



DEPARTMENT OF THE NAVY

NAVAL SEA LOGISTICS CENTER
5450 CARLISLE PIKE
PO BOX 2060
MECHANICSBURG, PA 17055-0795

IN REPLY REFER TO

NAVSEALOGCENINST 4440.1 CH-1
N44/AMW
JUL 6 2000

NAVSEALOGCEN INSTRUCTION 4440.1 CHANGE TRANSMITTAL 1

From: Commanding Officer, Naval Sea Logistics Center
To: All NAVSEALOGCEN N44 Personnel

Subj: PROCEDURES FOR LEVEL 1/SUBSAFE (LI/SS) CONTRACT/PURCHASE
ORDER NEWS AND QUALITY ASSURANCE LETTERS OF INSTRUCTION

Encl: (1) NAVSEALOGCEN Checklist for the Review of LI/SS Contracts and
Purchase Orders
(2) Quality Assurance Letter of Instruction for Contracts Administered by a
Defense Contract Management Agency w/enclosure and attachments
(3) Quality Assurance Letter of Instruction for Contracts Administered by a
Supervisor of Shipbuilding Activity w/enclosure and attachments

1. Purpose. To update subject instruction.

2. Action. Holders of the basic instruction will:

a. Make the following pen and ink changes:

(1) Replace "Defense Contract Management Command (DCMC)" with
Defense Contract Management Agency (DCMA) or Supervisor of Shipbuilding
(SUPSHIP)" in paragraph 2b.

(2) Replace "DCMC" with DCMA/SUPSHIP" in paragraphs 2b, 2c
(2 places), 4 (3 places), 6c, and 6e.

(3) Replace "issuance" with "issuing" in paragraph 3.

(4) Replace "five days" with "ten days" in paragraph 6a.

(5) Replace "enclosure (2)" with "either enclosure (2) or (3)" in paragraph 6c.

(6) Replace "on a quarterly basis" with "each month" in paragraph 6d.

(7) Add "when included with procurement document" after "contract
folders" in paragraph 6h.

NAVSEALOGCENINST 4440.1 CH-1

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Subj: PROCEDURES FOR LEVEL 1/SUBSAFE (LI/SS) CONTRACT/PURCHASE
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(8) Replace "contract review" with "QALI file" in paragraph 6h(2).

(9) Delete "M85" of "Copy to:" list.

b. Replace enclosure 1 of basic instruction with enclosure (1) of this change transmittal.

c. Replace enclosure (2) of basic instruction with enclosure (2) of this change transmittal.

d. Add enclosure (3) of this change transmittal as enclosure (3) to basic instruction.


J. A. GUSTAFSON
By direction

Copy to:
NAVICP (M02B, M024, M0241, M0243, M84, M845, M8451, M8452, M8453)



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NAVSEALOGCENINST 4440.1
N44/AMW

OCT 23 1998

NAVSEALOGCEN INSTRUCTION 4440.1

From: Commanding Officer, Naval Sea Logistics Center

Subj: PROCEDURES FOR LEVEL I/SUBSAFE (LI/SS) CONTRACT/PURCHASE
ORDER REVIEWS AND QUALITY ASSURANCE LETTERS OF
INSTRUCTION

Ref: (a) NAVICP Itr 4400 Ser 8452/086 of 13 Mar 96

Encl: (1) NAVSEALOGCEN Checklist for the Review of LI/SS Contracts and
Purchase Orders
(2) Quality Assurance Letter of Instruction (QALI)

1. Purpose. To establish procedures for the internal processing of Level I/SUBSAFE (LI/SS) Contract/Purchase Order Reviews and the internal process of Quality Assurance Letters of Instructions (QALIs).

2. Definitions

a. Contract Review. A review of all LI/SS Stock Program contracts/purchase orders to ensure that all required administrative requirements and contract clauses are included.

b. Quality Assurance Letters of Instruction (QALI). Specific instructions issued to a Defense Contract Management Command (DCMC) Quality Assurance Representative (QAR) to supplement the normal DCMC Quality Assurance Program function that specify mandatory inspections pertaining to the most important tests, dimensions, or other characteristics of the product. QALIs are prepared when a contract is awarded to a vendor who has exhibited quality problems on items similar to those of the contract.

c. Joint Source Certification. Generally, when material is procured for the LI/SS Stock Program it is inspected by the DCMC QAR at the contractor's facility and subsequently delivered to Portsmouth Naval Shipyard (PNS) for receipt inspection and acceptance. Once it is accepted, a Material Identification and Control (MIC) marking is applied to the material and it is then sent to the respective stocking point.

OCT 23 1998

Depending on various factors such as the need for the material, shipping costs, prior quality problems, etc., Joint Navy Source Inspection and Certification may be used. For Joint Navy Source Inspection and Certification, a receipt inspector representing PNS goes to the contractor's facility and together with the DCMC QAR performs a joint inspection of the material against the requirements of the contract.

Upon inspection and acceptance of the material at the contractor's facility, the receipt inspector from PNS assigns MIC certification. The material is then sent directly to the end user or the designated stocking point.

3. Scope. This instruction applies to all Naval Sea Logistics Center (NAVSEALOGCEN) employees responsible for performing reviews of LI/SS *issuing* Contract/Purchase Orders, and those employees responsible for the ~~issuance~~ of a QALI from identifying a contractor to receive a QALI to the closing of a QALI.

The requirements of this instruction are applicable to items assigned Special Material Identification Codes (SMICs), L1 (Level I), SS (SUBSAFE), S1 (Surface Unique Level I), C1 (Level I Oxygen Clean), SB (SUBSAFE Oxygen Clean), Q3 (Quality Assured), and VG (Quality Assured Oxygen Clean).

4. Background. Review of contracts/purchase orders for LI/SS Stock Program material is conducted to ensure that all the necessary administrative requirements and clauses are included. Many requirements and contract clauses are unique to specific items, thereby requiring tailoring of the contract. Review of the contracts reduces potential delays within the contract cycle as well as prevents possible claims against the Government.

Subsequently, when a contract is awarded to a contractor who has exhibited quality problems on items similar to those under the contract, NAVSEALOGCEN prepares and issues a QALI to the DCMC. The purpose of the QALI is to provide specific inspection and/or test criteria to be monitored by the DCMC QAR. In addition, the QALI serves to alert the DCMC QAR of adverse trends and specific problems in an effort to preclude the risk of repeat rejections and delivery of unacceptable material to the LI/SS Stock Program.

5. Responsibilities. NAVSEALOGCEN's responsibility for managing the LI/SS Contract Review task and the QALI task is provided by reference (a).

6. Action. Upon receipt of contracts and/or contract modifications whether from NAVICP via the Print Office or a CASREP delivered via internal courier, the following actions shall be followed:

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a. Contracts or purchase orders shall be reviewed within five days of receipt. CASREPs shall be reviewed within two days. The review shall ensure that all administrative requirements and clauses listed in enclosure (1) are included as applicable.

b. If the review discloses any deficiencies, such as the omission of an administrative requirement or a required contract clause, NAVSEALOGCEN shall provide a memorandum to the NAVICP Buyer (Code 0243 or Code 0241) identifying the need for a correction and requesting proper modification to the contract. A copy of the memorandum shall be forwarded to NAVICP (Codes 024 and 0243, and 0241) for CASREP contracts.

c. When it is determined that the normal DCMC Procurement Quality Assurance (PQA) actions will not suffice, a tailored QALI, ^{DCMA/SUBSHIP} enclosure (2), shall be issued. *either enc (2) or (3)*

d. NAVSEALOGCEN shall prepare a QALI List on a quarterly basis. ^{each month} The QALI List is a listing of contractors meeting specific criteria and denoting that procurements involving those contractors require the preparation of a QALI. The QALI List shall be prepared in March, June, September, and December.

e. When preparing QALIs, specific characteristics must be designated. ^{DCMA will} not accept general designations. ^{DCMA/SUBSHIP} QALI requirements must not exceed contractual requirements, e.g., do not specify 100% inspection when the contract requires only sampling inspection. As a minimum, consideration must be given to the following data elements in determining the need for and selection of appropriate QALI requirements:

- (1) Purchase specifications requirements.
- (2) NAVSEALOGCEN contractor history file.
- (3) Defective material files/reports.
- (4) Contractor survey results.
- (5) Product Data Reporting and Evaluation Program (PDREP) data.
- (6) NAVSEALOGCEN Vendor Assessment Program (VASP) data.

f. Upon determining that a contract requires a QALI and/or Joint Source Certification, the NAVSEALOGCEN Desk Guide for the preparation of QALIs, and/or Joint Source Certifications shall be used for supplementary guidance.

g. QALIs shall be prepared on a contract-by-contract basis and shall be issued on contracts/purchase orders for supplies which have a critical application, are complex,

or have unusual requirements. The decision shall also be based on past contractor performance and criticality of the material.

h. CASREP contract folders ^{when included with procurement document} shall be initialed, dated, and stamped to indicate whether or not a QALI is being issued for that order.

i. Upon receipt of a contract modification, the contract number will be checked to determine whether or not NAVSEALOGCEN has issued a memo requesting that changes be made.

(1) If NAVSEALOGCEN has issued a memo pertaining to the same contract number as the modification, then NAVSEALOGCEN shall verify that all the necessary changes requested by the memo were made.

(2) If NAVSEALOGCEN has not issued any memos against that particular contract number, then NAVSEALOGCEN shall determine whether or not any QALIs were issued on that contract. If a QALI was issued, NAVSEALOGCEN shall review the modification to determine whether or not there are any changes in the delivery date which in turn may affect the QALI process. A copy of the contract modification shall be filed with the original NAVSEALOGCEN ~~contract review~~. *QALI File.*

7. Maintenance. The maintenance responsibility for this instruction is assigned to the LI/SS Support Division (N44) of the Logistics Support Engineering Group (N40).


