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# Add to Cart

ASA-100 Quality System
MIL-I-45208 Inspection System

(mo/yr) .mo/yr)

		Revisions				Rev:		
Letter	E.O. Number	- Descriptio	n				Date	2
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Used On	Contract#:			Vou	n Compo	ny Nomo		
Prepared By: Your Dept:	Your Co			1 00	r Compa	ny Name		
Your Dept:				INSP	ECTION	SYSTEM		
Your Dept:			INSPECTION SYSTEM QA-101					
Your Dept:		Size	<b>A</b>	CAGE:		Your Form# (n	no/yr)	1 of 27

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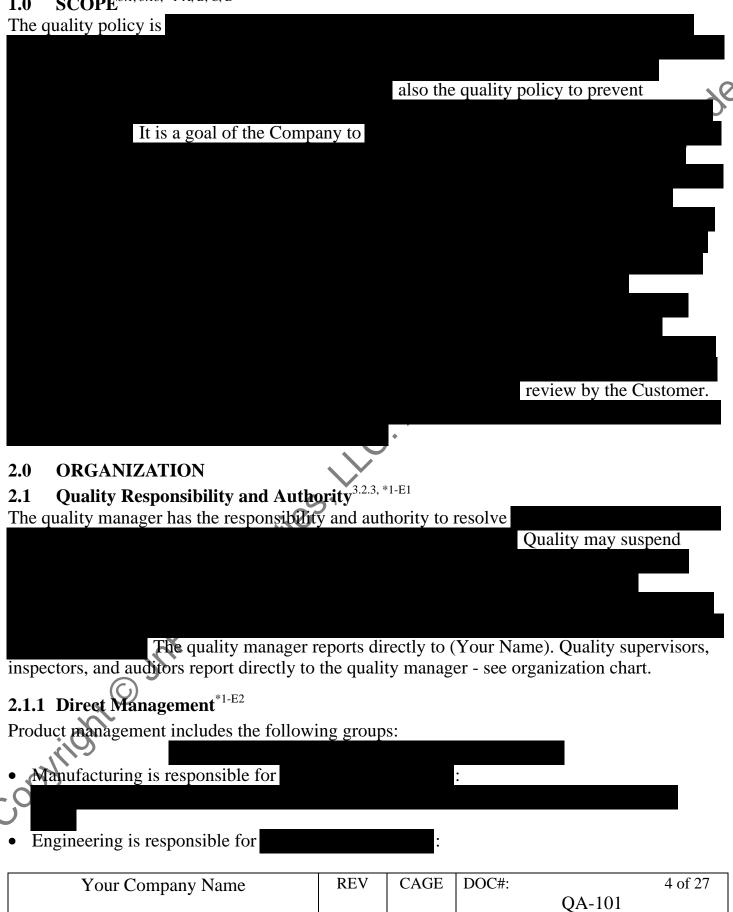
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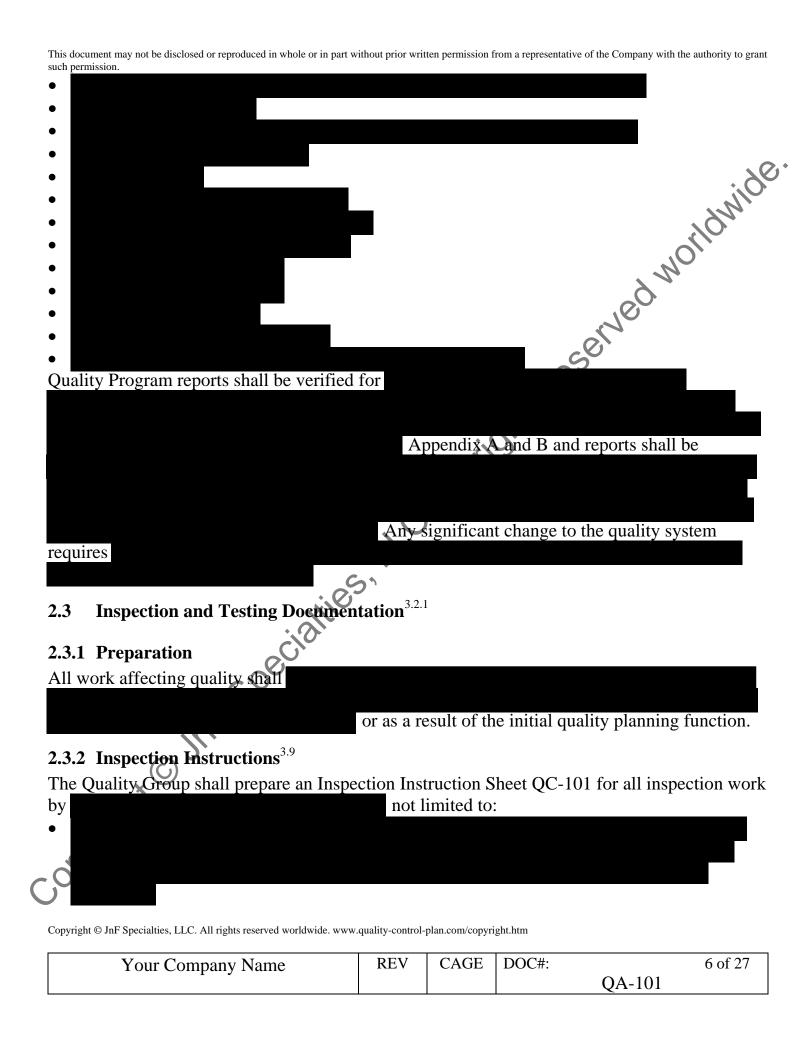
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to paragraph numbers from MIL-I-45208 and numbers that follow an asterisk correspond to
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## 1.0 SCOPE<sup>3.1, 3.13, \*1-A, B, C, D</sup>



