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

(mo/yr)

Revisions						Rev:	
Letter	E.O. Number - Description					Date	
Used On	Contract#:		Your Company Name				
Prepared By:	Your Co						
Your Dept:							
Your Dept:			INSPECTION SYSTEM				
Your Dept:			QA-101				
Your Dept:			Size:	A	CAGE:		Your Form# (mo/yr) 1 of 27

Your Logo

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This inspection system is subject to Customer evaluation and verification based upon ASA-100 Quality System Standard for Distributors MIL-I-45208A.^{3.13} Superscript numbers correspond to paragraph numbers from MIL-I-45208 and numbers that follow an asterisk correspond to paragraphs contained in ASA-100.

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3.1, 3.13, *1-A, B, C, D

de.

100

1

2.1 Quality Responsibility and Authority^{3.2.3, *1-E1}

3.2.3, *1-E1

The quality manager reports directly to (Your Name). Quality supervisors, inspectors, and auditors report directly to the quality manager - see organization chart.

4*1-E2

Product management includes the following groups:

-
-

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- Purchasing is responsible for [redacted]:
- Quality is responsible for [redacted]:

All direct management efforts shall be accomplished using [redacted] personnel or teams selected on the basis of meeting Quality, Cost and Schedule objectives.

2.1.2 Problem Resolution

Quality problems resulting from [redacted]
[redacted]
[redacted] has the authority, responsibility and freedom to [redacted]
[redacted] have an influence.

2.2 Initial Quality Planning^{3.11.1, 3.11.2}

2.2.1 Basic Contract Review

The Quality Group is responsible for [redacted]
[redacted]
[redacted] The form used to record this review is the Basic Contract Review QC-118.

2.2.2 Review of the Quality Program^{*1-E14, 2-A, A1}

The Quality Group collects data for [redacted] which may include, but is not limited to:

- [redacted]
- [redacted]
- [redacted]
- [redacted]

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

Quality Program reports shall be verified for

[REDACTED]

Appendix A and B and reports shall be

[REDACTED]

Any significant change to the quality system

requires

[REDACTED]

2.3 Inspection and Testing Documentation^{3.2.1}

2.3.1 Preparation

All work affecting quality shall [REDACTED]

[REDACTED] or as a result of the initial quality planning function.

2.3.2 Inspection Instructions^{3.9}

The Quality Group shall prepare an Inspection Instruction Sheet QC-101 for all inspection work by [REDACTED] not limited to:

- [REDACTED]

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After approval the IIS is released for [REDACTED]
[REDACTED] updated.

2.4 Records^{3.2.2, *1-E4}

2.4.1 General

Data to be recorded includes [REDACTED]
[REDACTED]
[REDACTED] the nature of the inspection (type), number of samples inspected,
number and type [REDACTED]
[REDACTED]

2.4.2 Record Verification^{*13-A}

The Quality Group examines records for [REDACTED]
[REDACTED] initials or stamp and
date (mo/yr).

2.4.3 Record Maintenance^{*12-A, B, C, D, E}

Records shall be maintained as directed [redacted]

To the extent [redacted]

[redacted] shall be protected from [redacted]

2.4.4 Active Records

Records for active contracts shall be [redacted]

[redacted] by the Document Control Center.

2.4.4.1 Objective Evidence

Records shall be collected or produced to the extent necessary to provide [redacted]

2.5 Corrective Action^{3.2.3}

2.5.1 Internal Corrective Action Requests

A Corrective Action Request (CAR) or a Request for Corrective Action (RFCA) QC-102 shall be initiated as promptly as practicable to [redacted]

[redacted] quality shall be corrected on an [redacted] basis.

2.5.2 Corrective Action Implementation by the NRB

The NRB forwards the CAR or RFCA to the assigned Group where an [redacted]

[redacted] may be conducted to prevent [redacted]

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

A Supplier corrective action shall be initiated by

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 [REDACTED]

2.5.4.2 Corrective Action Progress

Progress of the corrective action shall

completes the corrective action form

_____ and prepares a response for _____

measuring and test equipment instruments and devices shall [REDACTED]
[REDACTED] with
consideration given to [REDACTED]
[REDACTED]

3.4 Use of Contractor's Inspection Equipment^{3.3}

3.4.1 Availability

Gauges, inspection devices and test equipment shall [REDACTED]
[REDACTED]
[REDACTED] available to operate the equipment and to [REDACTED]
[REDACTED]

3.5 Control of Purchases^{3.11, 3.11.1, 3.11.2, 3.11.3}

3.5.1 Supplier History^{*5-C}

A list of approved suppliers is maintained in Supplier Approval Procedure, Approved Supplier List QC-121-3.

