QUALITY REQUIREMENTS INSTRUCTIONS FOR FASTENERS

TO DETERMINE THOSE REQUIREMENTS WHICH ARE INVOKED ON THIS PURCHASE ORDER, REFER TO THE APPLICABLE PARAGRAPHS NOTED ON THE PURCHASE ORDER.

1. GOVERNMENT SOURCE INSPECTION ACCESS

The government reserves the right to inspect at source, supplies and services not manufactured or performed at the Buyer's facility. In the event this right is to be exercised, you will be notified and paragraph 2 (below) will become applicable.

2. GOVERNMENT SOURCE INSPECTION

Government inspection is required prior to shipment from your plant. Upon receipt of this order, promptly notify the Government Representative who normally services your plant so that appropriate planning for Government inspection can be accomplished. You are required to provide an acceptable inspection area for the Government Representative.

3. BUYER'S SOURCE INSPECTION ACCESS

The Buyer reserves the right to inspect at source, supplies and services not manufactured or performed at the Buyer's facility. In addition, the Seller is required to inform the Buyer of the tentative dates of the conductance of all tests applicable to these items at least (10) days in advance of such tests. The Seller is further required to inform the Buyer of any changes in the above schedule. Should the Buyer not be present when the test/inspection/operation is scheduled, testing shall proceed unless otherwise notified by the Buyer. Witness of manufacturing processes and/or tests by the Buyer Quality Assurance shall not be construed to indicate acceptance of the product. Evidence of Source inspection shall normally accompany each shipment.

4. MIL-I-45208A INSPECTION SYSTEM

MIL-I-45208A is applicable. The Seller shall prepare and submit an inspection flow chart within thirty (30) days after contract. The flow chart may be prepared in any Seller format, but must contain the following as a minimum; a block‑type flow chart or description of the sequence of quality verification functions. The documents shall specify numerical sequence of production/ manufacturing operations, inspections, test, etc., that will be performed during fabrication and test at the component and associated subsystems. Information shall include a brief description of each operation, inspection or test, number of the applicable procedure, drawing or work instruction and location.

5. SELLER'S QUALITY CONTROL

This level of inspection is that normally met by the seller, as outlined in the sellers written quality control procedures, which are based on industry wide standards for the product supplied. The seller should have as a minimum, procedures that control and describe the manufacture of the product supplied to assure product of high quality in acceptance with the purchase order.

6. RECEIPT INSPECTION (For Buyer Information Only)

Warehouse Receiving Inspection shall be performed on all items received at the buyers facility as follows:

Assure items are properly packaged undamaged, identified, and are the type and quantity required in the purchase order.

Verify that suppliers objective quality evidence has been received as required by purchase order.

Quality Receipt Inspections should be performed upon receipt at the Buyer's facility.

7. MARKING LEVEL 1

Seller shall comply with Level 1 requirements in Form SSF Q1648.

8. PHYSICAL AND CHEMICAL TESTS

8.1 Physical and chemical tests shall be in accordance with the applicable procurement specification.

9. DATA REQUIREMENTS

9.1 Objective Quality evidence shall be maintained by the manufacturer for a period of not less than 7 years from date of shipment unless forwarded with the material.

9.2 Physical and Chemical test reports shall be forwarded to Ingalls Shipbuilding with material.

9.3 Physical and Chemical test reports must be available at suppliers facility for review by Ingalls Shipbuilding representative. These reports shall be maintained by the supplier for a period of 3 years.

9.4 Nondestructive test reports shall be forwarded to Ingalls Shipbuilding with each shipment.

9.5 Certificate of conformance for Chemical and Physical tests.

9.6 A lot of fasteners consists of one heat of material, of one type and style, of the same nominal size, and fabricated and heat treated in the same batch or by a continuous process under the same; conditions as to time and temperature.

9.7 A lot of fasteners consists of one grade of material, of one type and style, of the same nominal size, and produced under essentially the same conditions.

9.8 A lot of fasteners consists of one grade of material produced under essentially the same conditions in a continuous process

10. FASTENER IDENTIFICATION

10.1 Fasteners procured to MIL-S-1222, ASTM, or other specification shall be marked in accordance with that specification. Fasteners procured to ASTM will be to the latest revision. Revisions to all other military and federal specifications shall be the issue in effect on 1 January 1984 for DDG, 1 January 1983 for LHD and 1 September 1995 for LPD.

10.2 Self‑locking bolts and screws shall be marked with a minimum of six raised or depressed dots on the head of the fastener.

11. Substitutions

Suppliers shall not furnish substitutions unless specifically authorized by the buyer.

12. ASTM fasteners shall comply with the requirements of Form SSF Q5838.