



3. ANSI/ASQ Z1.4-2003




- \* D. Seller shall furnish to Buyer or Buyer's Representative an electronic, non-proprietary monthly report that contains, but is not limited to, the following data elements from the final inspection:

4. Distributor (Source provider) if applicable
5. Original Manufacturer
6. LM Aero Part Number
7. Total Lot Quantity
8. Sample Quantity Inspected
9. Number of Items Accepted
10. Number of Items Rejected
11. Feature Rejected
12. Equipment Utilized to Perform Inspection

III. ENGINEERING INSPECTION CRITERIA

- A. Equipment to inspect and/or validate the required characteristics varies based upon the tool type. Seller shall ensure that each piece of inspection equipment is capable of measuring to the tolerance specified in Industry Standard and/or Buyer specifications. Seller shall provide a listing of measuring equipment, gages, holding devices, and method employed for validating each characteristic identified in Paragraph III. C (at the Seller's facility) to Buyer or Buyer's Representative upon request.
- B. Prior to Buyer receipt, Seller shall ensure that all Items delivered shall have the following inspected for conformance to the applicable Buyer's Standard Tool Specification, "P" Sheet, "C" Number Drawing, TMS (Tool Manufacturing Standard), and/or NAS (National c0.



MARIETTA, MERIDIAN, & CLARKSBURG	FORT WORTH
Flute Configuration Shank Configuration End Configuration Corner Radius	Radial Rake Angle Shank Diameter Corner Radius Radius Mismatch Preset Flats Length/Depth Core Diameter End Concavity Radial/Axial Clearance
	Pilot Diameter/Pilot Hole Countersink Angle Pilot Length Seat Angle Axial Rake Angle Seat Angle Thread 2A Fit Countersink/Pilot Radius
Corner Radius Diameter Pilot Hole	Radial/Axial Rake Corner Radius Pilot Diameter Margin Width Flat/Perpendicular Cutting Edges
	Countersink Angle Countersink Axial Rake Angle Transition Between Countersink and Drill (radius or counterbore) Lip Height Variation Chisel Edge Centrality Web Thickness (W2) Shank Diameter Margin Width Alignment of Secondary Cutting Edges Key Characteristics Identified by Drawing
	

	MARIETTA, MERIDIAN, & CLARKSBURG	FORT WORTH
Hole Saws	Diameter End Configuration Arbor Threads	
Routers	Diameter End Configuration	
Bucking Bars	Surface Finish Hardness	
Drill & Reamer Bushings	Inside Diameter Outside Diameter Length	
Keller-Lok Bushings	Inside Diameter Outside Diameter Length	
Safety Apparel	Size Logo	
Process Tooling	Dimensional Check with Tape Measure or Equivalent	
Slings	Over-All-Length with Tape Measure or Equivalent	

D. Seller shall inspect the following characteristics by Standard Tool Number for the Marietta, Meridian, and Clarksburg facilities for the specific features identified below:

1. 550H006  
Hole must be centered with no burrs per Buyer specification
2. 550H007  
Dash number must match bushing size per Buyer specification
3. 550H008  
Slot dimension = 0.141" +.002"/-.000"
4. 550H203  
Surface coating adherence  
Dash number location per Buyer specification

IV. TAPER-LOK DRILL AND REAMER VERIFICATION BY BUYER

A. Seller shall submit a sample quantity of Taper-Lok drills and/or reamers to Buyer for verification. The verification process consists of the Buyer drilling and/or reaming holes to verify conformance to Engineering standards.

- B. Seller shall ship the test samples to Buyer at no increase in Buyer's cost or fee.
- C. Seller shall use the following guidelines to determine the proper quantity to be sent by Seller to Buyer for verification.
  - 1. Two (2) drill or reamers from the first 50 received and one (1) drill or reamer for every additional 50 (or portion of 50).
  - 2. The minimum quantity to be sent will be two (2) and the maximum quantity will be six (6).
- \* D. Seller shall complete the Tapered Cutter Verification Request form or a Buyer-approved alternate for submitting the samples to Buyer. The form may be accessed at: <http://www.lockheedmartin.com/material-management>. Highlight "Quality Requirements" and select "Forms". Seller shall submit an individual form, in triplicate, for each unique tool.
- D. Seller shall contact the buyer of record on the Purchase Order for specific shipping instructions for each sample to be submitted for verification.
- E. If and when Seller receives a completed and approved Tapered Cutter Verification Request form from Buyer, Seller shall ship the remaining quantity to Buyer.
- F. If Buyer has documented a rejection on the Tapered Cutter Verification Request form, Seller may submit additional sample quantities to Buyer for verification. If Buyer documents rejection of the additional sample(s), the entire lot is rejected and is not suitable for use by Buyer.