J. J. HUND

Distribution:
N44 Personnel

Copy to:
NAVICP (M02B, M024, M0241, M0243, M84, M845, M8451, M8452, M8453, ~~M85~~)

JUL 6 2000

22 May 2000
Revision E**CHECK LIST FOR THE REVIEW OF LEVEL I/SUBSAFE CONTRACTS**

The following items shall be included in all LI/SS Stock Program contracts/purchase orders unless an exception is noted:

1. **Contract No., Contractor and Contractor's CAGEC** on cover page of contract/purchase order.
2. **LEVEL I, SUBSAFE, SURFACE LEVEL I, LEVEL I OXYGEN CLEAN, SUBSAFE, OXYGEN CLEAN, and R/Y/G** stamped on the first page of contract. SMIC **Q3** stamp is not required on first page of contract/purchase order.
3. **RED/YELLOW/GREEN (R/Y/G)** stamped on contract Cover Sheet. Ensure Clause **NAVICPGA03 – NOTICE TO CONTRACT ADMINISTRATION AND RECEIVING ACTIVITIES (JUN 1994) (NAVSUP)** is included in the contract/purchase order.
4. **National Stock Number (NSN), Delivery Date, and Ship To Activity** on Page 2 (Continuation Sheet) of contract/purchase order.
5. **Shipment destinations** on distribution in External Distribution Section of contract/purchase order.
6. **Waiver of Inspection and Test Plan** (normally CDRL Item A001) in Awards Notes section of continuation page.
7. **Configuration Control** clause in Section C, Paragraph 3, Requirements of contract/purchase order.
8. **Mercury Free** clause in Section C, Paragraph 3, Requirements of contract/purchase order.
9. **Radiography** clause in Section E, Paragraph 4, Quality Assurance of contract/purchase order. Issue QALI for all awards invoking radiography, **except the radiography of weld joints.**
10. **NAVICPDA02 – MARKINGS (LI/SS) NAVICP-M) MAR 1993)** and **NAVICPEA01 – SOURCE INSPECTION & ACCEPTANCE LEVEL I/SUBSAFE MATERIALS (NAVICP-M) (NOV 1992).**
 - a. Joint Source Certification is invoked on **Oxygen Clean, DMP, Selected Trippers, Problem Vendors, Propulsion Shafts and Repair Items** listed on the current **Consolidated LI/SS Joint Source Certification List.**

Enclosure (1)

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- b. Joint Source Certification will be waived by a note on Page 2 of the award, for a large purchase when a "buy" is solicited via a RFT, (i.e., 99-R....and Source Certification clauses are included), and the "buy" is awarded via Contract (i.e., 99-C-....). The RFP becomes part of the award so an Award Note is included on Page 2 to delete the source certification clauses.

NOTE: No Award Note is included on Page 2 of the contract when the "buy" is for a small purchase and solicited via a RFQ (i.e., 99-Q-...and Source Certification clauses are included in the solicitation) and the "buy" is awarded via a Purchase Order (i.e., 99-P-...) because the entire solicitation (RFQ) is reprinted and included as part of the purchase order.

11. **NAVICPEA03 – INSPECTION AND ACCEPTANCE (NAVICP-M) (APR 1993)** and verify that site for final acceptance agrees with Sub-Paragraph 1. (Non-Joint Source Certification Contracts).
12. **Quality System Requirements** clause in Section E, Paragraph 4., Quality Assurance invoking a specific inspection system.
13. **NAVICPGA02 – NOTE FOR CONTRACTOR/ADMINISTRATIVE CONTRACTING OFFICER (NAVICP-M) DEC 1996) and proper fill-ins:**
- a. "< > When a DCMA office ... and "Inquiries and correspondence directed...as follows: Code < >".
- b. "< > NOTE FOR CONTRACTORS..." and "DELIVER UNOPENED TO CODE < >"
14. **Clause 42.246.17 - Warranty of Supplies.** This clause is not required for **Q3 stock buys and repair contracts**
15. **Clause 52.246.2 - Inspection of Supplies Fixed-Price; Clause 252.243.7000 – Engineering Change Proposals invoking MIL-STD-973; Clause 252.246.7000 - Material Inspection and Receiving Report; and Clause 252.246.7001 - Warranty of Data.**
16. Contract Data Requirements List (DD Form 1423) items correspond to contract/purchase order.
17. Awards distribution codes include:

EXTERNAL DISTRIBUTION:

- N00102 (Code 136.2) -- All Contracts including contracts invoking Radiography.
- N00102 (Code 138) -- Welding Electrodes Awards

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INTERNAL DISTRIBUTION:

NAVSEALOGCEN (N44)

NOTE: When a contract is a CASREP and hand carried by NAVICP or forwarded in via mail courier in the contract folder, the cover of folder shall be stamped "QALI" and recorded if a QALI was required or not, dated and initialed by reviewer when review of contract is complete. Reconcile vendor with QALI Candidate List.

JUL 6 2000



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COM & FTS (717) 605-
DSN 430 & EXT.
FAX #
IN REPLY REFER TO:
4400
Ser N44/

From: Commanding Officer, Naval Sea Logistics Center
To: Commander, Defense Contract Management Agency, Quality Assurance
Representative
c/o DCMA (City)
Attn: (Gov't QAR)

Subj: LEVEL I/SUBSAFE (LI/SS) SPECIAL INSPECTION REQUIREMENTS FOR
CONTRACT N00104-00-_____ WITH (VENDOR)

Encl : (1) Quality Assurance Letter of Instruction (QALI)

1. Request enclosure (1) be implemented for the subject contract. Enclosure (1) is not intended to restrict you from performing other inspection requirements as may be required or appropriate.
2. Questions pertaining to enclosure (1) should be directed to the Naval Sea Logistics Center (NAVSEALOGCEN) N44, unless otherwise specified. If notified by the contractor that inspections and/or tests performed by you, as required by enclosure (1), may result in additional cost or delay in delivery, advise the contractor to contact the Procurement Contracting Officer (PCO) at the Naval Inventory Control Point (NAVICP).
3. Initial submission of Attachments (A), (B) and (C) of enclosure (1) shall be completed by you and returned within thirty (30) days from the date of this letter. A return envelope is provided for your convenience.
4. Final submission of Attachments (D), (E), (F) or (G) of enclosure (1) shall be completed by you and returned within thirty (30) days from the date that the DD Form 250 has been signed. Please provide a copy of the DD Form 250 along with the objective quality evidence. You are responsible for collecting and forwarding all required documents from a subcontractor Quality Assurance Representative (QAR(s)) to whom a letter of delegation was issued.
5. Authority for approval of nonconforming supplies by Defense Contract Management Agency (DCMA) is restricted and specifically addressed in the subject contract.

Enclosure (2)

JUL 6 2000

Subj: LEVEL 1/SUBSAFE (LI/SS) SPECIAL INSPECTION REQUIREMENTS FOR
CONTRACT N00104-00-_____ WITH (VENDOR)

6. In accordance with DLAM 8200.2, Section III, Part 1, you are requested at the time of each shipment, to forward copies of all supporting documentation associated with material release and the attached QALI to:

Naval Sea Logistics Center (N44)
ATTN: Alice M. Worchach
PO Box 2060
Mechanicsburg, PA 17055-0795

7. As identified by Attachment (A) and (D) of enclosure (1), increased surveillance of the contractor is being requested. The prime contractor may have previously experienced a problem in the delivery of requisite material to the LI/SS Stock Program and/or the contractor's processes to satisfy the quality assurance provisions of this contract requires a documented review. If a process review has been completed within the last three years, please provide the Objective Quality Evidence (OQE) of such review to update our records. The following method(s) of increased surveillance has been specified for the attached QALI, as indicated by the marking of a "X" below.

Type I – Inspection (Attachment E of enclosure (1) applies)

Type II – Process Control Review (Attachment F of enclosure (1) applies)

8. As a reminder, submission of waivers and deviations should be submitted to the Procurement Contracting Officer via the NAVICP, Mechanicsburg web site at <http://www.navicp.navy.mil/84/download.htm>. Process Control Checklists are available for printing via Naval Sea Logistics Center, Detachment Portsmouth web site at <http://www.nslcptsmh.navsea.navy.mil/supplier/supplier.htm#par>.

9. Our point of contact for this matter is Alice M. Worchach, NAVSEALOGCEN N44, DSN 430-1896 or Commercial (717) 605-1896. Her Email address is "WorchachAM@NAVSEA.NAVY.MIL". The facsimile (FAX) number for our office is (717) 605-4750.

E. E. MARTIN, III, P.E.
By direction

Copy to:
DCMA Philadelphia (w/o enclosures)
DCMD-E-OP (J. Puleo) (w/o enclosures)
NAVICP (Codes 02522.03)

JUL 6 2000

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI)

Ref: (a) NAVSEA P-3683 Navy and Marine Corp Product Data Reporting and Evaluation Program (PDREP) Manual

A. Purpose:

1. The Contractor may have previously experienced a problem in the delivery of requisite material to the Level I/SUBSAFE (LI/SS) Stock Program or the contractor's processes that would be used to satisfy the quality assurance provisions of this contract requires a documented review.

2. Naval Sea Logistics Center (NAVSEALOGCEN) has evaluated the performance data and requests increased surveillance along with supporting documentation to either preclude recurrence or update of a documented review for the following:

Contract Number:

Prime Contractor:

DCMA Location:

Procurement Contracting Officer:

Naval Inventory Control Point (Code 0243.)

ATTN:

P O Box 2020

Mechanicsburg, PA 17055-0788

Phone: (717) 605-

B. General Instructions :

1. This QALI supplements the quality assurance provisions issued for the subject contract.

2. Unless a 100 percent inspection is indicated for a characteristic, sample inspect in accordance with the subject contract.

C. Definitions : The words listed below are used throughout this QALI and are defined as follows:

1. **Perform** - physically accomplish test(s) and/or inspection(s).

2. **Witness Complete** - observe the supplier's performance of all steps of the test, inspection, or other operation to ensure that the requirements of the contract

are met including verification during the initial observation that an approved procedure, where required, is used.

3. **Witness** - observe the test, inspection or other operation, when it is performed by the supplier, to the extent necessary to ensure that requirements are met, including initial observation that an approved procedure where required, is used.

4. **Verify** - review completely contractor's documented evidence of test(s) and/or inspection(s).

5. **Objective Quality Evidence (OQE)** - quantitative and qualitative data of all mechanical, chemical, and performance tests performed (as required by the applicable specification, drawing, or other provisions of the contract) to prove that the material supplied conforms to the specified requirements.

D. Specific Instructions :

1. It is requested that the following requirements be satisfied by the Administrative Contracting Officer (ACO), Defense Contract Management Agency (DCMA) Quality Assurance Representative (QAR), servicing the Prime Contractor.

2. Performance of inspection shall be documented as the inspections are performed. The supporting documentation provided by the DCMA QAR is separate from the documentation maintained by the contractor. The documentation should include, as a minimum, the following information:

- a. The type of inspection performed (nomenclature, i.e. visual, dimensional, etc.)
- b. Contract/purchase order number
- c. Description of the component(s)
- d. Part number and revision number
- e. Heat or lot number, manufacturer's serial number or contract line item number and contract number of the component(s)
- f. Date of inspection
- g. Contractor's procedure used
- h. Number of items inspected, accepted, rejected and the sample size used (if reject, refer to the corrective action request number)
- i. Name of individual performing the inspection (first initial and last name or unique individual code)

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

3. The inspection characteristics listed below shall be identified on the inspection record using the appropriate Inspection Attribute Code.

4. Since only certain inspection characteristics from Chapter 3, pages 63-65 of reference (a) will apply to this contract, the numerical sequence may be discontinuous.