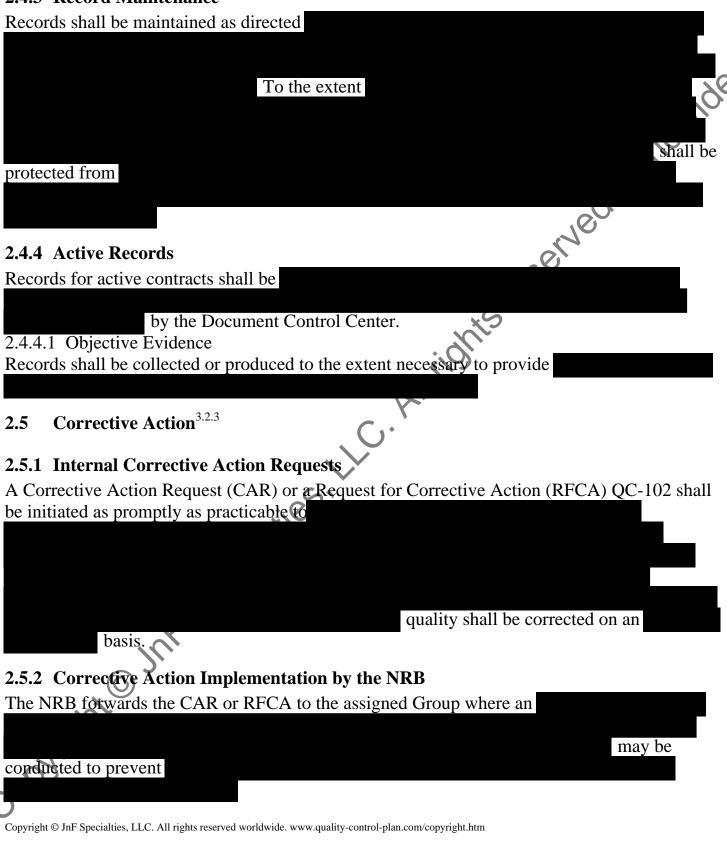
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<ul> <li>Purchasing is responsible for</li> </ul>		:			
		_			
<ul> <li>Quality is responsible for</li> </ul>		•			:.60.
All direct management offerts shall b	a aaaamnligh	ad using		ad parganna	1 or tooms
All direct management efforts shall be selected on the basis of meeting Qual	-	_	objectives	nal personne	or teams
_	• •		3,40		
<b>2.1.2 Problem Resolution</b> Quality problems resulting from			XS		
Quanty problems resulting from					
			.1	•1 •1•.	
freedom to		has the	authority, 1	responsibility a	and
have a	an influence.				<del></del>
2.2 Initial Quality Planning <sup>3,11,1,3</sup>	3.11.25				
2.2.1 Basic Contract Review					
The Quality Group is responsible for					
The Quality Group is respond to to					
	1.1.		41 D :		
The form used 118.	to record this	s review i	s the Basic	Contract Revi	ew QC-
	*1-E14, 2-A, A1				
<b>2.2.2 Review of the Quality Progra</b> The Quality Group collects data for	am 121,21,11				which
may include, but is not limited to:					which
•					
-•0					
Your Company Name	REV	CAGE	DOC#:	O A 101	5 of 27
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Prepare (IIS) Inspection Instruction Sheet QC-101. The form may include, but is not limited to: After approval the IIS is released for updated. ialties, **Records**<sup>3.2.2, \*1-E4</sup> 2.4 2.4.1 General Data to be recorded includes the nature of the inspection (type), number of samples inspected, number and type 2.4.2 Record Verification\*13-A The Quality Group examines records for initials or stamp and date (mo/yr).

