

## RC-62 INSPECTION REQUIREMENTS – SSME

Paragraph 3.6 and 3.5 "Statistical Quality Control" - Imposed by Specification STO802GT0001/STO802GT0002 and STO802GT0008 respectively under Code 20 of Buyer's Purchase Contract is hereby deleted in its entirety and the following provision substituted in lieu thereof:

1. Seller or Seller's subcontractors shall maintain verifiable objective evidence that each finished detail, sub-assembly and final assembly characteristic, of products comprising this contract were 100% inspected.
2. Exceptions to this contractual provision necessitated by Seller's manufacturing and/or processing methods must be submitted to the Buyer in writing noting the reason for contract exception along with an alternate inspection plan, indicating each characteristic involved and Seller's alternate proposal for assuring conformance.
3. To participate in a sampling program seller shall, as a minimum, have 1) submitted an approved first article, and 2) have performed consistently in the normal and reduced inspection category, as defined in MIL-STD-105D, when submitting material to The Boeing Company.
4. In lieu of 100% inspection of all features, Seller shall:
  - Justify deviation from Buyer's contractual inspection requirements.
  - Specifically identify all features to be sampled.
  - Classify characteristics to be sampled, subject to:
    - The determination that a characteristic is critical shall preclude the use of sampling inspection methods.
    - The documented justification of any and all deviations from Buyer's classification of characteristics.
    - Sample as or more stringently than requirements of Buyer's Quality Assurance Instruction RI-16.1-XVI.
    - Submit plan for ensuring randomness of sample.
    - Plan must assure randomness of sample in accordance with MIL-STD-105.

NOTE: Repetitive dimensions/features may qualify single parts for sampling, subject to Buyer's Quality Engineering approval on feature by feature basis.

5. Complete records, by serial or lot number, of all sample data will be kept on file as specified by requirements of Buyer's contract, including those features and units which are rejected as a result of sampling inspections.
6. The proposed alternate plan identifying supplier's name and plan number shall be submitted to Buyer's Purchasing department.
7. Buyer approval of Seller's alternate plan will be evidenced by the signatures and date of authorized representatives of NASA and Buyer's Quality Engineering department.

8. The sampling program shall be maintained as part of the supplier quality system and shall be subject to verification by Buyer's Procurement Quality Assurance.