5. Due to the critical program requirements, the DCMA QAR must maintain the documentation of completed inspections for a minimum period of two years after the sign-off date on the DD Form 250, unless a greater time period is specified by another specification or document. It is highly recommended that the DCMA QAR establish a procedure to prevent water and/or fire damage of records.

6. Inspection records need to be maintained either in the form of handwritten (in ink) records or a computer-based record system. When the option to use a computer-based record system is elected, provisions for periodic back-up of all records must be implemented. Changes to computer systems, software, or macro routines normally result in the loss of usefulness of computer-based information. As such, it is highly recommended that Microsoft Office products be the software standard. DCMA shall assure that records are retrievable and available upon request.

E. **Inspection Attributes and Codes:** One or more of the following inspection attributes may be specified for this QALI. This paragraph provides amplification of a Type I request for increased surveillance. The specific attributes applicable to this QALI are highlighted in gray and identified on Attachment E as follows:

1. **Documentation** (Attribute Code 01) - For each inspection lot, the DCMA QAR shall **verify** that the documentation required by the Contract Data Requirements List (CDRL), is complete in quantity and content, is legible and signed by an appropriate representative, is directly traceable to the material and is included with the shipment. Also, forward one copy of all documentation is to be forwarded to the PCO.

2. **Packaging and Packing** (Attribute Code 03) - The DCMA QAR shall **witness** that the packaging and packing is in accordance with the subject contract.

3. **Visual Product Inspection** (Attribute Code 04) - For each inspection lot, the DCMA QAR shall **perform** a visual inspection for good workmanship ensuring that the inner and outer surfaces of the item are free of dirt, chips, scale and foreign substances and that there are no dents, cracks, gouges or tool marks, which may restrict the flow or violate minimum wall thickness.

4. **Material Identification** (Attribute Code 05) - For each inspection lot, the DCMA QAR shall **perform** an inspection to ensure all markings (100%) are clearly and legibly marked on the material and are directly traceable to the certification

provided in accordance with the quality assurance provisions of the subject contract and the requirements of Data Item Description of DI-MISC-81020.

5. Material Verification (Attribute Code 06) - For each inspection lot, the DCMA QAR shall **verify** that quantitative chemical and mechanical analyses are traceable to heat, lot, or batch identification and in accordance with the quality assurance provisions of the subject contract and meet the requirements of Data Item Description of DI-MISC-81020.

6. Radiography (Attribute Code 07) - For each item (100%), the DCMA QAR shall **perform** inspection on all radiographs and shooting sketches for quality and conformance. The radiography test procedure will receive a documented review to ensure that the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the quality assurance provisions of the subject contract. Acceptance criteria for castings will be to criticality Level I per Table XVIII, XIX, or XX, as applicable, of MIL-STD-278. Acceptance criteria for weldments will be per Table XI of MIL-STD-278 (P-1 piping) or MIL-STD-2035, class 1, as applicable. In performing the above inspection, the DCMA QAR shall:

a. Ensure that radiography is inspected and accepted by a qualified QAR in accordance with DLAM 8200.2 Section III Part I Paragraph 3-104 and DLAM 8200.1, PQA Section 9-504.

b. Complete Attachment G, the RT Check List, and forward with the film to:

Portsmouth Naval Shipyard
ATTN: Code 136.2
Portsmouth, NH 03804-5000

Also, send a copy of the completed RT Check List to:

Naval Sea Logistics Center N44
ATTN: Alice Worhach
P O Box 2060
Mechanicsburg, PA 17055-0795

c. The DD 250 and RT Certification(s) shall be completed in accordance with DLAM 8200.1, Section III, Paragraph 3-104.

7. Magnetic Particle Test (Attribute Code 08) - For each item (100%), the DCMA QAR shall **verify** the magnetic particle test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

8. Ultrasonic Test (Attribute Code 09) - For each item (100%), the DCMA QAR shall **verify** the ultrasonic test. The test procedure will receive a documented review

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

9. Liquid Penetrant Test (Attribute Code 10) - For each item (100%), the DCMA QAR shall **verify** the liquid penetrant test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

10. Pressure Test (Attribute Code 12) - For each item (100%), the DCMA QAR shall **witness complete** the performance of the test and verify the results of the test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

11. Dimensions (Attribute Code 15) - For each item (100%), the QAR shall **witness** the dimensional inspection in accordance with the tolerance of the applicable specification, drawing, or other provisions of the contract. In the case of balls or ball assemblies for ball valves, the following dimensional characteristics are highlighted:

- _____ a. Dimensions of ball(s) outside diameter, and finish
 - _____ b. Location and size of the ball bore and of the ball stem slot
 - _____ c. Single seat height over the ball in accordance with the specification
 - _____ d. Dimensions from seat retainer plug mating surface of body to centerline of stem cavity and back seat surface in body
 - _____ e. Dimension from seat retainer plug mating face surface to back seat surface on end of plug
 - _____ h. Dimensions from tailpiece bolting face surface to back seat surface
 - _____ i. When air bleed holes are required by the referenced drawing, ensure appropriate air bleed holes are in their proper location
 - _____ j. Other dimensions: _____
-

12. Finish (Attribute Code 19) - For each (100%) item, the DCMA QAR shall **perform** inspection of surface finish, grade, type and coverage in accordance with the subject contract.

F. **Attachments** : The following attachments invoke the specific requirements of this QALI and identify the necessary reporting information to monitor the successful completion of this QALI.

1. Attachments A & D to this enclosure are the front pages of the DCMA QAR Acknowledgement and identifies the specific method of surveillance to be accomplished by the DCMA QAR for the subject contract. The method of increased surveillance includes inspections and/or process control reviews, identified as Type I and II of this QALI, respectively. Submission of Attachment A is required for the initial disposition and Attachment D is required for the final disposition of this QALI. OQE (inspection records) must be provided to NAVSEALOGCEN N44 with the final disposition and shall include a signed copy of the DD 250.

2. Attachment B to this enclosure requests pertinent information for the identity of the prime contractor and subcontractors performing work on the subject contract. If applicable, a copy of the letter of delegation for subcontractors is requested. Attachment B also requests the identification of the contractor's inspection system documentation. Submission of Attachment B is required at the time of initial disposition of this QALI. Please notify NAVSEALOGCEN N44, if any changes occur during the processing of the subject contract.

3. Attachment C to this enclosure requests pertinent information for the identity of the DCMA QAR for the prime contractor and all DCMA QARs at the subcontractors' locations performing work on the subject contract. Submission of Attachment C is required at the time of initial disposition of this QALI. Again, please notify NAVSEALOGCEN N44 if any changes occur during the processing of the subject contract.

4. Attachment E to this enclosure specifically identifies by attribute the inspection(s) to be accomplished during the processing of the subject contract. Amplification of the inspection requirements has been provided within the previous paragraph E, "Inspection Attributes and Codes". It is considered a Type I method of increased surveillance of the prime contractor. If a Type I surveillance method is specified by the QALI, one submission of Attachment E along with the OQE (inspection record) is required at the time of final disposition of the contract to NAVSEALOGCEN N44.

5. Attachment F to this enclosure requests a comprehensive review of the contractor's and/or subcontractor's process(es). This review may be accomplished during a joint (DCMA/NAVICP/NAVSEALOGCEN) Pre-Award or Post-Award Survey, provided the survey is recommended by the PCO. In all other cases, the DCMA QAR is requested to accomplish the review. A process control check list is provided for each process identified. Completing and submitting the check list satisfies the requirement for the OQE. This review should be performed prior to the commencement of work on the subject contract. All corrective action(s) needed to resolve a deficiency is to be reported. A Corrective Action Request (CAR) form is

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

provided for this purpose. If a Type II surveillance method is specified by the QALI, one submission of Attachment F along with the completed process control check list and any resulting Corrective Action Requests (CAR) is required at the time of final disposition of the contract to NAVSEALOGCEN N44. Please notify NAVSEALOGCEN N44 when corrective action has been accomplished.

6. Attachment G to this enclosure is the Radiographic Film Package Check List and is provided as an aid for processing radiographic film for the Overread Inspection required by the Level I/SUBSAFE Program. When radiography is invoked in the contract, one submission of Attachment G is required to be provided to Portsmouth Naval Shipyard for the Overread Inspection and one submission of Attachment G is required at final disposition to NAVSEALOGCEN N44.

YOUR QALI CHECKLIST		
INITIAL SUBMISSION		
<input type="checkbox"/>	ATTACHMENT "A" (FRONT PAGE)	ACKNOWLEDGEMENT
<input type="checkbox"/>	ATTACHMENT "B"	
<input type="checkbox"/>	ATTACHMENT "C"	
<input type="checkbox"/>	COPY OF LETTERS OF DELEGATION (LODs)	
FINAL SUBMISSION		
<input type="checkbox"/>	ATTACHMENT "D" (FRONT PAGE)	ACKNOWLEDGEMENT
<input type="checkbox"/>	COPY OF DD FORM 250	
<input type="checkbox"/>	ATTACHMENT "E" ALONG WITH - OBJECTIVE QUALITY EVIDENCE	TYPE I SURVEILLANCE ONLY
<input type="checkbox"/>	ATTACHMENT "F" ALONG WITH - COMPLETED PROCESS CONTROL CHECKLIST - CORRECTIVE ACTION REQUESTS (CAR)	TYPE II SURVEILLANCE ONLY
<input type="checkbox"/>	ATTACHMENT "G"	RADIOGRAPHY ONLY

<p>JUL 6 2000</p>	<p>LEVEL I / SUBSAFE STOCK PROGRAM</p> <p>DCMA QAR ACKNOWLEDGEMENT</p> <p>QUALITY ASSURANCE LETTER OF INSTRUCTION</p> <p>NAVICP CONTRACT NUMBER: N00104 - _____</p> <p>QALI REQUIREMENT / INITIAL SUBMISSION</p>
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ORIGINAL REQUEST / POINT OF CONTACT

The Defense Contract Management Agency (DCMA) Quality Assurance Representative (QAR) is requested to identify the information in Attachments B and C along with this attachment and return the same to the address below. If additional information or clarification is needed, please contact Alice M Worhach at the Naval Sea Logistics Center (N44). Her phone number is (717) 605-1896 or DSN (430). The office facsimile number is (717) 605-4750 and her internet address is "WorhachAM@NAVSEA.NAVY.MIL". The QAR of the Prime Contractor is responsible for collecting and forwarding all required documents from a subcontractor QAR(s) to whom a Letter of Delegation (LOD) was issued

Naval Sea Logistics Center (N44)
 ATTN Alice M. Worhach
 P.O. Box 2060
 Mechanicsburg, PA 17055-0795

The Naval Sea Logistics Center is recommending _____ Type I - inspection(s) by Attribute (Attachment E) and/or increased surveillance of the Prime Contractor _____ Type II - Process Control Review (Attachment F) by the following method(S):