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## **2.4.3 Record Maintenance**\*12-A, B, C, D, E



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## **2.5.2.1** Corrective Action Monitoring\*8-H

An initial review of the adequacy of improvements and corrections and the monitoring of the effectiveness of actions taken shall

#### 2.5.3 Supplier Corrective Action

A Supplier corrective action shall be initiated by

An initial review of the adequacy of improvements and

corrections and

by the Quality Group.

#### 2.5.4 Customer Request for Corrective Action

A Customer request for corrective action may

In all cases the Customer request

#### 2.5.4.1 Corrective Action Implementation

The Corrective Action Board (CAB), working with other Company organizations as needed, analyzes

### 2.5.4.2 Corrective Action Progress

Progress of the corrective action shall

completes the corrective action form

and prepares a

response for

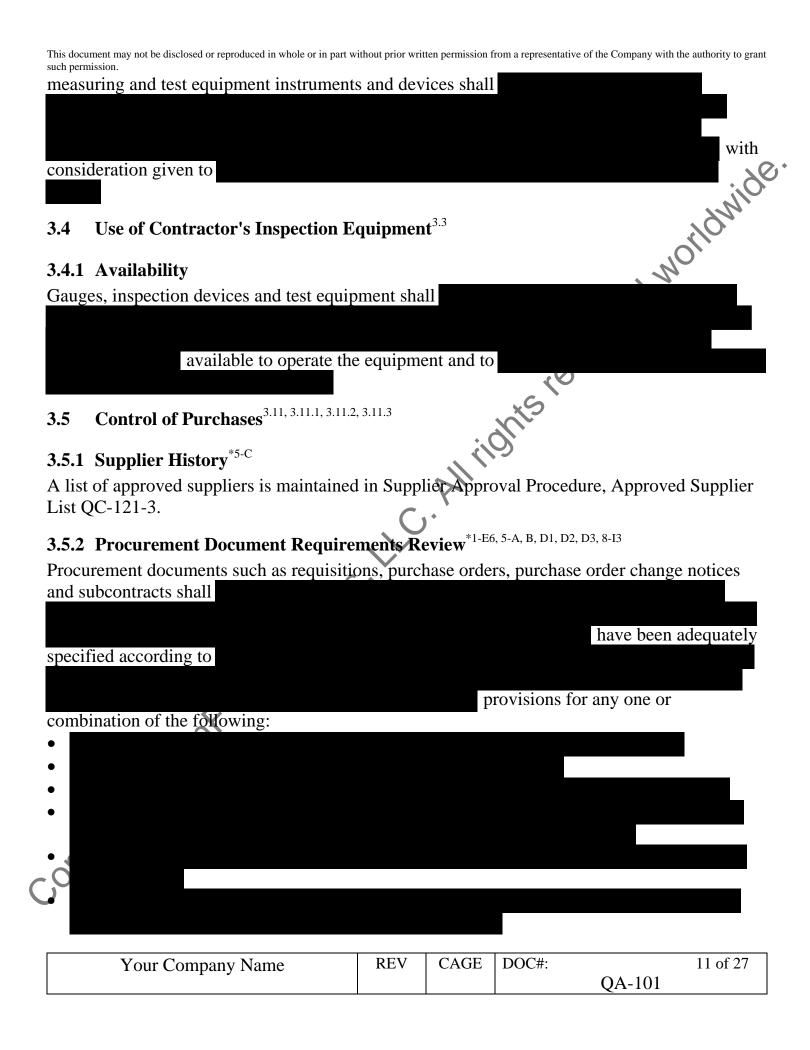
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#### 3.0 FACILITIES AND STANDARDS

