

P-205 Rev A Additional Inspection Services Requirements

These requirements are *in addition to* all other requirements in purchase orders to machined part suppliers.

Documentation

For each lot of inspected parts, the following documentation shall be emailed or, if posted, placed in one, 9" x 12" envelope:

- The completed CED Quality Assurance Record (QAR). If parts from more than one lot are used to satisfy an order, separate QAR's must be completed for each lot supplied.

Note: It is not necessary to pull separate samples from the whole lot for each AQL sample size. First, randomly select the maximum number of samples required by the Sample Size table below for the lot size, and then select the required samples for each check from that one group.

Lot Size	GL Code Letter	Sample Size for given AQL		
		Critical 0.10	Major 1.0	Minor 4.0
2 - 8	A	All	All	2
9 - 15	B	All	9	3
16 - 25	C	All	13	5
26 - 50	D	All	13	8
51 - 90	E	All	13	8
91 - 150	F	All if ≤ 124 125 if ≥ 125	20	13
151 - 280	G	125	50	32
281 - 500	H	125	50	32
501 - 1200	J	125	80	50
1201 - 3200	K	125	80	50
3201 – 10,000	L	200	125	50

Sample Sizes

Note: While not identical, sample sizes are guided by ANSI/ASQ Z1.4-2008, Table II-A – Single sampling plans for normal inspection (master table), with changes to some sample sizes and the following modifications:

- "Ac" and "Re" values are not used. In all cases, a single rejection shall result in 100% inspection of the lot for the rejected characteristic.
 - In cases where the sample size of a less stringent AQL is the same or greater than the sample size of a more stringent AQL, the sample size of the less stringent AQL may be reduced to the next lower size.
- A legible copy of each required material certificate of conformance for each lot of parts
 - A legible copy of each required processing certificate of conformance for each lot of parts

If the documentation is posted, the words "Inspection Documentation" shall be legibly written on the outside of the envelope and the envelope then placed in one of the part shipping containers.

Please use the following addresses for the documentation:

If emailed: tbretz@ced.us.com and copy bsiener@ced.us.com and djaeger@ced.us.com
Subject: Inspection Documentation for _____ <<<CED Part Number
Chemring Energetic Devices
If posted: 2525 Curtiss Street
Downers Grove, Illinois 60515
Attention: Receiving Inspection

Separate sampled parts

Separate and legibly identify the inspected samples from uninspected parts that were not part of the samples.

Packaging

All parts and documentation must be packaged to protect from loss, damage, or deterioration. The sampled parts shall be identified and not mixed with the non-sampled parts.

Approved 02/08/17 by:
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