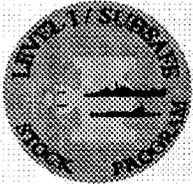
PLANNED DISPOSITION OF INSTRUCTION

<p>ATTACHMENT</p> <p>E</p>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<p>INSPECTION(S) BY ATTRIBUTE WILL BE PERFORMED (PROVIDE COPY OF OBJECTIVE QUALITY EVIDENCE)</p> <p>INSPECTION(S) BY ATTRIBUTE WILL BE PERFORMED WITH EXCEPTIONS NOTED</p> <p>INSPECTION(S) BY ATTRIBUTE CANNOT BE PERFORMED FOR THE FOLLOWING REASONS</p>
<hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/>		

<p>ATTACHMENT</p> <p>F</p>	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<p>PROCESS CONTROL REVIEW WILL BE PERFORMED (PROVIDE COMPLETED COPY OF CHECK LIST AND CORRECTIVE ACTION REQUEST)</p> <p>PROCESS CONTROL REVIEW WILL BE PERFORMED WITH EXCEPTIONS NOTED</p> <p>PROCESS CONTROL REVIEW CANNOT BE PERFORMED FOR THE FOLLOWING REASONS</p>
<hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/>		

<p>INITIAL RESPONSE</p>	<hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/>
-------------------------	---

<p>_____ DCMA QAR Signature</p>	<p>____/____/____ Date</p>
---------------------------------	----------------------------



LEVEL I / SUBSAFE STOCK PROGRAM JUL 6 2000

**DCMA QAR ACKNOWLEDGEMENT
QUALITY ASSURANCE LETTER OF INSTRUCTION**

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____

PRIME CONTRACTOR IDENTIFICATION

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____

POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:

- MANUAL: REV _____ DATE ____ / ____ / ____

- LAST MANUAL REVIEW BY DCMC, QAR ____ / ____ / ____

N/A **SUBCONTRACTOR #1 IDENTIFICATION - PROVIDE COPY OF LETTER OF DELEGATION (LOD)**

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____

POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:

- MANUAL: REV _____ DATE ____ / ____ / ____

- LAST MANUAL REVIEW BY DCMC, QAR ____ / ____ / ____

N/A **SUBCONTRACTOR #2 IDENTIFICATION - PROVIDE COPY OF LETTER OF DELEGATION (LOD)**

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____

POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:

- MANUAL: REV _____ DATE ____ / ____ / ____

- LAST MANUAL REVIEW BY DCMC, QAR ____ / ____ / ____

JUL 6 2000



LEVEL I / SUBSAFE STOCK PROGRAM DCMA QAR ACKNOWLEDGEMENT QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____

IDENTIFICATION OF DCMA QAR FOR PRIME CONTRACTOR

(NAME)	(LINE 1 OF MAILING ADDRESS)
(RESIDENCY)	(LINE 2 OF MAILING ADDRESS)
(LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)	(CITY) (STATE) (ZIP CODE)
(LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)	(PHONE NUMBER) (FAX NUMBER)
(CITY) (STATE) (ZIP CODE)	(INTERNET ADDRESS)
	(PAGER NUMBER)

CERTIFICATION TRAINING

<input type="checkbox"/> U-20 Level I / SUBSAFE, NPM Workshop	Completed ___ / ___ / ___	In order to perform Quality Assurance on this contract,
<input type="checkbox"/> R-70 Material Certification Review Workshop	Completed ___ / ___ / ___	the DCMA QAR should have successfully, as a minimum,
<input type="checkbox"/> U-21 Navy Level I / SUBSAFE QAR Shipyard Training	Completed ___ / ___ / ___	completed the U-20 and R70 Workshop.
<input type="checkbox"/> L1 <input type="checkbox"/> L2 <input type="checkbox"/> L3 <input type="checkbox"/> L4 ISO-9000 Training	Completed ___ / ___ / ___	

N/A IDENTIFICATION OF DCMA QAR FOR SUBCONTRACTOR #1

(NAME)	(LINE 1 OF MAILING ADDRESS)
(RESIDENCY)	(LINE 2 OF MAILING ADDRESS)
(LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)	(CITY) (STATE) (ZIP CODE)
(LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)	(PHONE NUMBER) (FAX NUMBER)
(CITY) (STATE) (ZIP CODE)	(INTERNET ADDRESS)
	(PAGER NUMBER)

CERTIFICATION TRAINING

<input type="checkbox"/> U-20 Level I / SUBSAFE, NPM Workshop	Completed ___ / ___ / ___	In order to perform Quality Assurance on this contract,
<input type="checkbox"/> R-70 Material Certification Review Workshop	Completed ___ / ___ / ___	the DCMA QAR should have successfully, as a minimum,
<input type="checkbox"/> U-21 Navy Level I / SUBSAFE QAR Shipyard Training	Completed ___ / ___ / ___	completed the U-20 and R70 Workshop.
<input type="checkbox"/> L1 <input type="checkbox"/> L2 <input type="checkbox"/> L3 <input type="checkbox"/> L4 ISO-9000 Training	Completed ___ / ___ / ___	

N/A IDENTIFICATION OF DCMA QAR FOR SUBCONTRACTOR #2

(NAME)	(LINE 1 OF MAILING ADDRESS)
(RESIDENCY)	(LINE 2 OF MAILING ADDRESS)
(LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)	(CITY) (STATE) (ZIP CODE)
(LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)	(PHONE NUMBER) (FAX NUMBER)
(CITY) (STATE) (ZIP CODE)	(INTERNET ADDRESS)
	(PAGER NUMBER)

CERTIFICATION TRAINING

<input type="checkbox"/> U-20 Level I / SUBSAFE, NPM Workshop	Completed ___ / ___ / ___	In order to perform Quality Assurance on this contract,
<input type="checkbox"/> R-70 Material Certification Review Workshop	Completed ___ / ___ / ___	the DCMA QAR should have successfully, as a minimum,
<input type="checkbox"/> U-21 Navy Level I / SUBSAFE QAR Shipyard Training	Completed ___ / ___ / ___	completed the U-20 and R70 Workshop.
<input type="checkbox"/> L1 <input type="checkbox"/> L2 <input type="checkbox"/> L3 <input type="checkbox"/> L4 ISO-9000 Training	Completed ___ / ___ / ___	



LEVEL I / SUBSAFE STOCK PROGRAM

JUL 6 2000

**DCMA QAR ACKNOWLEDGEMENT
QUALITY ASSURANCE LETTER OF INSTRUCTION**

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____

QALI REQUIREMENT / FINAL SUBMISSION

ORIGINAL REQUEST / POINT OF CONTACT

The Defense Contract Management Agency (DCMA) Quality Assurance Representative (QAR) has been requested to increase surveillance of the Prime Contractor as identified by Attachments E and/or F. Please submit the appropriate attachment(s) along with the DD Form 250, Objective Quality Evidence (OQE) of inspection, and this attachment to the address below. If additional information or clarification is needed, please contact Alice M Worhach at the Naval Sea Logistics Center (N44). Her phone number is (717) 605-1896 or DSN (430). The office facsimile number is (717) 605-4750 and her internet address is "WorhachAM@NAVSEA.NAVY.MIL". The QAR of the Prime Contractor is responsible for collecting and forwarding all required documents from a subcontractor QAR(s) to whom a Letter of Delegation (LOD) was issued

Naval Sea Logistics Center (N44)
ATTN Alice M. Worhach
P.O. Box 2060
Mechanicsburg, PA 17055-0795

The Naval Sea Logistics Center has recommended _____ Type I - Inspection(s) by Attribute (Attachment E) and/or
increased surveillance of the Prime Contractor _____ Type II - Process Control Review (Attachment F)
by the following method(S):

FINAL DISPOSITION OF INSTRUCTION

- | | | |
|---------------------|--------------------------|--|
| ATTACHMENT

E | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS BEEN PERFORMED (PROVIDE COPY OF OBJECTIVE QUALITY EVIDENCE) |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS BEEN PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS NOT BEEN PERFORMED FOR THE FOLLOWING REASONS |

- | | | |
|---------------------|--------------------------|--|
| ATTACHMENT

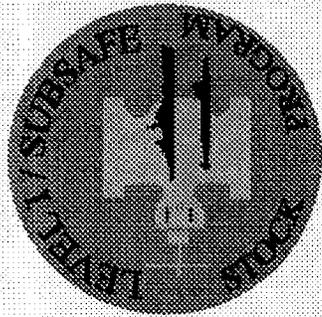
F | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS BEEN PERFORMED (PROVIDE COMPLETED COPY OF CHECK LIST AND CORRECTIVE ACTION REQUEST) |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS BEEN PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS NOT BEEN PERFORMED FOR THE FOLLOWING REASONS |

FINAL RESPONSE

_____ DCMA QAR Signature

_____/_____/_____
Date

JUL 6 2000



LEVEL I / SUBSAFE STOCK PROGRAM

DCMA QAR ACKNOWLEDGEMENT

QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 -

TYPE I - INCREASED SURVEILLANCE REQUEST - INSPECTION(S) BY ATTRIBUTE

CODE	TITLE	INSPECTION STATUS			
		REQUESTED	COMPLETED	DATE ACCOMPLISHED	
01	DOCUMENTATION	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
03	PACKAGING AND PACKING	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
04	VISUAL PRODUCT INSPECTION	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
05	MATERIAL IDENTIFICATION	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
06	MATERIAL VERIFICATION	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
07	RADIOGRAPHY	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
08	MAGNETIC PARTICLE TEST	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
09	ULTRASONIC TEST	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
10	LIQUID PENETRANT TEST	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
12	PRESSURE TEST	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
15	DIMENSIONS, ___ BALL / BALL VALVE ASSY	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	
19	FINISH	<input type="checkbox"/> Y <input type="checkbox"/> N	<input type="checkbox"/> Y <input type="checkbox"/> N	___ / ___ / ___	

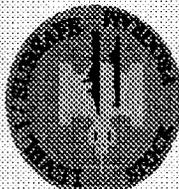
_____/_____/_____
 DCMA QAR Signature Date

LEVEL I / SUBSAFE STOCK PROGRAM JUL 6 2000

DCMA QAR ACKNOWLEDGEMENT
 QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 -

