


PROCESS BULLETIN 108:00

PROCEDURE FOR ADDITIONAL INSPECTION REQUIREMENTS FOR D5 PROGRAM – SUNDSTRAND REF. PQA-300

REVISION LOG

REV LTR	PAGE (S)	DESCRIPTION	DATE	BY	APPR
N/C	All	Initial release	04/26/89	LCL	RLR
A	All	Complete format change. Paragraph 2.1 "Rev. N/C" to "Rev. A." Exhibit 7.2A "Rev. E" to "Rev. F." Exhibit 7.2B "Rev. E" to "Rev. F." Exhibit 7.2C "Rev. L" to "Rev. M."	1-08-09	JSK	

*ORIGINAL SIGNATURE ON FILE



**PROCEDURE FOR ADDITIONAL INSPECTION
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SUNDSTRAND (REF. PQA-300)**

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1.0 PURPOSE

1.1 To establish a procedure for control, recording and retaining required inspection of certain characteristics and notes as noted herein and records retained until the year 2032.

2.0 SCOPE

2.1 The requirements of this procedure apply to all Sundstrand D-5 purchase orders requiring clause Appendix PQA-300, Rev. A.

3.0 DEFINITIONS

3.1 The characteristics and notes to be inspected and recorded will be as defined herein, as specified in MIL-STD-105, Sample Size Table I, Inspection Level II and Master Table IIA Normal.

4.0 RESPONSIBILITIES

4.1 Contracts

4.1.1 Contracts will enter or require entry upon all Sales Orders, reference to this procedure "PB 108:00 APPLIES."

4.1.2 Contracts will forward to Quality Assurance any changes to PQA-300.

4.2 Production Control

4.2.1 Production Control will enter or require entry on all PR-Assy reference to this procedure "PB 108:00 APPLIES" and forward to QA for review and approval.

4.3 Manufacturing Engineering

4.3.1 Manufacturing Engineering at the request of Quality Assurance or Production Manager will enter upon the PR-Assy those operations deemed appropriate.

4.4 Quality Assurance

4.4.1 Final Inspection (Station 10) will perform and record inspection on characteristics and notes per paragraph 3.0, PR-Assy and as noted herein.

4.4.2 The Final Inspection Data Sheet shall show Sample Size, Characteristics/Note inspected, the results (range), inspector and date. See Exhibits 7.2A, B and C.



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4.4.3 Copies shall be made and accompany shipment for that lot and become a part of shipping documentation.

5.0 INSPECTION REQUIREMENTS

5.1 Using MIL-STD-105, Sample Size Table I, Level II and Table IIA the following inspection and recording is required as stated in paragraph 7.0.

Part Number	Characteristics	Sheet	Drawing Zone	AQL
RV57-13				
5636930	Note 3	1	7/8C	100%
"	Note 17 (visual for insert)	1	7/8B	100%
"	Note 20	1	7/8A	100%
"	1 3/8-18UNJEF-3A Th'd (Check prior to installation of insert)	1	3/4A	1.5%
"	.924 / .925	1	3B	1.5%
"	All other characteristics/notes			4.0%
RV57-14				
5636997	Note 3	1	7/8C	100%
"	Note 17 (visual for insert)	1	6-8B	0.25%
"	Note 19	1	6-8B	100%
"	Note 20	1	6-8A	100%
"	1 3/8-18JEF-3A Th'd (Check prior to installation of insert)	1	4A	1.5%
"	.924 / .925	1	3B	1.5%
"	All other characteristics/notes			4.0%
RV99-38				
5636992	Note 3	1	7/8B	100%
"	Note 17 (Visual for insert)	1	5-8A	0.25%
"	Note 20	1	5-8A	100%
"	External MS33656E16 Th'd (Check prior to installation of insert)	1	3C	1.5%
"	All other characteristics/notes			4.0%



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EXHIBIT 7.2A

INSPECTION REPORT

Part No. RV57-13 Rev. No. F P.O. No. _____
 Part Name Relief Valve S.O. No. _____
Sample Size Procedure per PB 108:00

Notes	B/P DIM		Item	B/P DIM & TOL	Actual Reading	
1	N/A		21	1-3/8-18 UNJEF-3A Thd	-----	
2	N/A		22	1.375/1.366 DIA		
3	Test Results		23	Go/No Go Ring Gages		
4	N/A		24	.925-.924 DIA		
5	N/A		25	.210/.180 DIM		
6	Marking		26	1.555/1.545 DIM		
7	Serialized		27	.640/.620 DIM		
8	N/A		28	.310/.300 DIM		
9	N/A		29	3.600 MAX DIM		
10	N/A		30	O-Ring Groove	-----	
11	N/A		31	.217/.207 Wide		
12	N/A		32	.812/.811 DIA		
13	N/A		33	1.453/1.423 HEX		
14	N/A		34			
15	N/A		35			
16	N/A		36			
17	Insert	Bottomed .000/.003	37			
18	N/A		38			
19	O-Rings	Flash & Mismatch	39			
20	X-Rays	Spring <input type="checkbox"/>	40			

Remarks _____

Inspected By: _____ Date: _____



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EXHIBIT 7.2B

INSPECTION REPORT

Part No. RV57-14 Rev. No. F P.O. No. _____
 Part Name Relief Valve S.O. No. _____
Sample Size Procedure per PB 108:00

Notes	B/P DIM		Item	B/P DIM & TOL	Actual Reading	
1	N/A		21	1-3/8-18 UNJEF-3A Thd	-----	
2	N/A		22	1.375/1.366 DIA		
3	Test Results		23	Go/No Go Ring Gages		
4	N/A		24	.925-.924 DIA		
5	N/A		25	.210/.180 DIM		
6	Marking		26	1.555/1.545 DIM		
7	Serialized		27	.640/.620 DIM		
8	N/A		28	.310/.300 DIM		
9	N/A		29	3.600 MAX DIM		
10	N/A		30	O-Ring Groove	-----	
11	N/A		31	.217/.207 Wide		
12	N/A		32	.812/.811 DIA		
13	N/A		33	1.453/1.423 HEX		
14	N/A		34			
15	N/A		35			
16	N/A		36			
17	Insert	Bottomed .000/.003	37			
18	N/A		38			
19	O-Rings	Flash & Mismatch	39			
20	X-Rays	Spring <input type="checkbox"/>	40			

Remarks _____

Inspected By: _____ Date: _____



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EXHIBIT 7.2C

INSPECTION REPORT

Part No. RV99-38 Rev. No. M P.O. No. _____
 Part Name Relief Valve S.O. No. _____
Sample Size Procedure per PB 108:00

Notes	B/P DIM		Item	B/P DIM & TOL	Actual Reading	
1	N/A		21	1-5*16-12 UNTJ-3A Thd	-----	
2	N/A		22	1.312/1.301 DIA		
3	Test Results		23	Go/No Go Ring Gages		
4	N/A		24	1.640/1.610 DIA		
5	N/A		25	1.215/1.185 DIA		
6	Marking		26	40°/50° 2 PLCS.		
7	Serialized		27	.580/.560 DIM		
8	N/A		28	.145/.135 DIM		
9	N/A		29	1.229/1.209 DIA		
10	N/A		30	.145/.105 DIM		
11	N/A		31	2.077/2.047 DIM		
12	N/A		32	1.266/1.234 HEX		
13	N/A		33			
14	N/A		34			
15	N/A		35			
16	N/A		36			
17	Insert	Bottomed .000/.003	37			
18	N/A		38			
19			39			
20	O-Rings	Flash & Mismatch	40			

Remarks _____

Inspected By: _____ Date: _____