## **3.1 Drawings, Documentation and Changes**<sup>3.2.4, \*1-E3, 13-A</sup>

The Quality Group shall be removed from **Change Control**<sup>3.2.4, \*1-E3, E14</sup> Changes to contractual requirements shall upgrade inspection and test instructions, to the quality system of the change prior to implementation. Measuring and Test Equipment  $^{3.3,\,*\text{1-E9},\,\text{E12},\,\text{7-A},\,\text{B}}$ 3.3 All measuring and test equipment instruments and devices used to determine a deliverable item's conformance to specified requirements shall New measuring and test equipment instruments and devices shall list and date each instance of Measuring and test equipment instruments and devices shall not Employee-owned Your Company Name 10 of 27 **REV** DOC#: **CAGE QA-101** 



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thana ana digana di	was in the programme	ant do au	mant it is			
mere are discrepan	icies in the procurem	ent docui	ment, it is			
				by a Qua	ality Group	
presentative and re	turned to					
6 Materials and	l Material Control <sup>3.</sup>	9, 3.12				
$\mathcal{O}$						
6.1 Receiving Ins	pection*1-E6, 7, 8, 9, 11, 6	-A, A1, A2, A	3, A4, A5, B,	C, E, 8-A, D, J, J2	2, K, 9-A	
ll materials shall be						
Your Com	pany Name	REV	CAGE	DOC#:		12 of 27
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	adjus	sted upon	the basis of	f the	
Three levels of Sampling exist for non-ce	ertified Su	ppliers:			
A statistically sampled lot of material aware	aiting nor	n-conform			0
When an item drawing is revised and/or vidiffers from parts in stores, the early revised				te document revision leve	_
Parts that have been sent out for special p	rocessing	g shall			
Measuring and test equipment devices an	d measure	ement sta	ndards that	have bee	
All new measuring instruments and device	es shall b	e e	M.		
	,	examined	l upon rece	ipt only for	
All incoming supplies shall be					
An incoming supplies shan be	7				
		Prior to in			
Receiving inspection uses the following i			on for all it	ems:	QC-114 (mo/yr)
Your Logo  Special Instructions:  ANSI Z 1.4; Level I reduced, A  Die-controlled = 5/lot	QL 1.0	Specification Specification Approv	on:		QC-114 (III//y1)
Commercial or items >50Lbs =	1/Lot				
				_	
,007					
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All limited sh	elf life items received with					doogwat
necify an evr	piration date.					does not
	be inspected with appropria	ate				
				_		
Vhen periodi	verification of certification	n validi	ty is require	ed		
				, the res	sults shall be	
ocented our	olies shall be					
icrepied sup	plies shall be					naintained
ntil					1	
			identified	by		
<u>You</u>	r Company Name	REV	CAGE	DOC#:		14 of 27
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such permission.					
•					
After approval, the					
	docum	ents requ			divible
		ιο	be updated.	•	Who
3.6.3 Raw Material Inspection					40.
The Purchasing Group specifies					
				70	
Receiving inspection personnel shal					
Raw material waiting for test shall				9	
The material waiting for test sharp			×S		
A Calculated Risk Release form QC-	104				
				cha	ll be
maintained by				Sila	II oc
When tests or analyses are complete t	ha tast rapor	t shall			
when tests of analyses are complete to	Con	Silaii			
Upon completion of inspection the in					
	with a	until c	uch time as	processing	nacassarily
		until 8	ucii tiiile as	processing i	necessarry
Unacceptable materials shall be					
3.6.4 Control of Special Materials*	1-E12				
Items that are hazardous (such as					
	,			hall be inco	natad
according to			S	shall be inspe	ected
	<b>41</b>			1	1.11.14 - 1.1
	the			uniess pro	hibited by
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## **Production Processing and Fabrication**<sup>3.2.1</sup>

