

GENERAL DYNAMICS Ordinance and Tactical Systems	ST. PETERSBURG, FLORIDA		
	SUPPLIER QUALITY CLAUSE		
TITLE PLAN OF INSPECTION (POI), LOT ACCEPTANCE RECORDS (LAR), AND CERTIFIED MATERIAL TEST REPORTS (CMTR)	QUALITY CLAUSE S3	REVISION 2	EFFECTIVE DATE APRIL 10, 2025
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.			

1.0 REFERENCES

- MIL-STD-1916 (Revision as stated on Technical Data Package List (TDPL)): Preferred Methods for Acceptance of Product
- MIL-STD-1168 (Revision as stated on (TDPL)) Ammunition Lot Numbering and Ammunition Data Card

2.0 REQUIREMENTS

The subcontractor is responsible to obtain all applicable documentation, perform all applicable inspections and/or tests required by the subcontract to ensure full compliance to all drawing and/or technical specification requirements for the procured items and/or services prior to shipment. Whether quantitative, qualitative, attribute and/or variable; the subcontractor shall ensure that there is adequate Objective Quality Evidence (OQE) documentation to indicate the acceptance status of the procured items and/or services provided under this subcontract. OQE includes any documentation generated during the production and inspection of product pertaining to the quality of the product or service based on observations, measurements, and/or tests that can be verified, whether quantitative or qualitative. Evidence shall be expressed in terms of specific quality requirements or characteristics. These characteristics are identified in the Quality Assurance Provisions (QAP), drawings, specifications, and other technical data that describes the item, process, or procedure.

The subcontractor shall not return items or sublevel items into a deliverable lot that were utilized during a destructive inspection/test or any item or sublevel item which may no longer meet the item specification due to excessive handling, damage, or exposure to the environment without written authorization by General Dynamics Ordnance and Tactical Systems (GD-OTS).

All references to MIL-STD-105, MIL-STD-414, MIL-STD-1235, and/or ANSI/ASQ Z1.4 appearing in the Technical Data Package (TDP) for this subcontract shall be replaced by the DOD Preferred Methods for Acceptance of Product MIL-STD-1916.

3.0 PLAN OF INSPECTION (POI)

Prepare in subcontractor format.

3.1 GENERAL SECTION OF POI

The POI General Section Requirements shall contain the minimum requirements specified in Table 1- Document Requirements QCD (S3-1)

Formation of Lots- The term “inspection lot” as used in this specification is defined as an essentially homogenous collection of units of product from which a representative sample is drawn and inspected to determine conformance with applicable requirements. The sample selected shall represent only that quantity of units from which the sample was drawn and shall not be construed to represent any prior or subsequent quantities presented for inspection. Homogeneity shall be

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considered to exist provided the inspection lot has been produced by one manufacturer, in one unchanged process, in accordance with the same drawings, same drawing revision, same specification, and same specification revision and complies with the provisions for submission of product as specified in MIL-STD-1916 as modified by the QAP. Changes to the process, specification, or drawing not affecting safety performance, interchangeability, or storage, as determined by the Government, shall not be deemed to alter the homogeneity of an inspection lot. All material submitted for inspection in accordance with this specification shall comply with the homogeneity criteria specified herein and in lots complying with the lot formation provisions of MIL-STD-1916

The subcontractor's methodology for formation and control of production lot numbering per MIL-STD-1168. Prior to changing the Lot Interfix number, the subcontractor shall notify in advance GD-OTS for authorization of the change. Lot Interfix changes the subcontractor shall specify the reason for the change of Lot Interfix number per MIL-STD-1168 and will need to receive written approval from GD-OTS prior to implementation.

Table 1- POI General Section Requirements
NOTE: If TDPL changes only the POI General Section needs to be resubmitted.
POI General Section Revision and or date
Part Number and Revision and any applicable Engineering Change Proposal(s) (ECP)
Part Name
Name and Address of Supplier
Formation of Lot
QAP and Revision
TDPL and revision
Process Flow Table or Process Flow Chart – sequentially identifying all manufacturing, inspection Examination and Testing operations. For example: Non-Destructive Testing, Static Fire, Chemical Analysis, Mechanical Analysis, Special Processes, etc.
Receiving Inspection (materials, components, assemblies, or services) including any Customer Furnished Material (CFM) or Government Furnished Material (GFM)
Acceptance Inspection Equipment (AIE), Measurement System Evaluation (MSE), or Acceptance Automated Inspection Equipment (AAIE)
Revision Change Table- defining change, date, rev of POI General Document Requirements

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3.2 POI INSPECTION REQUIREMENTS

The POI defines the requirements for all of the inspections or tests to be conducted on an assembly or component to meet QAP and TDPL requirements shall be submitted as QCD (S3-2). The POI shall be a record of inspection/testing that meets the requirements specified in Table 2.

The inspection system will detail the tests and inspections to be performed on the product being procured from receiving inspection to final inspection and shipment. It will provide OQE of the subcontractor's methods for complying with the inspection aspects of the contract and the TDP to substantiate product conformance. Any changes to the product TDP, inspection processes, gaging methodologies, manufacturing processes, location, acceptance testing, facilities and/or environmental requirements require a revision to the POI and approval by GD-OTS prior to implementation.