TYPE II - INCREASED SURVEILLANCE REQUEST - PROCESS CONTROL REVIEW



NO.	PROCESS CHECKLISTS TITLE	PERFORMING ACTIVITY		COMPLETED	DATE ACCOMPLISHED
		LAST REVIEW	PROCESS CONTROL REVIEW		
01	METALLURGICAL / CHEMICAL LABORATORY TESTING	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
02	HYDROSTATIC TESTING	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
03	NONDESTRUCTIVE TESTING:	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
03/1	- RADIOGRAPHY (RT)	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
03/2	- ULTRA SONIC (UT)	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
03/3	- MAGNETIC PARTICLE (MT)	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
03/4	- DYE PENETRANT (PT)	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
04	CALIBRATION	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
05	DIMENSIONAL CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
06	MATERIAL CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
07	DRAWING / CONFIGURATION MANAGEMENT CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
08	PAINTING AND SURFACE PREPARATION	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
09	SUPPLIER / SUBCONTRACTOR CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
10	FIRST ARTICLE TESTING (FAT)	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
11	RECEIVING INSPECTION	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
12	NONCONFORMING MATERIAL CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
13	COMPONENT / SYSTEM CLEANLINESS	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
14	TORQUE	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
15	OBJECTIVE QUALITY EVIDENCE	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
16	PACKAGING AND PRESERVATION	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
17	FINAL INSPECTION	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
18	ELECTRICAL TESTING	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
19	FLAME SPRAY	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
20	CONTRACT / PURCHASE ORDER CONTROL	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
21	INTERNAL QUALITY AUDITS	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
22	WELDING	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
22/1	- WELD PROCEDURES / WELD QUALIFICATION DATA	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
22/2	- WELDER QUALIFICATION / WELD WORKMANSHIP	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
23	HEAT TREATMENT	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
24	PLATING	/ /		<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
DATA AND PROCEDURE IS A CONTRACT DELIVERABLE FOR REVIEW / APPROVAL BY NAVAL SEA LOGISTICS CENTER					
				<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
				<input type="checkbox"/> Y <input type="checkbox"/> N	/ /
				<input type="checkbox"/> Y <input type="checkbox"/> N	/ /

DCMA QAR Signature _____ Date _____

NOTES:
 - REVIEW SHOULD NOT BE MORE THAN THREE YEARS OLD
 - REVIEW CHECKLIST(S) HAVE BEEN INCLUDED WITH THIS ATTACHMENT

JUL 6 2000

R. T. FILM PACKAGE CHECK LIST

TO BE FORWARDED TO PORTSMOUTH NAVAL SHIPYARD FOR R. T. OVERREAD

- NOTE:** (1) This check list is not intended to be a comprehensive list of contract or MIL-STD-271 requirements and does not alleviate DCMA responsibility for ensuring that the contract or MIL-STD-271 requirements are totally satisfied. It does provide DCMA with a check list for problem areas found in the past on R. T. films forwarded for overread inspection.
- (2) The DCMA Quality Assurance Representative (QAR) should place their initials in each block for each item after verifying that the requirement has been satisfied.
- (3) If an item is not applicable, so signify by using "N/A" in place of the check mark.

CONTRACT NUMBER N00104 - _____ - _____ - _____ - _____

ITEM	ITEM DESCRIPTION	CHECK
1.	CORRECT PENETRAMETER SIZE USED.	_____
2.	CORRECT PENETRAMETER MATERIAL USED.	_____
3.	PROPER SHIM MATERIAL AND THICKNESS USED.	_____
4.	CORRECT SOURCE-TO-FILM DISTANCE USED. THE DISTANCE IS DOCUMENTED ON THE READER SHEET. VERIFY ISOTOPE IN STOCK AND THE ISOTOPE USED IN SHOOTING FILM ARE THE SAME.	_____
5.	FILM DENSITY ON BLOCK IMAGE IS NOT GREATER THAN 15% OF THE DENSITY IN AREA OF INTEREST.	_____
6.	FILM DENSITY IS 1.5 TO 4.0 FOR SINGLE FILM VIEWING IN AREA(S) TO BE EXAMINED AND 2.0 TO 4.0 FOR DOUBLE FILM VIEWING IN AREA (S) TO BE EXAMINED.	_____
7.	RADIOGRAPHIC SHOOTING SKETCHES (RSSs) WERE PROVIDED WITH OVERREAD PACKAGE. THE RSSs ARE CLEAR, LEDGIBLE AND IDENTIFY THE GENERIC MATERIAL TYPE USED IN THE SELECTION OF MIL-STD-278 ACCEPTANCE CRITERIA.	_____
8.	SHOOTING SKETCH SPECIFIES WALL THICKNESS OF ITEM.	_____
9.	COMPLETE COVERAGE OF REPAIRED AREA (S).	_____
10.	ORIGINAL RADIOGRAPHS OF REPAIRED AREA(S) INCLUDED WITH OVERREAD PACKAGE (IF APPLICABLE)	_____
11.	VERIFY PENETRAMETER, SHIM AND/OR LOCATION NUMBER IS NOT PLACED IN WELD REPAIR AREA.	_____
12.	SKETCH (ES) SHOWING LOCATION (S), SIZE (S), SHAPE (S) OF REPAIRED AREA (S) INCLUDED WITH OVERREAD PACKAGE.	_____
13.	<u>ALL INDICATIONS, FILM PROCESSING DEFECTS AND ARTIFACTS HAVE BEEN DOCUMENTED ON RADIOGRAPHIC INSPECTION REPORT. USE OF A "CHINA MARKER" IS AUTHORIZED TO CORRELATE FILM INDICATIONS TO DISPOSITION IN THE INSPECTION REPORT.</u>	_____
14.	RADIOGRAPHIC INSPECTION REPORT HAS: A. DCMA QAR STAMP B. DCMA QAR R. T. CERTIFICATION NO. & DATE OF QUALIFICATION EXPIRATION. C. DCMA QAR SIGNATURE AND DATE.	_____

THE REQUIREMENTS OF ITEMS 1 THROUGH 14 HAVE BEEN ACCOMPLISHED, AS APPLICABLE, AND ARE SATISFACTORY:

DCMA SIGNATURE _____ DATE _____

15.	DD 250 PROVIDED WITH OVERREAD PACKAGE.	_____
16.	DD 250 BLOCK 16 PROVIDES: HEAT NUMBERS, R. T. NUMBERS, ITEM DESCRIPTION	_____

THE REQUIREMENTS OF ITEMS 15 AND 16 HAVE BEEN ACCOMPLISHED AND ARE SATISFACTORY:

DCMA SIGNATURE _____ DATE _____

COMPLETE AND FORWARD THIS CHECKLIST WITH THE FILM TO PORTSMOUTH NAVAL SHIPYARD.
ALSO FORWARD A COPY OF THIS CHECKLIST TO NAVSEALOGCEN.

JUL 6 2000



DEPARTMENT OF THE NAVY
 NAVAL SEA LOGISTICS CENTER
 5450 CARLISLE PIKE
 P O BOX 2060
 MECHANICSBURG PA 17055-0788

COM & FTS (717) 605-
 DSN 430 & EXT.
 FAX #
 IN REPLY REFER TO:
 4400
 Ser N44/

From: Commanding Officer, Naval Sea Logistics Center
 To: Supervisor of Shipbuilding, Newport News (Code 313D)

Subj: LEVEL I/SUBSAFE (LI/SS) SPECIAL INSPECTION REQUIREMENTS FOR
 CONTRACT N00104-00-_____ WITH (VENDOR)

Encl : (1) Quality Assurance Letter of Instruction (QALI)

1. Request enclosure (1) be implemented for the subject contract. Enclosure (1) is not intended to restrict you from performing other inspection requirements as may be required or appropriate.

2. Questions pertaining to enclosure (1) should be directed to the Naval Sea Logistics Center (NAVSEALOGCEN) N44, unless otherwise specified. If notified by the contractor that inspections and/or tests performed by you, as required by enclosure (1), may result in additional cost or delay in delivery, advise the contractor to contact the Procurement Contracting Officer (PCO) at the Naval Inventory Control Point (NAVICP).

3. Initial submission of Attachments (A), (B) and (C) of enclosure (1) shall be completed by you and returned within thirty (30) days from the date of this letter. A return envelope is provided for your convenience.

4. Final submission of Attachments (D), (E), (F) or (G) of enclosure (1) shall be completed by you and returned within thirty (30) days from the date that the DD Form 250 has been signed. Please provide a copy of the DD Form 250 along with the objective quality evidence. You are responsible for collecting and forwarding all required documents from a subcontractor Defense Contract Management Agency (DCMA) Quality Assurance Representative (QAR(S)) to whom a letter of delegation was issued.

5. Authority for approval of nonconforming supplies by SUPSHIP is restricted and specifically addressed in the subject contract.

Enclosure (3)

JUL 6 2000

Subj: LEVEL 1/SUBSAFE (LI/SS) SPECIAL INSPECTION REQUIREMENTS FOR
CONTRACT N00104-00-_____ WITH (VENDOR)

6. In accordance with SUPSHIP Operating Manual, S0300-B2-MAN-010, you are requested at the time of each shipment, to forward copies of all supporting documentation associated with material release and the attached QALI to:

Naval Sea Logistics Center (N44)
ATTN: Alice M. Worchach
PO Box 2060
Mechanicsburg, PA 17055-0795

7. As identified by Attachment (A) and (D) of enclosure (1), increased surveillance of the contractor is being requested. The prime contractor may have previously experienced a problem in the delivery of requisite material to the LI/SS Stock Program and/or the contractor's processes to satisfy the quality assurance provisions of this contract requires a documented review. If a process review has been completed within the last three years, please provide the Objective Quality Evidence (OQE) of such review to update our records. The following method(s) of increased surveillance has been specified for the attached QALI, as indicated by the marking of a "X" below.

Type I – Inspection (Attachment E of enclosure (1) applies)

Type II – Process Control Review (Attachment F of enclosure (1) applies)

8. As a reminder, submission of waivers and deviations should be submitted to the Procurement Contracting Officer via the NAVICP, Mechanicsburg web site at <http://www.navicp.navy.mil/84/download.htm>. Process Control Checklists are available for printing via Naval Sea Logistics Center, Detachment Portsmouth web site at <http://www.nslcptsmh.navsea.navy.mil/supplier/supplier.htm#par>.

9. Our point of contact for this matter is Alice M. Worchach, NAVSEALOGCEN N44, DSN 430-1896 or Commercial (717) 605-1896. Her Email address is "WorchachAM@NAVSEA.NAVY.MIL". The facsimile (FAX) number for our office is (717) 605-4750.

E. E. MARTIN, III, P.E.
By direction

Copy to:
COMNAVSEASYS COM (SEA 04XQ)
NAVICP (Codes 02522.03)

JUL 6 2000

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI)

Ref: (a) NAVSEA P-3683 Navy and Marine Corp Product Data Reporting and Evaluation Program (PDREP) Manual

A. Purpose:

1. The Contractor may have previously experienced a problem in the delivery of requisite material to the Level I/SUBSAFE (LI/SS) Stock Program or the contractor's processes that would be used to satisfy the quality assurance provisions of this contract requires a documented review.

2. Naval Sea Logistics Center (NAVSEALOGCEN) has evaluated the performance data and requests increased surveillance along with supporting documentation to either preclude recurrence or update of a documented review for the following:

Contract Number: N00104 - 00 - _____

Prime Contractor: (VENDOR)

Procurement Contracting Officer (PCO):

Naval Inventory Control Point (Code 0243.)

