

GENERAL DYNAMICS Ordnance and Tactical Systems	ST. PETERSBURG, FLORIDA		
	SUPPLIER QUALITY CLAUSE		
TITLE	QUALITY CLAUSE	REVISION	EFFECTIVE DATE
STATISTICAL PROCESS CONTROL	S6	0	June 9, 2023
<small>Material and/or services supplied to purchase orders must be in accordance with all quality clause requirements and any additional requirements outlined on the Purchase Order.</small>			

1.0 REFERENCES

- DI-MGMT-81987 (Latest revision unless stated otherwise): Statistical Process Control (SPC) Plan
- MIL-STD-1916 (Revision as stated on Technical Data Package List (TDPL)): Department of Defense (DoD) Preferred Methods for Acceptance of Product

2.0 REQUIREMENTS

An SPC Plan and SPC Report shall be submitted in accordance with the descriptions and requirements of DI-MGMT-81987. This requirement is regarding SPC being used as a method of controlling a manufacturing process. If no SPC is being used in the subcontractors manufacturing operations, an exception must be submitted in writing and approved per the instructions given in the General Supplier Quality Clause “S1” for exceptions.

Suppliers are also encouraged to consider SPC as an alternate method for lot acceptance, as referenced in MIL-STD-1916. The contractor shall verify process capability, the current minimum values of process capability are equivalent to a Process Capability Index (Cpk) of 2.00 for critical characteristics and 1.33 for majors. If this is of interest, please make this interest known to your General Dynamics Ordnance and Tactical Systems (GD-OTS) Supply Chain contact and your GD-OTS Supplier Quality Engineer for further discussion.

Three data submittals are required for this clause. A General SPC Plan, a Detailed SPC Plan and a SPC Report. The General SPC Plan (S6-1) will discuss the philosophy of the organization with regards to the use of SPC, how variables are selected for data capture, and how the data is used for process control. This would include a discussion of how AIE requirements will be included in the SPC Plan. Should the supplier choose to utilize SPC for acceptance, the gaging used for the SPC must be approved by GD-OTS in advance. The Detailed SPC Plan (S6-2) will specify the precise variables to be addressed by SPC, show any existing information for processes already under control by virtue of relatively continuous production and show the format of the data report that will be submitted. The SPC Report (S6-3) will provide the data for GD-OTS production as outlined in the Detailed SPC Plan.

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3.0 QUALITY CLAUSE DELIVERABLES (QCD)

Microsoft Office or PDF formats are preferred. All subcontractor data submittals shall be in English. These data items shall be submitted to GD-OTS in accordance with the QCD as indicated below. The method of submission to GD-OTS St. Petersburg is specified in the General Supplier Quality Clause "S1" located on GD-OTS's Supplier Portal <https://www.gd-ots.com/suppliers/quality-clauses/> under GD-OTS St. Petersburg, FL.

NO.	TITLE	GD-OTS APPROVAL REQUIRED	SUBMITTAL TIMING/FREQUENCY
S6-1	General SPC Plan	Yes	Unless otherwise directed in the Subcontract/Purchase Order (PO) or Special Instructions document provided by GD-OTS; QCD is due 60 calendar days prior to production, First Article (FA), or Physical Configuration Audit (PCA), whichever comes first.
S6-2	Detailed SPC Plan	Yes	Unless otherwise directed in the Subcontract/Purchase Order (PO) or Special Instructions document provided by GD-OTS; QCD is due 60 calendar days prior to production, First Article (FA), or Physical Configuration Audit (PCA), whichever comes first.
S6-3	SPC Report	Yes	Unless otherwise directed in the Subcontract/PO or Special Instructions document provided by GD-OTS; QCD is due 7 calendar days after completion of a deliverable production lot.

4.0 REVISION HISTORY

REV	DATE	CHANGE
0	06/09/2023	ECN23315-Initial Release