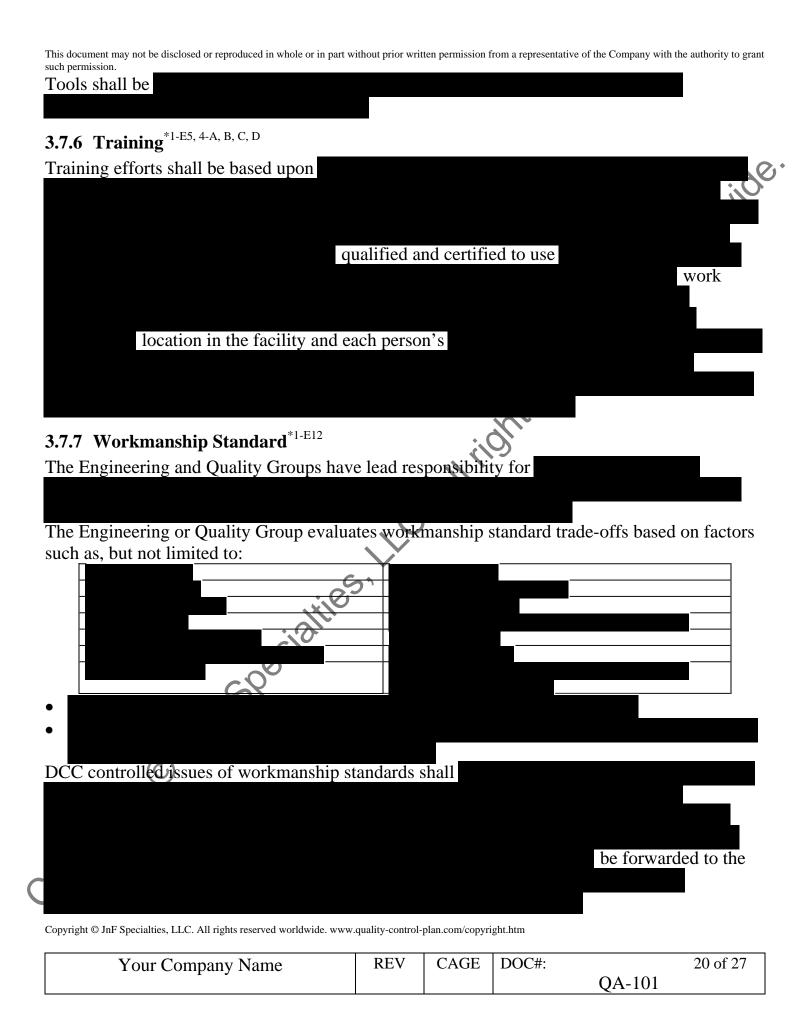
3.7.1 In-process Inspection	10
The Quality Group is responsible for	<u> </u>
Parts, components and subasse	amblias
Parts, components and subasse	as defined by
	as defined by
	or when there is an
Whenever a material condition exists that diffe	ers from
There were a material condition exists that are	should be in the form of a
	suitable for the circumstance.
*1-F12	
3.7.1.1 Special Processes*1-E12	
Ultra precise and super complex work function	ns shal
controlled to maintain	
	marridad by
	provided by
	the work. Records of
certification/recertification of	
The Manufacturing Group is responsible for	
	and to
The Quality Group is responsible for	
The Quality Group is responsible for	
	when warranted, accomplishing the
corrective action on an	men warantee, accomplishing the
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such permission.
3.7.2 Inspection Methods <sup>3.4, *9-A</sup>
Inspection methods may include, but shall be not limited to:
Inspections shall be made
using includes verification of compliance to:
includes verification of compliance to:
When physical inspection of processed supplies is
performed when control of product
quality is
3.7.2.1 Calculated Risk Release
In the event materials, components or assemblies are needed prior to receipt of Certified Test
Data, Certificate of Compliance or Analysis, approved Request for Deviation or Waiver or other
limited risk condition, cognizant NRB members of the Products and Quality Group may
unless waived by
diffess warved by
3.7.3 Identification <sup>3.5</sup>
Parts or assemblies found to be in compliance with inspection requirements shall
be forwarded to a secure holding area or
3.7.4 Failure Reporting <sup>3.7</sup>
A Nonconformance Report QC-103 shall be
2.7.5 Tasking Ingrestion <sup>3,3</sup>
3.7.5 Tooling Inspection <sup>3.3</sup>
All production tools such as jigs, fixtures and templates used for producing deliverable supplies
shall be and work orders.
allu work orders.