3.5.2 Procurement Document Requirements Review^{*1-E6, 5-A, B, D1, D2, D3, 8-I3}

Procurement documents such as requisitions, purchase orders, purchase order change notices and subcontracts shall [REDACTED]
[REDACTED] have been adequately
specified according to [REDACTED]
[REDACTED] provisions for any one or
combination of the following:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

- [Redacted]
- [Redacted]
- [Redacted]

Class of Part	Required on Receipt	Required for Shipment
[Redacted]	[Redacted]	[Redacted]
[Redacted]	[Redacted]	[Redacted]
[Redacted]	[Redacted]	[Redacted]
[Redacted]	[Redacted]	[Redacted]
[Redacted]	[Redacted]	[Redacted]

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

If there are discrepancies in the procurement document, it is [Redacted]
[Redacted] by a Quality Group representative and returned to [Redacted]

3.6 Materials and Material Control^{3.9, 3.12}

3.6.1 Receiving Inspection^{*1-E6, 7, 8, 9, 11, 6-A, A1, A2, A3, A4, A5, B, C, E, 8-A, D, J, J2, K, 9-A}

All materials shall be [Redacted]
[Redacted]

adjusted upon the basis of the

Three levels of Sampling exist for non-certified Suppliers:

A statistically sampled lot of material awaiting non-conformance disposition is not released to production until appropriate documentation.

When an item drawing is revised and/or when an item is purchased to a revision level that differs from parts in stores, the early revision parts

Parts that have been sent out for special processing shall

Measuring and test equipment devices and measurement standards that have been

All new measuring instruments and devices shall be examined upon receipt only for

All incoming supplies shall be Prior to inspecting

Receiving inspection uses the following inspection instruction for all items:

Your Logo	Receiving Inspection Instructions		QC-114 (mo/yr)	
	Special Instructions: ANSI Z 1.4; Level I reduced, AQL 1.0 Die-controlled = 5/lot Commercial or items >50Lbs = 1/Lot	Specification:		
		Specification:		
		Approval:		
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[illegible]

Supplies shall be inspected with appropriate [REDACTED]

When periodic verification of certification validity is required [REDACTED]
[REDACTED], the results shall be [REDACTED]

identified by

the same day for [REDACTED] which is completed [REDACTED]

At the completion of each inspection and/or

Files shall be

Receiving inspection personnel observe the following document order of precedence in the event of conflict, ambiguity or contradiction:

3.6.2 Inspection Instructions^{*1-E6}

The Quality Group prepares the inspection instruction sheet by performing tasks that may include, but are not limited to:

- [REDACTED]

Category	Item	Value
Category 1	Item 1.1	10
	Item 1.2	20
	Item 1.3	30
	Item 1.4	40
	Item 1.5	50
	Item 1.6	60
	Item 1.7	70
	Item 1.8	80
	Item 1.9	90
	Item 1.10	100
Category 2	Item 2.1	10
	Item 2.2	20
	Item 2.3	30
	Item 2.4	40
	Item 2.5	50
	Item 2.6	60
	Item 2.7	70
	Item 2.8	80
	Item 2.9	90
	Item 2.10	100

- [REDACTED]

After approval, the [REDACTED] documents requires [REDACTED] to be updated.

3.6.3 Raw Material Inspection

The Purchasing Group specifies [REDACTED]

Receiving inspection personnel shall [REDACTED]

Raw material waiting for test shall [REDACTED]

A Calculated Risk Release form QC-104 [REDACTED] shall be maintained by [REDACTED]

When tests or analyses are complete the test report shall [REDACTED]

Upon completion of inspection the inspector shall [REDACTED] with a [REDACTED] until such time as processing necessarily

Unacceptable materials shall be [REDACTED]

3.6.4 Control of Special Materials^{*1-E12}

Items that are hazardous (such as [REDACTED], [REDACTED] shall be inspected according to [REDACTED]

[REDACTED] the [REDACTED] unless prohibited by [REDACTED]

The supplies shall be

the work performed by

The identification tags for rubber components or parts with rubber components bear a cure date. The date is indicated by [REDACTED] indicates the oldest rubber part was manufactured during [REDACTED] Material [REDACTED] [REDACTED] may be shipped and used up to [REDACTED]

3.6.5 Stores^{*3-A, B, C, D, 8-A, B, C, H1, 9-A}

Stock room personnel shall be responsible for

and expired shelf-life status.

All items shall be

controlled to ensure

that contain shelf-life limited items

3.6.6 Protection of Quality During Production, Storage and Use^{*1-E6}

Product protection factors shall be considered, such as, but not limited to:

- [illegible]

- [REDACTED]

3.7 Production Processing and Fabrication^{3.2.1}

3.7.1 In-process Inspection

The Quality Group is responsible for [REDACTED]
[REDACTED]
[REDACTED] Parts, components and subassemblies [REDACTED]
[REDACTED] as defined by [REDACTED]
[REDACTED] or when there is an [REDACTED]
[REDACTED]
Whenever a material condition exists that differs from [REDACTED]
[REDACTED] should be in the form of a [REDACTED]
[REDACTED] suitable for the circumstance.