ATTN:

P O Box 2020

Mechanicsburg, PA 17055-0788

Phone: (717) 605-

B. General Instructions :

1. This QALI supplements the quality assurance provisions issued for the subject contract.

2. Unless a 100 percent inspection is indicated for a characteristic, sample inspect in accordance with the subject contract.

C. **Definitions :** The words listed below are used throughout this QALI and are defined as follows:

1. ***Perform*** - physically accomplish test(s) and/or inspection(s).

2. ***Witness Complete*** - observe the supplier's performance of all steps of the test, inspection, or other operation to ensure that the requirements of the contract are met including verification during the initial observation that an approved procedure, where required, is used.

JUL 6 2000 **QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI)** (continued)

3. **Witness** - observe the test, inspection or other operation, when it is performed by the supplier, to the extent necessary to ensure that requirements are met, including initial observation that an approved procedure where required, is used.
4. **Verify** - review completely contractor's documented evidence of test(s) and/or inspection(s).
5. **Objective Quality Evidence (OQE)** - quantitative and qualitative data of all mechanical, chemical, and performance tests performed (as required by the applicable specification, drawing, or other provisions of the contract) to prove that the material supplied conforms to the specified requirements.

D. **Specific Instructions** :

1. It is requested that the following requirements be satisfied by the Administrative Contracting Officer (ACO), Supervisor of Shipbuilding (SUPSHIP) Quality Assurance Specialist (QAS), servicing the Prime Contractor.
2. Performance of inspection shall be documented as the inspections are performed. The supporting documentation provided by the SUPSHIP QAS is separate from the documentation maintained by the contractor. The documentation should include, as a minimum, the following information:
 - a. The type of inspection performed (nomenclature, i.e. visual, dimensional, etc.)
 - b. Contract/purchase order number
 - c. Description of the component(s)
 - d. Part number and revision number
 - e. Heat or lot number, manufacturer's serial number or contract line item number and contract number of the component(s)
 - f. Date of inspection
 - g. Contractor's procedure used
 - h. Number of items inspected, accepted, rejected and the sample size used (if reject, refer to the corrective action request number)
 - i. Name of individual performing the inspection (first initial and last name or unique individual code)
3. The inspection characteristics listed below shall be identified on the inspection record using the appropriate Inspection Attribute Code.

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

4. Since only certain inspection characteristics from Chapter 3, pages 63-65 of reference (a) will apply to this contract, the numerical sequence may be discontinuous.

5. Due to the critical program requirements, the SUPSHIP QAS must maintain the documentation of completed inspections for a minimum period of two years after the sign-off date on the DD Form 250, unless a greater time period is specified by another specification or document. It is highly recommended that the SUPSHIP QAS establish a procedure to prevent water and/or fire damage of records.

6. Inspection records need to be maintained either in the form of handwritten (in ink) records or a computer-based record system. When the option to use a computer-based record system is elected, provisions for periodic back-up of all records must be implemented. Changes to computer systems, software, or macro routines normally result in the loss of usefulness of computer-based information. As such, it is highly recommended that Microsoft Office products be the software standard. SUPSHIP shall assure that records are retrievable and available upon request.

E. **Inspection Attributes and Codes:** One or more of the following inspection attributes may be specified for this QALI. This paragraph provides amplification of a Type I request for increased surveillance. The specific attributes applicable to this QALI are highlighted in gray and identified on Attachment E as follows:

1. **Documentation** (Attribute Code 01) - For each inspection lot, the SUPSHIP QAS shall **verify** that the documentation required by the Contract Data Requirements List (CDRL), is complete in quantity and content, is legible and signed by an appropriate representative, is directly traceable to the material and is included with the shipment. Also, forward one copy of all documentation is to be forwarded to the PCO.

2. **Packaging and Packing** (Attribute Code 03) - The SUPSHIP QAS shall **witness** that the packaging and packing is in accordance with the subject contract.

3. **Visual Product Inspection** (Attribute Code 04) - For each inspection lot, the SUPSHIP QAS shall **perform** a visual inspection for good workmanship ensuring that the inner and outer surfaces of the item are free of dirt, chips, scale and foreign substances and that there are no dents, cracks, gouges or tool marks, which may restrict the flow or violate minimum wall thickness.

4. **Material Identification** (Attribute Code 05) - For each inspection lot, the SUPSHIP QAS shall **perform** an inspection to ensure all markings (100%) are clearly and legibly marked on the material and are directly traceable to the certification provided in accordance with the quality assurance provisions of the subject contract and the requirements of Data Item Description of DI-MISC-81020.

JUL 6 2000 **QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI)** (continued)

5. **Material Verification** (Attribute Code 06) - For each inspection lot, the SUPSHIP QAS shall **verify** that quantitative chemical and mechanical analyses are traceable to heat, lot, or batch identification and in accordance with the quality assurance provisions of the subject contract and meet the requirements of Data Item Description of DI-MISC-81020.

6. **Radiography** (Attribute Code 07) - For each item (100%), the SUPSHIP QAS shall **perform** inspection on all radiographs and shooting sketches for quality and conformance. The radiography test procedure will receive a documented review to ensure that the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the quality assurance provisions of the subject contract. Acceptance criteria for castings will be to criticality Level I per Table XVIII, XIX, or XX, as applicable, of MIL-STD-278. Acceptance criteria for weldments will be per Table XI of MIL-STD-278 (P-1 piping) or MIL-STD-2035, class 1, as applicable. In performing the above inspection, the SUPSHIP QAS shall:

- a. Ensure that radiography is inspected and accepted by a qualified QAS in accordance with SUPSHIP Operating Manual, S0300-B2-MAN-010.
- b. Complete Attachment G, the RT Check List, and forward with the film to:

Portsmouth Naval Shipyard
ATTN: Code 136.2
Portsmouth, NH 03804-5000

Also, send a copy of the completed RT Check List to:

Naval Sea Logistics Center N44
ATTN:
P O Box 2060
Mechanicsburg, PA 17055-0795

- c. The DD 250 and RT Certification(s) shall be completed in accordance with SUPSHIP Operating Manual, S0300-B2-MAN-010.

7. **Magnetic Particle Test** (Attribute Code 08) - For each item (100%), the SUPSHIP QAS shall **verify** the magnetic particle test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

8. **Ultrasonic Test** (Attribute Code 09) - For each item (100%), the SUPSHIP QAS shall **verify** the ultrasonic test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

9. Liquid Penetrant Test (Attribute Code 10) - For each item (100%), the SUPSHIP QAS shall **verify** the liquid penetrant test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

10. Pressure Test (Attribute Code 12) - For each item (100%), the SUPSHIP QAS shall **witness complete** the performance of the test and verify the results of the test. The test procedure will receive a documented review to ensure the contractor's NDT Level III Examiner has approved the procedures and satisfies the requirements of MIL-STD-271 and the provisions of the contract.

11. Dimensions (Attribute Code 15) - For each item (100%), the SUPSHIP QAS shall **witness** the dimensional inspection in accordance with the tolerance of the applicable specification, drawing, or other provisions of the contract. In the case of balls or ball assemblies for ball valves, the following dimensional characteristics are highlighted:

- _____ a. Dimensions of ball(s) outside diameter, and finish
 - _____ b. Location and size of the ball bore and of the ball stem slot
 - _____ c. Single seat height over the ball in accordance with the specification
 - _____ d. Dimensions from seat retainer plug mating surface of body to centerline of stem cavity and back seat surface in body
 - _____ e. Dimension from seat retainer plug mating face surface to back seat surface on end of plug
 - _____ h. Dimensions from tailpiece bolting face surface to back seat surface
 - _____ i. When air bleed holes are required by the referenced drawing, ensure appropriate air bleed holes are in their proper location
 - _____ j. Other dimensions: _____
-

12. Finish (Attribute Code 19) - For each (100%) item, the SUPSHIP QAS shall **perform** inspection of surface finish, grade, type and coverage in accordance with the subject contract.

F. **Attachments** : The following attachments invoke the specific requirements of this QALI and identify the necessary reporting information to monitor the successful completion of this QALI.

JIII 6 2000 QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued)

1. Attachments A & D to this enclosure are the front pages of the SUPSHIP QAS Acknowledgement and identifies the specific method of surveillance to be accomplished by the SUPSHIP QAS for the subject contract. The method of increased surveillance includes inspections and/or process control reviews, identified as Type I and II of this QALI, respectively. Submission of Attachment A is required for the initial disposition and Attachment D is required for the final disposition of this QALI. OQE (inspection records) must be provided to NAVSEALOGCEN N44 with the final disposition and shall include a signed copy of the DD 250.

2. Attachment B to this enclosure requests pertinent information for the identity of the prime contractor and subcontractors performing work on the subject contract. If applicable, a copy of the letter of delegation for subcontractors is requested. Attachment B also requests the identification of the contractor's inspection system documentation. Submission of Attachment B is required at the time of initial disposition of this QALI. Please notify NAVSEALOGCEN N44, if any changes occur during the processing of the subject contract.

3. Attachment C to this enclosure requests pertinent information for the identity of the SUPSHIP QAS for the prime contractor and all DCMA QARs at the subcontractors' locations performing work on the subject contract. Submission of Attachment C is required at the time of initial disposition of this QALI. Again, please notify NAVSEALOGCEN N44 if any changes occur during the processing of the subject contract.

4. Attachment E to this enclosure specifically identifies by attribute the inspection(s) to be accomplished during the processing of the subject contract. Amplification of the inspection requirements has been provided within the previous paragraph E, "Inspection Attributes and Codes". It is considered a Type I method of increased surveillance of the prime contractor. If a Type I surveillance method is specified by the QALI, one submission of Attachment E along with the OQE (inspection record) is required at the time of final disposition of the contract to NAVSEALOGCEN N44.

5. Attachment F to this enclosure requests a comprehensive review of the contractor's and/or subcontractor's process(es). This review may be accomplished during a joint (SUPSHIP/NAVICP/NAVSEALOGCEN) Pre-Award or Post-Award Survey, provided the survey is recommended by the PCO. In all other cases, the SUPSHIP QAS is requested to accomplish the review. A process control check list is provided for each process identified. Completing and submitting the check list satisfies the requirement for the OQE. This review should be performed prior to the commencement of work on the subject contract. All corrective action(s) needed to resolve a deficiency is to be reported. A Corrective Action Request (CAR) form is provided for this purpose. If a Type II surveillance method is specified by the QALI, one submission of Attachment F along with the completed process control check list and any resulting CAR is required at the time of final disposition of the contract to

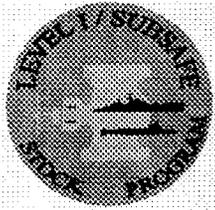
QUALITY ASSURANCE LETTER OF INSTRUCTION (QALI) (continued) JUL 6 2000

NAVSEALOGCEN N44. Please notify NAVSEALOGCEN N44 when corrective action has been accomplished.

