

GENERAL DYNAMICS

Ordnance and Tactical Systems

Healdsburg Supplier Quality Requirements

QR-0036

Revision	Date
B	10/18/2023

Inspection Sampling Plan

Revision History

REV.	CN #	DATE INCORP.	NOTES
-	40764	02/27/2019	Initial Release
A	87376	01/03/2023	Added SQR 36D – Special Inspection
B	95251	10/18/2023	Added SQR 36E – Level I, AQL 1.5

Requirements

The Seller shall perform lot sample inspection on items to be delivered under the Purchase Order, in accordance with this SQR. Lot sampling does not relieve the Seller from responsibility to assure conformance of every part lot. If inspection data is required to be submitted, the data shall be reported for each sample requiring inspection. In all cases where defective items are found within the sample, the entire lot shall be inspected 100% for the characteristic found to be out of specification and all defective items found shall be either corrected, or removed from the lot. Electronic submission of inspection data through secure methods of transmission as approved by General Dynamics is the preferred method of inspection data submittal.

Sample sizes shall be determined as follows, with references to AQL per ANSI/ASQ Z1.4. In all cases, Single Sampling per ANSI/ASQ Z1.4 is used.

SQR 36 – General Inspection, Level II, 1.5 AQL, Normal

Lot Quantity			Sample Size
2	to	90	*8
91	to	280	32
281	to	500	50
501	to	1,200	80
1,201	to	3,200	125
3,201	to	10,000	200
10,001	to	35,000	315
> 35,000			See ANSI/ASQ Z1.4

* If lot size is less than 8, inspect 100%

SQR 36 – General Inspection, Level II, 1.5 AQL, Normal

SQR 36A – General Inspection, Level II, 2.5 AQL, Normal

Lot Quantity			Sample Size
2	to	50	*5
51	to	150	20
151	to	280	32
281	to	500	50
501	to	1,200	80
1,201	to	3,200	125
3,201	to	10,000	200
10,000	to	35,000	315
> 35,000			See ANSI/ASQ Z1.4

* If lot size is less than 5, inspect 100%

SQR 36A – General Inspection, Level II, 2.5 AQL, Normal

SQR 36B – 100% Inspection

All parts shall be inspected. The Seller shall provide 100% dimensional inspection data of features shown on drawings, specification documents, or contained in the Purchase Order for 100% of the deliverable quantity under the Purchase Order. Inspection includes verification of notes shown on the drawing. Where 100% inspection is inappropriate (i.e. destructive testing, plating compliance, painting, etc.) the Seller shall coordinate with the Buyer the means utilized to verify the required test/inspection data such as using surrogate items (coupons), certification reports, etc. in lieu of direct verification.

SQR 36C – Inspection Sampling for Key Characteristics

When invoked on the drawing, this SQR section applies to Key Characteristics (KCs), as specified on GD-OTS drawings, SOWs or other PO documentation. The drawing symbol for a KC is \diamond . Sampling KCs is based on the tolerance range of the specific features per Table A and Table B criteria, below.

- **Table A.** Use Table A for KC features dimensioned 0.XX +/- 0.01 (Block tolerance) and 0.XXX +/- 0.005 (Block tolerance)
- **Table B.** KC features dimensioned 0.XXX, tolerance tighter than +/- 0.005 or 0.XXXX (any tolerance).

Lot Quantity			Table A	Table B
2	to	8	*2	*3
9	to	15	3	5
16	to	25	5	8
26	to	50	8	13
51	to	90	13	20
91	to	150	20	32
151	to	280	32	50
281	to	500	50	80
501	to	1,200	80	125
1,201	to	3,200	125	200
3,201	to	10,000	200	315
10,001	to	35,000	315	500
> 35,001			Request from GD-OTS buyer	

* If lot size is less than minimum sample size, inspect 100%

SQR 36C – KC Inspection

SQR 36D – Special Inspection, Level S3, 2.5 AQL, Normal

When specified (**typically for molded and/or stamped parts produced from qualified tooling**), this SQR section applies to Special Level S-3, as specified on GD-OTS drawings, SOWs, or other PO documentation. Special Levels are given where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

Lot Quantity			Sample Size
2	to	15	*2
16	to	50	3
51	to	150	5
151	to	500	8
501	to	3,200	13
3,201	to	35,000	125
> 35,000			See ANSI/ASQ Z1.4

* If lot size is less than minimum sample size, inspect 100%

SQR 36D – Special Inspection, Level S3, 2.5 AQL, Normal

SQR 36E – General Inspection, Level I, 1.5 AQL, Normal

Lot Quantity			Sample Size
2	to	280	*8
281	to	1200	32
1201	to	3200	50
3201	to	10,000	80
10,001	to	35,000	125
35,001	to	150,000	200
150,001	to	500,000	315
> 500,000			500

* If lot size is less than 8, inspect 100%

SQR 36E – General Inspection, Level I, 1.5 AQL, Normal