

REDACTED

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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: <input type="text"/>
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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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1.0 SCOPE^{3.1, 3.13, *1-A, B, C, D}

The quality policy is

[Redacted]

also the quality policy to prevent

It is a goal of the Company to

review by the Customer.

2.0 ORGANIZATION

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

The quality manager has the responsibility and authority to resolve

[Redacted]

Quality may suspend

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

2.1.1 Direct Management^{*1-E2}

Product management includes the following groups:

[Redacted]

- Manufacturing is responsible for [Redacted]: [Redacted]
- Engineering is responsible for [Redacted]: [Redacted]

[Redacted]

- Purchasing is responsible for [Redacted]:

[Redacted]

- Quality is responsible for [Redacted]:

[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] 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]

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

Records shall be maintained as directed [REDACTED]

To the extent

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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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 [REDACTED]

2.5.3 Supplier Corrective Action

A Supplier corrective action shall be initiated by [REDACTED]

[REDACTED]

An initial review of the adequacy of improvements and corrections and [REDACTED]

[REDACTED] by the Quality Group.

2.5.4 Customer Request for Corrective Action

A Customer request for corrective action may [REDACTED]

[REDACTED]

In all cases the Customer request [REDACTED]

2.5.4.1 Corrective Action Implementation

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

[REDACTED]

2.5.4.2 Corrective Action Progress

Progress of the corrective action shall [REDACTED]

[REDACTED]

completes the corrective action form [REDACTED]

and prepares a response for [REDACTED]

[REDACTED]

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3.0 FACILITIES AND STANDARDS

3.1 Drawings, Documentation and Changes^{3.2.4, *1-E3, 13-A}

The Quality Group shall [REDACTED]
[REDACTED] be removed from [REDACTED]

3.2 Change Control^{3.2.4, *1-E3, E14}

Changes to contractual requirements shall [REDACTED]
[REDACTED] upgrade inspection and test instructions,
[REDACTED] to the quality system [REDACTED]
[REDACTED] of the change prior to implementation.

3.3 Measuring and Test Equipment^{3.3, *1-E9, E12, 7-A, B}

All measuring and test equipment instruments and devices used to determine a deliverable item's conformance to specified requirements shall [REDACTED]
[REDACTED]
[REDACTED] New measuring
and test equipment instruments and devices shall [REDACTED]

[REDACTED] list and date each instance of [REDACTED]
[REDACTED] Measuring and test equipment instruments and
devices shall not [REDACTED]

[REDACTED] Employee-owned

measuring and test equipment instruments and devices shall

consideration given to

with

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

3.4.1 Availability

Gauges, inspection devices and test equipment shall

available to operate the equipment and to

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

specified according to

have been adequately

provisions for any one or combination of the following:

-
-
-
-
-
-

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:			

- [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]

Temperature sensitive supplies, such as

forwarded

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 indicates the oldest rubber part was manufactured during Material

may be shipped and used up to

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:

-
-
-
-
-
-
-

- [Redacted]

3.7 Production Processing and Fabrication^{3.2.1}

3.7.1 In-process Inspection

The Quality Group is responsible for [Redacted]

[Redacted] Parts, components and subassemblies [Redacted] as defined by [Redacted]

[Redacted] or when there is an [Redacted]

Whenever a material condition exists that differs from [Redacted] should be in the form of a [Redacted] suitable for the circumstance.

3.7.1.1 Special Processes^{*1-E12}

Ultra precise and super complex work functions shall [Redacted]

[Redacted] controlled to maintain [Redacted]

[Redacted] provided by [Redacted]

[Redacted] the work. Records of [Redacted] certification/recertification of [Redacted]

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

The Quality Group is responsible for [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:

[REDACTED]

Inspections shall be made using [REDACTED] includes verification of compliance to: [REDACTED]

When physical inspection of processed supplies is [REDACTED] performed when control of product quality is [REDACTED]

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 [REDACTED] unless waived by [REDACTED]

3.7.3 Identification^{3.5}

Parts or assemblies found to be in compliance with inspection requirements shall [REDACTED] be forwarded to a secure holding area or [REDACTED]

3.7.4 Failure Reporting^{3.7}

A Nonconformance Report QC-103 shall be [REDACTED]

3.7.5 Tooling Inspection^{3.3}

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

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Tools shall be [redacted]

3.7.6 Training *1-E5, 4-A, B, C, D

Training efforts shall be based upon [redacted]

[redacted] qualified and certified to use [redacted] work [redacted] location in the facility and each person's [redacted]

3.7.7 Workmanship Standard *1-E12

The Engineering and Quality Groups have lead responsibility for [redacted]

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]
[redacted]	[redacted]
[redacted]	[redacted]
[redacted]	[redacted]
[redacted]	[redacted]

- [redacted]
- [redacted]

DCC controlled issues of workmanship standards shall [redacted]

[redacted] be forwarded to the [redacted]

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]

examination of the accompanying documentation for

Completed supplies shall be

if required. When specified, parts or assemblies found to be acceptable shall be

[REDACTED] for

appropriate action.

When modifications, repairs or replacements are required

[REDACTED] shall be performed [REDACTED]

3.8.2 Final Acceptance Testing

Supplies shall be approved for

[REDACTED]

according to

make certain that appropriate warnings and safety notices are

[REDACTED]

on a

Nonconformance Report QC-103. The Nonconformance Review process shall report

[REDACTED]

When modifications, repairs or replacements are required after

[REDACTED]

3.8.3 Final Acceptance Processing

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

- [REDACTED]

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

Documentation attesting to the acceptance of the supply shall [Redacted]

3.9 Handling, Storage and Delivery

3.9.1 Protecting Product Quality *1-E10, E12, 8-A, D, D1, E, F, G, H, 10-A, B1, B2, C, D, E, 11-A, B, B1 through B7

The Quality Group specifies, where required and according to [Redacted] instructions for [Redacted] the overall effectiveness of [Redacted] Preservation, packaging, packing and marking instructions shall be [Redacted] when necessary. Labeling to indicate [Redacted] Whenever possible, items shall be [Redacted]

Shipping and Receiving is responsible for the following routines:

- [Redacted]

[Redacted text block]

- The Quality Group is responsible for [Redacted]

[Redacted text block]

Information pertaining to the approval status of each item is [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]

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[Redacted] certain supplies and repairs in Standard [Redacted] may be

established.

3.10.2 Nonconformance Report Processing

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

3.10.3 Misrepresented Items^{*8-J1}

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

3.10.3.1 Scrapping Items to Prevent Misrepresentation^{*8-I, 11, 12}

- The NRB selects the appropriate scrapping technique from [Redacted]
- [Redacted] The Company shall report suspect items to [Redacted]

3.11 Indication of Inspection Status^{3.5, *1-E13}

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]

3.11.2 Identification Media

The inspection status of supplies is [Redacted]

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The inspector completes a Good Material Tag, following its format, upon completion of [redacted] a Withhold Tag, following its format, until conditions [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]

When the Customer contract is accepted [redacted] shall not relieve the Company [redacted] for Customer use during [redacted] at the Supplier's facility shall be [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] 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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