QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)

1. COMMAND AGENCY:

U.S. ARMY EDGEWOOD RESEARCH, DEVELOPMENT AND ENGINEERING CENTER

2. THESE QAP'S FORM PART OF DRAWING/SPECIFICATION 5-1-2702 AS SPECIFIED IN THE CONTRACT. INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.

3.

PART I -- APPLICABLE DOCUMENTS

DRAWINGS

5-1-1972 - Gasket, Canister Carrier
5-1-1973 - Ring Slip Washer

SPECIAL PACKAGING INSTRUCTIONS (SPI)

P5-1-2702 - Slip Ring, Gasket Assembly

OTHER DOCUMENTS

EA-P-1486 - Plastic Components for Chemical-Biological Protective Mask, M42A1

PART II -- QUALITY PROVISIONS

1. **Responsibility for inspection.** Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth herein where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

2. **Responsibility for compliance.** All items shall meet all requirements of applicable drawings, special packaging instructions, and specifications. The inspection set forth in this QAP shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in this QAP shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

3. **Contractor assurance of compliance.** The contractor's quality program or detailed inspection plan shall provide assurance of compliance of all characteristics with the applicable drawing, special packaging instruction, and specification requirements using, as a minimum, the conformance criteria specified herein.

4. **Alternative inspection provisions.** Alternative inspection procedures, methods, or equipment, such as statistical process control, tool control, and other types of sampling procedures may be used by the contractor when they provide, as a minimum, the level of quality assurance required by the inspection provisions specified herein. Prior to applying such alternative procedures, methods, or equipment, the contractor shall describe them in a written proposal submitted to the Government for evaluation and approval. When required, the contractor shall demonstrate that the effectiveness of each proposed alternative is equal to or better than the quality assurance provisions specified herein. In cases of dispute as to whether the contractor's proposed alternative provides equal quality assurance, the provisions of this QAP shall apply. All approved alternative inspection provisions shall be specifically incorporated into the contractor's quality program plan or detailed inspection system, as applicable.

5. **First article inspection.**

a. **Submission.** The first article sample shall consist of 10 slip rings (Drawing 5-1-2702). However, when packaging in accordance with SPI P5-1-2702 is required by the contract, the first article sample shall consist of 10 packaged slip rings. The first article sample shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any or all of the requirements of the applicable drawings and specified SPI.

b. **Acceptance criteria.** If any first article sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

6. **Quality conformance inspection.**

a. **Lotting.** A lot shall consist of the items produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions, and at essentially the same time.

b. **Sampling.** Samples shall be selected at random. Sampling shall be conducted in accordance with table I using the inspection levels specified in Part III of this QAP. If required, special sampling, inspection, and acceptance criteria are contained in Part III of this QAP.

c. **Inspection characteristics.** Critical characteristics are characteristics whose nonconformance to specified requirements is likely to result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product or whose nonconformance to specified requirements is likely to prevent performance of the tactical function of a major end item. Major characteristics are characteristics whose nonconformance to specified requirements is likely to result in failure or to reduce materially the usability of the item for its intended purpose. Minor characteristics are characteristics whose nonconformance to specified requirements is not likely to reduce materially the operation or usability of the item for its intended purpose.

d. **Inspection.** Inspection shall consist of examination and test of all the characteristics contained in Part III and Part IV of this QAP. Every item in the lot shall be inspected for critical characteristics. The lot represented shall be rejected when nonconformance to a critical characteristic is found.