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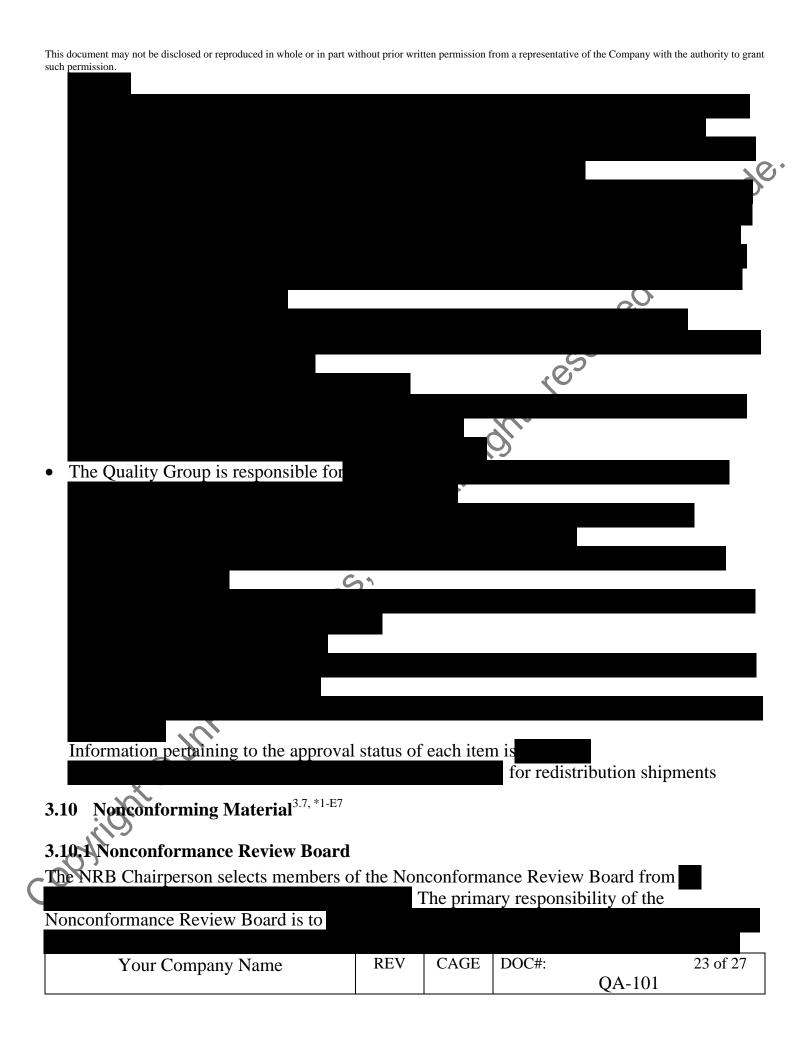


