

GENERAL DYNAMICS

Ordnance and Tactical Systems

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

Quality Clause	Revision	Phase In Date
Q73	1	10/05/2021

Q73–Key Process Characteristics (KPC) II

Requirements

Variation management in accordance with AS9103 shall be performed on key characteristics or processes. The AS9103 specification with applicable forms can be found at www.sae.org. AS9103 forms or equivalent shall be used to document the results for each part or assembly produced that influence variation, as well as the control techniques and measurement methods. Any dimensional documentation must be in the same unit of measurement as specified in the technical data package. Copies of the AS9103 report for each lot of product produced shall be submitted to the GD-OTS Supplier Quality Engineer (SQE) on a quarterly basis.

The supplier and/or sub-tier supplier shall execute a plan for KPCs. The plan shall be designed to minimize KPC variation from nominal. The supplier and/or sub-tier supplier shall implement SPC or other control measures to ensure KPCs meet a minimum Cpk of 1.33. The supplier and/or sub-tier supplier shall document action plans for improvement to processes not meeting the minimum capability requirement. This shall include process monitoring of KPCs or may consist of the monitoring of other appropriate characteristics.