TABLE I. Sampling

Lot size	Inspection levels and sample sizes										
	I	II	III	IV	V	VI	VII	VIII	IX	X	XI
2 to 8	*	*	*	*	*	*	*	*	5	3	2
9 to 15	*	*	*	*	*	*	13	8	5	3	2
16 to 25	*	*	*	*	*	20	13	8	5	3	3
26 to 50	*	*	*	*	32	20	13	8	5	5	5
51 to 90	*	*	*	50	32	20	13	8	7	6	5
91 to 150	*	*	125	50	32	20	13	12	11	7	6
151 to 280	*	*	125	50	32	20	20	19	13	10	7
281 to 500	*	315	125	50	48	47	29	21	16	11	9
501 to 1200	*	315	125	75	73	47	34	27	19	15	11
1201 to 3200	1250	315	125	116	73	53	42	35	23	18	13
3201 to 10000	1250	315	192	116	86	68	50	38	29	22	15
10001 to 35000	1250	315	294	135	108	77	60	46	35	29	15
35001 to 150000	1250	490	294	170	123	96	74	56	40	29	15
150001 to 500000	1250	715	345	200	156	119	90	64	40	29	15
500001 and over	1250	715	435	244	189	143	102	64	40	29	15

*Indicates one hundred percent inspection. If sample size exceeds lot size, perform one hundred percent inspection.
Accept the lot represented on zero nonconforming characteristics and reject the lot represented on one or more nonconforming characteristics for all inspection levels.

REVISIONS

4. RELEASE NUMBER	Rev. A Z55-004												
5. DATE	30 Apr 93												
4. RELEASE NUMBER													
5. DATE													
REVISION STATUS OF SHEETS	6. REVISION	A	A	A	A	A							
	7. SHEET	1	2	3	4	5							
	6. REVISION												
	7. SHEET												

8. QAP FOR: SLIP RING, GASKET ASSEMBLY

9. SUBMITTED BY: S. T. KIM SCBRD-RNE-S — 10. QAP NO.: 5-1-2702

11. DATE: 18 Nov 92 — 12. APPROVED: John G. Sullivan — 13. RELEASE NO.: Z55-002 — 14. PAGE NO.: 1 — 15. NO. OF PAGES: 5

DARCOM FORM 1 APR 79 2484-R

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)

16. REVISION SYMBOL AND DATE: Rev. A 30 APR 1993 — 10. QAP NO.: 5-1-2702 — 14. PAGE NO.: 2

DARCOM FORM 1 APR 79 2484-R

QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)

16. REVISION SYMBOL AND DATE: Rev. A 30 APR 1993 — 10. QAP NO.: 5-1-2702 — 14. PAGE NO.: 3

DARCOM FORM 1 APR 79 2484-R

7. **Inspection equipment coding.**

AD - Army designed special acceptance inspection equipment
CD - Contractor designed special acceptance inspection equipment
CE - Commercial inspection equipment
VI - Visual inspection

8. **Inspection requirements for packaging.** Any inspection requirements for packaging are applicable only when military packaging is required by the contract.

PART III — INSPECTION REQUIREMENTS

CLASSIFICATION OF CHARACTERISTICS

(a) **Slip ring, gasket assembly (Drawing 5-1-2702)**

Category	Characteristic	Sampling and acceptance criteria	Inspection method
Critical	None defined		
Major			
101	Specified components correctly assembled	Table I, level VII	VI
102	Workmanship (assembly clean and free from damage such as cracks distortion or tearing)	Table I, level VII	VI

(b) **Packaging (SPI P5-1-2702)**

Category	Characteristic	Sampling and acceptance criteria	Inspection method
Critical	None defined		
Major			
101	Item completely clean and dry prior to unit packing	Table I, level IX	VI
102	Stiffener correct	Table I, level IX	VI and CE
103	Tape correct	Table I, level IX	VI and CE
104	Unit pack container correct	Table I, level IX	VI and CE
105	Unit pack container marking correct	Table I, level IX	VI and CE

PART IV — CERTIFICATION REQUIREMENTS

Certification shall be required for each characteristic specified below and shall include actual examination and test results when required herein. Results of examinations and tests shall be on file at the contractor's facility and shall be available to the Government for review.

Number	Characteristic	To comply with
401	Washer (Drawing 5-1-1973)	EA-P-1486
402	Gasket	Drawing 5-1-1972
403	Packaging material	Applicable specification or standard specified in SPI P5-1-2702

PART V — TEST METHODS AND PROCEDURES

Not applicable

PART VI — NOTES

1. **Changes from previous issues.** The margins of this QAP are marked with vertical lines to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationships to the last previous issue.

June 29, 2004 4:46 PM