Sampling Inspection shall be per MIL-STD-1916, with verification levels (VL) as defined by the Quality Assurance Provision (QAP) or contract.

Table 2- Plan Of Inspection
POI Revision and or date
Part Number
Part Name
Specification (MIL- STD, ASTM...)
Acceptance Inspection Equipment (AIE) -Gage Description and number
Automated Acceptance Inspection Equipment (AAIE)- Gage Description and number
Inspection Process Number
QAP characteristic description, QAP Characteristic number (Critical, Major, Minor, Special)
Dimension and tolerance
Acceptable Quality Limit (AQL) – Sampling Plan and Verification Level
Statistical Process Control (SPC) – when utilized for acceptance and United States Government approved- define SPC Attribute or Variable and charting used (np, p, Xbar, RChart, MR, other)
SPC Rules- (ie. Western Electric Rules or Shewhart Rule or other)
SPC- define operations and dimension where SPC is implemented and approved for use
Revision Change Table- defining change, date, rev of POI

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3.3 LOT ACCEPTANCE RECORD (LAR) AND CERTIFIED MATERIAL TEST REPORT (CMTR)

The LAR document is the document that captures the manufacturing lot inspection results and shall be submitted as QCD (S3-3).

Inspection/testing results are required by GD-OTS to document the details of the inspection systems tests, Sample size, and inspection results performed on the product defined by the POI.

The LAR shall be in the subcontractor's format, a record of inspection/testing that meets the requirements specified in Table 3, and applicable item specifications. The subcontractor shall incorporate the Inspection provisions specified in the TDP and Special Instructions, as applicable.

The POI shall provide a copy of the applicable inspection forms to be used. (Typically, these will be in-process and final inspection sheets, attribute or variable inspection reports, applicable acceptance test requirements, applicable laboratory test reports which are employed as a permanent record of the inspection/test results).

The (CMTR) documents material and tests results used for validating compliance to specification and drawing requirements for all, Non-Destructive Testing, Special processes, physical, mechanical, and chemical properties of the material under test. The CMTR shall provide actual variable data when available (for example Hardness, Tensile, Chemical, results). The CMTR shall be provided for the FAAT and PCA when performed, submitted as QCD (S3-4). The CMTR shall be in the subcontractor's format, a record of inspection/testing that meets the requirements specified in Table 3, and applicable item specifications. At any time, GD-OTS may request the CMTR during manufacturing and the supplier shall provide upon request.

Table 3- Lot Acceptance Test or Lot Acceptance Report Document Requirements	
LAR, CMTR	Name of Supplier
LAR, CMTR	Title and Purpose of Document or Requirement
LAR, CMTR	Part Number, Part Revision (ECP, Request for Variance (RFV) if applicable)
LAR, CMTR	Part Name
LAR, CMTR	Date of Inspection
LAR, CMTR	Production Lot Number
LAR, CMTR	LOT Quantity, Quantity Accepted / Rejected
LAR, CMTR	Acceptance Criteria and tolerance
LAR	Variable or attribute data test results data and specification limits

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Table 3- Lot Acceptance Test or Lot Acceptance Report Document Requirements	
LAR	Identify if Normal, Tighten Reduced Sample Size is used
LAR	Revision Change Table- defining change, date, rev of POI
CMTR	Specification and revision (QAP, MIL- STD, ASTM...)
CMTR	Type Grade, size, heat lot number, batch number, specimen type
CMTR	Certified Test Results specifying Approval or Rejection
CMTR	Representative Authorized Signature attesting accuracy of report

4.0 QUALITY CLAUSE DELIVERABLES

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. Unless otherwise agreed upon, deliverables required within this QCD contain CUI and must be marked and transmitted in accordance with DoDI 5200.48, "Controlled Unclassified Information (CUI)."

NO.	TITLE	CUI	GD-OTS APPROVAL REQUIRED	SUBMITTAL TIMING/FREQUENCY
S3-1	POI General	Yes	Yes	Unless otherwise directed in the PO or Special Instructions document provided by GD-OTS; QCD is due 90 calendar days prior to start of FAAT or production.
S3-2	POI	Yes	Yes	Unless otherwise directed in the PO or Special Instructions document provided by GD-OTS; QCD is due 90 calendar days prior to start of FAAT or production.

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NO.	TITLE	CUI	GD-OTS APPROVAL REQUIRED	SUBMITTAL TIMING/FREQUENCY
S3-3	LAR	Yes	Yes	Unless otherwise directed in the PO or Special Instructions document provided by GD-OTS; QCD is due 15 calendar days after completion of lot acceptance.
S3-4	CMTR	Yes	Yes	Unless otherwise directed in the PO or Special Instructions document provided by GD-OTS; QCD is due 30 calendar days prior to FAAT or production.

5.0 REVISION HISTORY

REV	DATE	CHANGE
0	06/12/2023	ECN23315-Initial Release
1	01/11/2024	CUI Updates
2	04/10/2025	ECN25460 - Submittal timing/frequency update for S3-4, CMTR