3.7.1.1 Special Processes^{*1-E12}

Ultra precise and super complex work functions shall [REDACTED]
[REDACTED]
[REDACTED] controlled to maintain [REDACTED]
[REDACTED] provided by [REDACTED]
[REDACTED]
[REDACTED] the work. Records of
[REDACTED] certification/recertification of [REDACTED]
[REDACTED]

The Manufacturing Group is responsible for [REDACTED] and to
[REDACTED] the appropriate [REDACTED]

The Quality Group is responsible for [REDACTED]
[REDACTED]
[REDACTED] when warranted, accomplishing the
corrective action on an [REDACTED]

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3.7.2 Inspection Methods^{3.4, *9-A}

Inspection methods may include, but shall be not limited to:

Inspections shall be made

using 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

3.7.3 Identification^{3.5}

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^{3.7}

A Nonconformance Report QC-103 shall be

3.7.5 Tooling Inspection^{3.3}

All production tools such as jigs, fixtures and templates used for producing deliverable supplies shall be and work orders.

Training efforts shall be based upon

work

location in the facility and each person's

The Engineering and Quality Groups have lead responsibility for

The Engineering or Quality Group evaluates workmanship standard trade-offs based on factors such as, but not limited to:

	[REDACTED]	[REDACTED]
	[REDACTED]	[REDACTED]
	[REDACTED]	[REDACTED]
	[REDACTED]	[REDACTED]
	[REDACTED]	[REDACTED]

- [REDACTED]
- [REDACTED]

DCC controlled issues of workmanship standards shall

be forwarded to the

3.8 Completed Item Inspection and Testing^{3.2.1, 3.5}

3.8.1 Final Physical and Visual Inspection

All finished goods shall be [redacted]
[redacted]
[redacted] examination of the accompanying documentation for [redacted]
[redacted]
[redacted] Completed supplies shall be [redacted]
[redacted] if required. When specified, parts or assemblies found to be acceptable shall be [redacted]
[redacted]
[redacted] for appropriate action.
When modifications, repairs or replacements are required [redacted]
[redacted] shall be performed [redacted]

3.8.2 Final Acceptance Testing

Supplies shall be approved for [redacted]
[redacted]
[redacted] according to [redacted]
[redacted] make certain that appropriate warnings and safety notices are [redacted]
[redacted] on a Nonconformance Report QC-103. The Nonconformance Review process shall report [redacted]
[redacted]
When modifications, repairs or replacements are required after [redacted]
[redacted]

3.8.3 Final Acceptance Processing

After successful completion of final inspection and test, completed supplies shall be examined for the following:

- [redacted]

- The Quality Group is responsible for

Information pertaining to the approval status of each item is [redacted]
[redacted] for redistribution shipments

3.10 Nonconforming Material^{3.7, *1-E7}

3.10.1 Nonconformance Review Board

The NRB Chairperson selects members of the Nonconformance Review Board from [redacted]
[redacted] The primary responsibility of the
Nonconformance Review Board is to [redacted]

3.10.2 Nonconformance Report Processing

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

When shipped supplies are discovered to be misrepresented, the Quality Group [REDACTED]
[REDACTED] then notifies [REDACTED]

- The NRB selects the appropriate scrapping technique from [REDACTED]

[REDACTED]

The Company shall report suspect items to [REDACTED]

3.11.1 Inspection Stamps^{*6-D}

The Quality Group controls inspection stamps. The primary acceptance stamp is [REDACTED] when the stamp is removed from service. Stamps that are [REDACTED] for at least [REDACTED]

The inspection status of supplies is [REDACTED]

The inspector completes a Good Material Tag, following its format, upon completion of [REDACTED]
[REDACTED] a Withhold
Tag, following its format, until conditions [REDACTED]
[REDACTED] may be used to effectively [REDACTED]

3.12 Government Inspection at Subcontractor or Vendor Facilities^{3.8, 3.11, 3.11.1, 3.11.2}

When the Customer wishes to conduct Source Inspection at a Supplier's facility the following statement is [REDACTED]
[REDACTED]

When the Customer contract is accepted [REDACTED]
[REDACTED] shall not relieve the Company [REDACTED]
[REDACTED] for Customer
use during [REDACTED]
[REDACTED] at the Supplier's facility shall be [REDACTED]
[REDACTED] required to coordinate
corrective actions with the Customer when requested. The Supplier shall provide contract
[REDACTED] by direction of the [REDACTED]

3.13 Government Property^{3.6}

Government and Customer property shall be [REDACTED]
[REDACTED] including, but not limited to:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

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3.13.1 Bailed Property

Bailed property shall be [REDACTED]

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Referenced Documents:

ATA 300 – Shipping Container

ASTM D 3951 – Commercial Preservation, Packaging, Packing and Marking

QC-101 – Inspection Instruction Form

QC-102 – Request for Corrective Action

QC-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-121 – Purchase 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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