# **3.8** Completed Item Inspection and Testing<sup>3.2.1, 3.5</sup>

### 3.8.1 Final Physical and Visual Inspection

All finished goods shall be					
					.89
					alle
examination of the accompany	ying docu	mentation	n for		
Completed supplies shall be	guinad W	han anaai	fied newto	or organistics	found to be
acceptable shall be	quirea. w	nen speci	nea, parts	or assemblies	Tound to be
					for
appropriate action.			9)		101
When modifications, repairs or replacement	ents are re		C	1	
		shall t	oe perform	nea	
3.8.2 Final Acceptance Testing					
Supplies shall be approved for					
1'					
according to make certain that ap	propriate	warnings	s and safet	v notices are	
		8			
					on a
Nonconformance Report QC-103. The N	onconfori	nance Re	view proc	ess shall repor	
XX 71 1 1 2 7 1		. 1 (	2,		
When modifications, repairs or replacement	ents are re	equired at	ter		
<b>3.8.3 Final Acceptance Processing</b> After successful completion of final inspection.	action and	l tost con	anlatad su	nnliae chall ha	avaminad
for the following:	ection and	i test, con	iipieteu suj	ppnes snan be	Cxammeu
•					
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Documentation attes	ting to the acceptance	e of the s	upply sha	11		
					N	
	orage and Delivery				yed w	
3.9.1 Protecting Pro	oduct Quality*1-E10, E.	12, 8-A, D, D1	, E, F, G, H, 1	0-A, B1, B2, C, D	, E, 11-A, B, B1 thro	ough B7
	pecifi <u>es, where requi</u>					
		th	e overall	effectivenes	ss of	
					ing, packing	and
marking instructions	shall be					
						when
necessary. Labeling	to indicate					when
			When	ever possibl	e, items shall	be
	<u> </u>					
Shipping and Receiv	ring is responsible for	r the follo	wing rou	tines:		
•			$\mathcal{E}$			
O						
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		certain su	pplies and repairs in Standard
			may be
established. 3.10.2 Nonconformance Report Processir	ng		
•			
•			
•			
3.10.3 Misrepresented Items *8-J1			40
When shipped supplies are discovered to	be misre	oresented	, the Quality Group
			then notifies
3.10.3.1 Scrapping Items to Prevent Mi	crenrece	ntation*8	-1, 11, 12
<ul> <li>The NRB selects the appropriate scrap</li> </ul>	-		om
		*	
	1 11		
The Compa	iny snaii	report sus	spect items to
3.11 Indication of Inspection Status <sup>3.5</sup>	,*1-E13		
3.11.1 Inspection Stamps *6-D The Quality Group controls inspection sta	amne Th	a nrimary	accentance stamp is
The Quanty Group Controls inspection sta	amps. Th	c primary	acceptance stamp is
the stamp is removed from service. Stamp	as that are		when
	or at least		
3.11.2 Identification Media			
The inspection status of supplies is			
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#### 3.13.1 Bailed Property

Bailed property shall be

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#### Referenced Documents:

ATA 300 – Shipping Container

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OC-101 – Inspection Instruction Form

QC-102 – Request for Corrective Action

OC-103 – Nonconformance Report Form

QC-104 - Calculated Risk Release Form

QC-105 – Good Material Tag

QC-106 – Withhold Tag

QC-107 – Routing Ticket

QC-108 – R&I Inspection Record

QC-109 - Engineering Order

QC-110 – Request for Waiver / Deviation

QC-110-1 – Mil-Std-973 Request for Waiver / Deviation

QC-111 – Mil-Std-481 Engineering Change Proposal

QC-112 – Inspection Record

QC-113 – Bad Material Tag

QC-114 – R&I Inspection Instructions

QC-115 – Property Control

QC-116 – Calibration System and Forms

QC-117 - Supplier Quality Requirements

QC-118 - Basic Contract Review

QC-119 - Traveler

QC-120 – Purchase Order

QC-120 – Furchase Order Review Instructions

QC-121-3 – Supplier Approval Procedure / Approved Supplier List

QC-122 – Dimensional Analysis Record

QC-123 – Data List

QC-124-2 - ASA-100 Quality System Survey / MIL-I-45208 Inspection System Survey

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