6. Attachment G to this enclosure is the Radiographic Film Package Check List and is provided as an aid for processing radiographic film for the Overread Inspection required by the Level I/SUBSAFE Program. When radiography is invoked in the contract, one submission of Attachment G is required to be provided to Portsmouth Naval Shipyard for the Overread Inspection and one submission of Attachment G is required at final disposition to NAVSEALOGCEN N44.

YOUR QALI CHECKLIST		
INITIAL SUBMISSION		
<input type="checkbox"/>	ATTACHMENT "A" (FRONT PAGE)	ACKNOWLEDGEMENT
<input type="checkbox"/>	ATTACHMENT "B"	
<input type="checkbox"/>	ATTACHMENT "C"	
<input type="checkbox"/>	COPY OF LETTERS OF DELEGATION (LODs)	
FINAL SUBMISSION		
<input type="checkbox"/>	ATTACHMENT "D" (FRONT PAGE)	ACKNOWLEDGEMENT
<input type="checkbox"/>	COPY OF DD FORM 250	
<input type="checkbox"/>	ATTACHMENT "E" ALONG WITH	TYPE I SURVEILLANCE ONLY
<input type="checkbox"/>	- OBJECTIVE QUALITY EVIDENCE	
<input type="checkbox"/>	ATTACHMENT "F" ALONG WITH	TYPE II SURVEILLANCE ONLY
<input type="checkbox"/>	- COMPLETED PROCESS CONTROL CHECKLIST	
<input type="checkbox"/>	- CORRECTIVE ACTION REQUESTS (CAR)	
<input type="checkbox"/>	ATTACHMENT "G"	RADIOGRAPHY ONLY

JUL 6 2000



LEVEL I / SUBSAFE STOCK PROGRAM

SUPSHIP QAS ACKNOWLEDGEMENT

QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____

DELIVERY ORDER _____ CLIN _____

QALI REQUIREMENT / INITIAL SUBMISSION

ORIGINAL REQUEST / POINT OF CONTACT

The Supervisor of Shipbuilding, Quality Assurance Specialist (QAS) is requested to identify the information in Attachments B and C along with this Attachment and return the same to the address below. If additional information or clarification is needed, please contact Alice M. Worhach at the Naval Sea Logistics Center (N44). Her phone number is (717) 605-1896 or DSN (430). The office facsimile number is (717) 605-4750 and her internet address is "WorhachAM@NAVSEA.NAVY.MIL". The QAS of the Prime Contractor is responsible for collecting and forwarding all required documents from a subcontractor Defense Contract Management Agency, Quality Assurance Representative(s) to whom a Letter of Delegation (LOD) was issued

Naval Sea Logistics Center (N44)
 ATTN Alice M. Worhach
 P.O. Box 2060
 Mechanicsburg, PA 17055-0795

The Naval Sea Logistics Center is recommending _____ Type I - Inspection(s) by Attribute (Attachment E) and/or
 increased surveillance of the Prime Contractor _____ Type II - Process Control Review (Attachment F)
 by the following method(S):

PLANNED DISPOSITION OF INSTRUCTION

- | | | |
|---------------------|--------------------------|---|
| ATTACHMENT

E | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE WILL BE PERFORMED (PROVIDE COPY OF OBJECTIVE QUALITY EVIDENCE) |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE WILL BE PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE CANNOT BE PERFORMED FOR THE FOLLOWING REASONS |

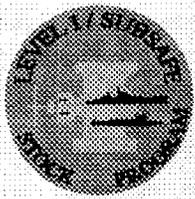
- | | | |
|---------------------|--------------------------|---|
| ATTACHMENT

F | <input type="checkbox"/> | PROCESS CONTROL REVIEW WILL BE PERFORMED (PROVIDE COMPLETED COPY OF CHECK LIST AND CORRECTIVE ACTION REQUEST) |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW WILL BE PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW CANNOT BE PERFORMED FOR THE FOLLOWING REASONS |

INITIAL RESPONSE

 SUPSHIP QAS Signature

_____/_____/_____
 Date



LEVEL I / SUBSAFE STOCK PROGRAM JUL 6 2000

SUPSHIP QAS ACKNOWLEDGEMENT

QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____
DELIVERY ORDER _____ CLIN _____

PRIME CONTRACTOR IDENTIFICATION

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____
POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:
- MANUAL: REV _____ DATE ____ / ____ / ____
- LAST MANUAL REVIEW BY SUPSHIP QAS ____ / ____ / ____

N/A SUBCONTRACTOR #1 IDENTIFICATION - PROVIDE COPY OF LETTER OF DELEGATION (LOD)

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____
POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:
- MANUAL: REV _____ DATE ____ / ____ / ____
- LAST MANUAL REVIEW BY PRIME ____ / ____ / ____

N/A SUBCONTRACTOR #2 IDENTIFICATION - PROVIDE COPY OF LETTER OF DELEGATION (LOD)

(NAME)

(LINE 1 OF PHYSICAL ADDRESS)

(LINE 2 OF PHYSICAL ADDRESS)

(CITY) (STATE) (ZIP CODE)

(LINE 1 OF MAILING ADDRESS)

(LINE 2 OF MAILING ADDRESS)

(CITY) (STATE) (ZIP CODE)

CAGE: _____
POC: _____
(NAME)

(TITLE)

(PHONE NUMBER) (FAX NUMBER)

(INTERNET ADDRESS)

INSPECTION SYSTEM DOCUMENTATION:
- MANUAL: REV _____ DATE ____ / ____ / ____
- LAST MANUAL REVIEW BY PRIME ____ / ____ / ____

JUL 6 2000



**LEVEL I / SUBSAFE STOCK PROGRAM
SUPSHIP QAS ACKNOWLEDGEMENT
QUALITY ASSURANCE LETTER OF INSTRUCTION**

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____
 DELIVERY ORDER _____ CLIN _____

IDENTIFICATION OF SUPSHIP QAS FOR PRIME CONTRACTOR

_____ (NAME)		_____ (LINE 1 OF MAILING ADDRESS)	
_____ (ACTIVITY)	_____ (CODE)	_____ (LINE 2 OF MAILING ADDRESS)	
_____ (LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (CITY)	_____ (STATE) (ZIP CODE)
_____ (LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (PHONE NUMBER)	_____ (FAX NUMBER)
_____ (CITY)	_____ (STATE) (ZIP CODE)	_____ (INTERNET ADDRESS)	
_____ (PAGER NUMBER)			

N/A **IDENTIFICATION OF DCMA QAR FOR SUBCONTRACTOR #1**

_____ (NAME)		_____ (LINE 1 OF MAILING ADDRESS)	
_____ (RESIDENCY)		_____ (LINE 2 OF MAILING ADDRESS)	
_____ (LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (CITY)	_____ (STATE) (ZIP CODE)
_____ (LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (PHONE NUMBER)	_____ (FAX NUMBER)
_____ (CITY)	_____ (STATE) (ZIP CODE)	_____ (INTERNET ADDRESS)	
_____ (PAGER NUMBER)			

CERTIFICATION TRAINING

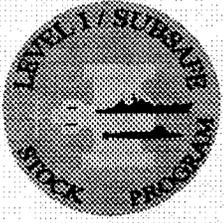
- | | | |
|---|---------------------------|---|
| <input type="checkbox"/> U-20 Level I / SUBSAFE, NPM Workshop | Completed ___ / ___ / ___ | In order to perform Quality Assurance on this contract, the DCMA QAR should have successfully, as a minimum, completed the U-20 and R70 Workshop. |
| <input type="checkbox"/> R-70 Material Certification Review Workshop | Completed ___ / ___ / ___ | |
| <input type="checkbox"/> U-21 Navy Level I / SUBSAFE QAR Shipyard Training | Completed ___ / ___ / ___ | |
| <input checked="" type="checkbox"/> L1 <input checked="" type="checkbox"/> L2 <input checked="" type="checkbox"/> L3 <input checked="" type="checkbox"/> L4 ISO-9000 Training | Completed ___ / ___ / ___ | |

N/A **IDENTIFICATION OF DCMA QAR FOR SUBCONTRACTOR #2**

_____ (NAME)		_____ (LINE 1 OF MAILING ADDRESS)	
_____ (RESIDENCY)		_____ (LINE 2 OF MAILING ADDRESS)	
_____ (LINE 1 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (CITY)	_____ (STATE) (ZIP CODE)
_____ (LINE 2 OF PHYSICAL ADDRESS OF RESIDENCY)		_____ (PHONE NUMBER)	_____ (FAX NUMBER)
_____ (CITY)	_____ (STATE) (ZIP CODE)	_____ (INTERNET ADDRESS)	
_____ (PAGER NUMBER)			

CERTIFICATION TRAINING

- | | | |
|---|---------------------------|---|
| <input type="checkbox"/> U-20 Level I / SUBSAFE, NPM Workshop | Completed ___ / ___ / ___ | In order to perform Quality Assurance on this contract, the DCMA QAR should have successfully, as a minimum, completed the U-20 and R70 Workshop. |
| <input type="checkbox"/> R-70 Material Certification Review Workshop | Completed ___ / ___ / ___ | |
| <input type="checkbox"/> U-21 Navy Level I / SUBSAFE QAR Shipyard Training | Completed ___ / ___ / ___ | |
| <input checked="" type="checkbox"/> L1 <input checked="" type="checkbox"/> L2 <input checked="" type="checkbox"/> L3 <input checked="" type="checkbox"/> L4 ISO-9000 Training | Completed ___ / ___ / ___ | |



LEVEL I / SUBSAFE STOCK PROGRAM

JUL 6 2000

**SUPSHIP QAS ACKNOWLEDGEMENT
QUALITY ASSURANCE LETTER OF INSTRUCTION**

NAVICP CONTRACT NUMBER: N00104 - _____ - _____ - _____

DELIVERY ORDER _____ CLIN _____

QALI REQUIREMENT / FINAL SUBMISSION

ORIGINAL REQUEST / POINT OF CONTACT

The Supervisor of Shipbuilding, Quality Assurance Specialist (QAS) has been requested to increase surveillance of the Prime Contractor as identified by Attachments E and/or F. Please submit the appropriate attachment(s) along with the DD Form 250, Objective Quality Evidence (OQE) of inspection and this attachment to the address below. If additional information or clarification is needed, please contact Alice M Worhach at the Naval Sea Logistics Center (N44). Her phone number is (717) 605-1896 or DSN (430). The office facsimile number is (717) 805-4750 and her internet address is "WorhachAM@NAVSEA.NAVY.MIL". The QAS of the Prime Contractor is responsible for collecting and forwarding all required documents from a subcontractor Defense Contract Management Agency, Quality Assurance Representative(s) to whom a Letter of Delegation (LOD) was issued

