

# **Document Number**

**DOC1004BC**

**For “New” GLG Spares BOA  
SPRPA1-14-G-003X - CSI**

**CHANGE RECORD**

<b>Rev</b>	<b>DATE</b>	<b>DESCRIPTION</b>	<b>BY</b>
A	12 <sup>th</sup> March 2015	Issued for Company Use	LP

This procedure has been approved by the following:

<b>Name</b>	<b>Signature</b>	<b>Date</b>
Owner: Lee Price Senior Supply Quality Engineer		
Quality Approval: Paul James Head of Quality		

**Use this template for Goodrich Landing Part Profiling:**

**BOA/TDP order (CO1 Suffixed Part Numbers): (for 'CSI' Orders)**

**Note:**

\*\* " CRITICAL" characteristics, selected by the GOVERNMENT CUSTOMER, must be inserted in the section below entitled "Additional Critical Characteristics: Identified per Customer Contract for the Part Number".

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**\*\* THIS PART IS CLASSIFIED AS CSI (THIS IS A CRITICAL SAFETY ITEM) \*\***

**\*\* GOVERNMENT SOURCE INSPECTION PERFORMED AT THE SUPPLIER FACILITY IS REQUIRED FOR THIS ORDER (REFERENCE "SUPPLIER DCMA WITNESS REQUIREMENTS" BELOW \*\***

The supplier shall provide with each shipment Inspection Records which include the Supplier Name, Ontic Purchase Order Number, Part Number, Part Revision Lot Number, Serial Number (if Applicable), Lot Size, and Inspection sample size for the part or assembly. The inspection records shall list all Critical Characteristics / Dimensions Included on each drawing or as identified on this Purchase Order. Critical Characteristics shall be inspected 100% and documented for the full unit population. Acceptance on Inspection Records shall be denoted by Inspection stamps.

**GENERAL ONTIC QUALITY REQUIREMENTS:**

1. Goodrich document 300 (Supplier and Product Quality Requirements) and Document 200 (Goodrich Approved Precessors) are imposed without exception (the referenced Goodrich documents are available for review via Live Link, or may be obtained from Ontic).
2. Critical parts Requirement: Part(s) Identified as having a Heat Treat characteristic of 180 KSI or above, shall require a manufacturing process plan that has been approved by Ontic Engineering prior to production use. All changes / deviations from the approved plan (Frozen Plan) shall be approved by Ontic Engineering.
3. The Suppliers shall submit all Manufacturing Plans and or Manufacturing Travellers, Approvals of Plans and Travellers from Goodrich, and Method Sheets for all processes for Ontic Approval prior to manufacturing the parts(s).
4. Prior to marking the parts the Supplier shall contract Ontic to confirm the correct markings to be applied to the parts / product. Marking shall be in accordance with MIL-STD-130 (latest Revision Applies). Method and location shall be in accordance with the drawing requirements or unless otherwise stated by Ontic.
5. All product discrepancies shall be reported directly to Ontic through the use of the Goodrich "Quality Notification Report" form GLG-SQA-F-2963. For Ontic review and disposition approval.

6. All specifications and documents shall include the reference to superseded specifications and or documents.
7. The Supplier shall provide completed Inspection Method Sheets / Final Inspection Sheets showing the actual dimensions taken for ALL Characteristics.
8. The Supplier shall maintain all raw material documentation for a minimum of ten (10) years.

**SUPPLIER DCMA WITNESS REQUIREMENTS: "GSI" – FIRST PIECE / PRODUCTION LOT INSPECTION / TESTING":**

\*\*\* NOTE: PRIOR TO PRESENTING PRODUCT TO DCMA, THE SUPPLIER SHALL SEND ALL INSPECTION DATA AND PRODUCT DOCUMENTATION TO ONTIC FOR REVIEW AND PREAPPROVAL \*\*\*

\*\*\* AFTER RECEIVING APPROVAL OF ALL PRODUCT DOCUMENTATION BY ONTIC – THEN THE SUPPLIER DCMA IS TO PERFORM **"GSI – FIRST PIECE / PRODUCTION LOT INSPECTION / TESTING":**

