaying the “Master” and part marking per drawing requirement shall be submitted with the FAI package. Master part(s) shall be retained at the Supplier for the life of the Purchase Order, plus two (2) years. (Contact GD-OTS prior to the disposal of any “Master”)
2. First Article Inspection, using the same unit of measurement as specified in the technical data package, and Test Results completed and submitted per AS9102.
3. Process Flow diagrams generated to include all manufacturing, inspection and special process operations.
4. Process FMEAs performed and submitted to GD-OTS.
- 5.A. Process Control Plan, for Key, Critical, or Major characteristics as identified by the Technical Data Package, or by GD-OTS within the Purchase Order.
- 5.B. Process Capability Studies and Gage R&R on measuring instruments shall be completed and submitted for these identified characteristics.
6. Work Instructions for all internal manufacturing and quality operations.

Printed copy for reference only.

For current version, see: www.gd-ots.com/Williston/QC/

After First Article sample(s) and data and the Production Process is approved by GD-OTS, the process is considered “Locked” and shall not vary without a request for change submitted to and approved by GD-OTS in advance of any change.

Resubmission is required after a 24 month lapse in production, or in the event of process changes delineated in QSP-TMP-10.0.1 is available through the GD-OTS Supplier Portal (<https://www.gd-ots.com/wp-content/uploads/2018/10/QSP-TMP-10.0.1.pdf>). Always reference the online document for current requirements.