Naval Sea Logistics Center (N44)
ATTN Alice M. Worhach
P.O. Box 2060
Mechanicsburg, PA 17055-0795

The Naval Sea Logistics Center has recommended _____ Type I - Inspection(s) by Attribute (Attachment E) and/or
increased surveillance of the Prime Contractor _____ Type II - Process Control Review (Attachment F)
by the following method(S):

FINAL DISPOSITION OF INSTRUCTION

- | | | |
|---------------------|--------------------------|--|
| ATTACHMENT

E | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS BEEN PERFORMED (PROVIDE COPY OF OBJECTIVE QUALITY EVIDENCE) |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS BEEN PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | INSPECTION(S) BY ATTRIBUTE HAS NOT BEEN PERFORMED FOR THE FOLLOWING REASONS |

- | | | |
|---------------------|--------------------------|--|
| ATTACHMENT

F | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS BEEN PERFORMED (PROVIDE COMPLETED COPY OF CHECK LIST AND CORRECTIVE ACTION REQUEST) |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS BEEN PERFORMED WITH EXCEPTIONS NOTED |
| | <input type="checkbox"/> | PROCESS CONTROL REVIEW HAS NOT BEEN PERFORMED FOR THE FOLLOWING REASONS |

FINAL RESPONSE

SUPSHIP QAS Signature

_____/_____/_____
Date

JUL 6 2000



LEVEL I / SUBSAFE STOCK PROGRAM

SUPSHIP QAS ACKNOWLEDGEMENT QUALITY ASSURANCE LETTER OF INSTRUCTION

NAVICP CONTRACT NUMBER: N00104 - _____

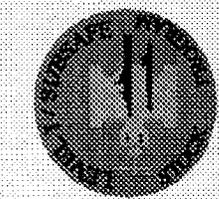
DELIVERY ORDER _____ CLIN _____

TYPE I - INCREASED SURVEILLANCE REQUEST - INSPECTION(S) BY ATTRIBUTE

CODE	TITLE	REQUESTED		INSPECTION STATUS		DATE ACCOMPLISHED
		Y	N	COMPLETED		
01	DOCUMENTATION	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
03	PACKAGING AND PACKING	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
04	VISUAL PRODUCT INSPECTION	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
05	MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
06	MATERIAL VERIFICATION	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
07	RADIOGRAPHY	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
08	MAGNETIC PARTICLE TEST	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
09	ULTRASONIC TEST	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
10	LIQUID PENETRANT TEST	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
12	PRESSURE TEST	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
15	DIMENSIONS, _____ BALL / BALL VALVE ASSY	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___
19	FINISH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	___/___/___

_____/_____/_____
SUPSHIP QAS Signature Date

LEVEL I / SUBSAFE STOCK PROGRAM
SUPSHIP QAS ACKNOWLEDGEMENT
QUALITY ASSURANCE LETTER OF INSTRUCTION
 NAVICP CONTRACT NUMBER: N00104 - _____
 DELIVERY ORDER _____ CLIN _____



JUL 6 2000

TYPE II - INCREASED SURVEILLANCE REQUEST - PROCESS CONTROL REVIEW

PROCESS CHECKLISTS		PROCESS CONTROL REVIEW		PROCESS CONTROL REVIEW		PROCESS CONTROL REVIEW	
NO.	TITLE	LAST REVIEW	PERFORMING ACTIVITY	REQUESTED	COMPLETED	DATE ACCOMPLISHED	
01	METALLURGICAL / CHEMICAL LABORATORY TESTING	/ /		Y	N	/ /	
02	HYDROSTATIC TESTING	/ /		Y	N	/ /	
03	NONDESTRUCTIVE TESTING:	/ /					
03/1	- RADIOGRAPHY (RT)	/ /		Y	N	/ /	
03/2	- ULTRA SONIC (UT)	/ /		Y	N	/ /	
03/3	- MAGNETIC PARTICLE (MT)	/ /		Y	N	/ /	
03/4	- DYE PENETRANT (PT)	/ /		Y	N	/ /	
04	CALIBRATION	/ /		Y	N	/ /	
05	DIMENSIONAL CONTROL	/ /		Y	N	/ /	
06	MATERIAL CONTROL	/ /		Y	N	/ /	
07	DRAWING / CONFIGURATION MANAGEMENT CONTROL	/ /		Y	N	/ /	
08	PAINTING AND SURFACE PREPARATION	/ /		Y	N	/ /	
09	SUPPLIER / SUBCONTRACTOR CONTROL	/ /		Y	N	/ /	
10	FIRST ARTICLE TESTING (FAT)	/ /		Y	N	/ /	
11	RECEIVING INSPECTION	/ /		Y	N	/ /	
12	NONCONFORMING MATERIAL CONTROL	/ /		Y	N	/ /	
13	COMPONENT / SYSTEM CLEANLINESS	/ /		Y	N	/ /	
14	TORQUE	/ /		Y	N	/ /	
15	OBJECTIVE QUALITY EVIDENCE	/ /		Y	N	/ /	
16	PACKAGING AND PRESERVATION	/ /		Y	N	/ /	
17	FINAL INSPECTION	/ /		Y	N	/ /	
18	ELECTRICAL TESTING	/ /		Y	N	/ /	
19	FLAME SPRAY	/ /		Y	N	/ /	
20	CONTRACT / PURCHASE ORDER CONTROL	/ /		Y	N	/ /	
21	INTERNAL QUALITY AUDITS	/ /		Y	N	/ /	
22	WELDING	/ /		Y	N	/ /	
22/1	- WELD PROCEDURES / WELD QUALIFICATION DATA	/ /		Y	N	/ /	
22/2	- WELDER QUALIFICATION / WELD WORKMANSHIP	/ /		Y	N	/ /	
23	HEAT TREATMENT	/ /		Y	N	/ /	
24	PLATING	/ /		Y	N	/ /	
DATA AND PROCEDURE IS A CONTRACT DELIVERABLE FOR REVIEW / APPROVAL BY NAVAL SEA LOGISTICS CENTER							
			SUPSHIP QAS Signature		Date		

NOTES:

- REVIEW SHOULD NOT BE MORE THAN THREE YEARS OLD
- REVIEW CHECKLIST(S) HAVE BEEN INCLUDED WITH THIS ATTACHMENT

JUN 6 2000

R. T. FILM PACKAGE CHECK LIST

TO BE FORWARDED TO PORTSMOUTH NAVAL SHIPYARD FOR R. T. OVERREAD

- NOTE:** (1) This check list is not intended to be a comprehensive list of contract or MIL-STD-271 requirements and does not alleviate SUPSHIP responsibility for ensuring that the contract or MIL-STD-271 requirements are totally satisfied. It does provide SUPSHIP with a check list for problem areas found in the past on R. T. films forwarded for overread inspection.
- (2) The SUPSHIP Quality Assurance Specialist (QAS) should place their initials in each block for each item after verifying that the requirement has been satisfied.
- (3) If an item is not applicable, so signify by using "N/A" in place of the check mark.

CONTRACT NUMBER N00104 - _____ - _____ - _____ - _____

DELIVERY ORDER _____ CLIN _____

ITEM	ITEM DESCRIPTION	CHECK
1.	CORRECT PENETRAMETER SIZE USED.	_____
2.	CORRECT PENETRAMETER MATERIAL USED.	_____
3.	PROPER SHIM MATERIAL AND THICKNESS USED.	_____
4.	CORRECT SOURCE-TO-FILM DISTANCE USED. THE DISTANCE IS DOCUMENTED ON THE READER SHEET. VERIFY ISOTOPE IN STOCK AND THE ISOTOPE USED IN SHOOTING FILM ARE THE SAME.	_____
5.	FILM DENSITY ON BLOCK IMAGE IS NOT GREATER THAN 15% OF THE DENSITY IN AREA OF INTEREST.	_____
6.	FILM DENSITY IS 1.5 TO 4.0 FOR SINGLE FILM VIEWING IN AREA(S) TO BE EXAMINED AND 2.0 TO 4.0 FOR DOUBLE FILM VIEWING IN AREA (S) TO BE EXAMINED.	_____
7.	RADIOGRAPHIC SHOOTING SKETCHES (RSSs) WERE PROVIDED WITH OVERREAD PACKAGE. THE RSSs ARE CLEAR, LEDGIBLE AND IDENTIFY THE GENERIC MATERIAL TYPE USED IN THE SELECTION OF MIL-STD-278 ACCEPTANCE CRITERIA.	_____
8.	SHOOTING SKETCH SPECIFIES WALL THICKNESS OF ITEM.	_____
9.	COMPLETE COVERAGE OF REPAIRED AREA (S).	_____
10.	ORIGINAL RADIOGRAPHS OF REPAIRED AREA(S) INCLUDED WITH OVERREAD PACKAGE (IF APPLICABLE)	_____
11.	VERIFY PENETRAMETER, SHIM AND/OR LOCATION NUMBER IS NOT PLACED IN WELD REPAIR AREA.	_____
12.	SKETCH (ES) SHOWING LOCATION (S), SIZE (S), SHAPE (S) OF REPAIRED AREA (S) INCLUDED WITH OVERREAD PACKAGE.	_____
13.	<u>ALL INDICATIONS, FILM PROCESSING DEFECTS AND ARTIFACTS HAVE BEEN DOCUMENTED ON RADIOGRAPHIC INSPECTION REPORT. USE OF A "CHINA MARKER" IS AUTHORIZED TO CORRELATE FILM INDICATIONS TO DISPOSITION IN THE INSPECTION REPORT.</u>	_____
14.	RADIOGRAPHIC INSPECTION REPORT HAS: A. SUPSHIP QAS STAMP B. SUPSHIP QAS R. T. CERTIFICATION NO. & DATE OF QUALIFICATION EXPIRATION. C. SUPSHIP QAS SIGNATURE AND DATE.	_____

THE REQUIREMENTS OF ITEMS 1 THROUGH 14 HAVE BEEN ACCOMPLISHED, AS APPLICABLE, AND ARE SATISFACTORY:

SUPSHIP SIGNATURE _____ DATE _____

15.	DD 250 PROVIDED WITH OVERREAD PACKAGE.	_____
16.	DD 250 BLOCK 16 PROVIDES: HEAT NUMBERS, R. T. NUMBERS, ITEM DESCRIPTION	_____

THE REQUIREMENTS OF ITEMS 15 AND 16 HAVE BEEN ACCOMPLISHED AND ARE SATISFACTORY:

SUPSHIP SIGNATURE _____ DATE _____

COMPLETE AND FORWARD THIS CHECKLIST WITH THE FILM TO PORTSMOUTH NAVAL SHIPYARD.
ALSO FORWARD A COPY OF THIS CHECKLIST TO NAVSEALOGCEN.

ENCLOSURE (1) - ATTACHMENT G