1. First Piece / Production Lot Inspection / Testing witness by the Government – shall be performed at the Supplier / Facility for each line item in every order against the subject Purchase Order.
2. When presenting First Piece / Production Lot Inspection / Testing, the supplier shall make product available to accomplish the inspections required. All detail parts including subcomponents and forging shall be available in all conditions required to validate all dimensional features. This includes parts having dimensions prior to and after processing such as plating and forgings prior to machining.
3. Functional Testing, where applicable, shall be in accordance with the applicable Acceptance Test Procedures (ATP) per the Goodrich Supplied data package.
4. When part weight is a drawing requirement, in addition to part dimensional characteristics. All parts shall be verified for weight in accordance with the drawing and results recorded for all parts.
5. The Supplier shall notify Ontic and their local DCMA Government Quality Assurance Representative 45 days prior to the planned date for the First Piece Production Lot Inspection / Testing so that the Government may be present to witness all required inspections and / or tests.

Upon completion of the Government witness of the inspections / tests, the supplier shall provide to Ontic objective evidence including DCMA's stamp specifically stating / validating the "GSI – First Piece Inspections / Tests" witnessed by the Government. This objective evidence shall be provided to Ontic at time of delivery of the order and / or when requested by Ontic.

**FIRST PIECE AND EVERY SIXTH (6<sup>TH</sup>) PIECE THEREAFTER OF EACH LOT RUN ON A MACHINE MANDATORY INSPECTION.**

1. The first piece of each lot run on a machine for specific part will be subjected to 100% dimensional inspection and documented. Every sixth (6<sup>th</sup>) piece thereafter (i.e.: 6, 12, 18, 24, etc.) shall be subjected to 100% dimensional inspection and documented. Ontic form (can be provided by Ontic) or equivalent form may be used to document the results of inspections.
2. Each of the in-process inspection pieces shall be marked or otherwise identified and linked to the associated inspection data described in (1.) above.
3. The documentation shall list all characteristics of the item and indicate acceptance / non-acceptance. The supplier shall provide completed inspection Method Documents as evidence of this in-process inspection.

**INSPECTION REQUIREMENTS: ONTIC / CONTRACTOR CRITICAL CHARACTERISTICS**

100% inspection of Critical Characteristics shall apply. Critical Characteristics on all parts in the lot shall be inspected and the actual measurement results recorded. This measurement data is to be provided with the shipment of parts to Ontic.

**DEFINITION OF CRITICAL CHARACTERISTICS:**

- A. Diametrical and linear dimensions having a total tolerance of 0.001" or less.
- B. Surface finishes having a 16 value or less.
- C. Any geometric feature control requirement with a total tolerance range of 0.002" or less.
- D. Angular Tolerances with a total range less than one (1) degree.

**ADDITIONAL CRITICAL CHARACTERISTICS: IDENTIFIED PER CUSTOMER CONTRACT FOR THIS PART NUMBER:**

(In this space, insert additional Customer selected CRITICAL Characteristics – or – state "NONE SPECIFIED" if none were specified by the Customer)

**THE FOLLOWING DOCUMENTATION SHALL BE PROVIDED WITH THE DELIVERED PARTS:**

1. Critical Process Source Verification (Process Certificate's: Heat Treat, NDT, Plating, etc.)
2. Forging source Verification (Forging Certificate's, last produced Forging Inspection Record for the lot provided).
3. Completed Process / Operations sheets (Shop Travellers, Routers, etc.).
4. Completed Inspection Sheets – (FAI from the job lot of this order, 1<sup>st</sup> and every 6<sup>th</sup> piece for all manufacturing lots, and Each Piece "Critical" data).

5. First Piece / First Production Lot Test Results (Evidence of DCMA Acceptance through DCMA stamp).
6. Material Certifications (Raw Material Certificate's: Melt Source and Distributor).

**TO BE ADDED TO GENERAL REQUIREMENTS FOR APPLICABLE PART NUMBERS:**

**MIL-W-81381 WIRE IS PROHIBITED**

The use of MIL-W-81381 wire is prohibited. MIL-W-22759 wire is to be used in Lieu of MIL-W-81381 when MIL-W-81381 is reference on any drawings or specifications for this procurement.

**MIL-STD-454 IS REFERENCED IN THE DRAWINGS OR IN THE SPECIFICATIONS**

If MIL-STD-454 is referenced in the drawings or in the specifications, the supplier is expected to show compliance with MIL-STD-200A. Personnel performing tasks in accordance with MIL-STD-200A shall be trained and certified as required by MIL-STD-2001A paragraph 5.1.4.