Q16 - Engineering Directed Standard Tool/Perishable Tool Inspection Requirements

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"IMPORTANT NOTICE: A hard copy of this document may not be the document currently in effect. The current version is always the version on the Lockheed Martin network."

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* REVISED   ** ADDED   ***DELETED

I. APPLICATION

Except as otherwise directed by Buyer, the governing revision of this document shall be the revision in effect on the date of this Purchase Order (PO). Subject to limitation by Buyer, if any, if subsequent revisions of this Buyer document are issued, Seller is authorized to use the latest revision of this document. If Seller opts for use of the latest revision, Seller shall utilize the applicable portions of the latest revision in their entirety.

NOTE: As used herein, the term "Buyer" is synonymous with the term "LOCKHEED MARTIN", the terms "Purchase Order" and "PO" are synonymous with the term "Contract", the terms "Item" and "Items" are synonymous with the term "Work", and the term "Seller" is synonymous with the term "SELLER", all as may be used elsewhere in the PO of which this document "Q16 – Engineering Directed Standard Tool/Perishable Tool Inspection Requirements" is a part.

II. REQUIREMENTS

A. Seller shall perform an inspection after all normal manufacturing operations have been completed. Seller shall perform this inspection of any Item prior to delivery to Buyer.

B. Seller shall furnish the results of this inspection and any previous inspections to

Table 1 Buyer Site Inspection Requirements by Tool Category

	MARIETTA, MERIDIAN, & CLARKSBURG	FORT WORTH
Common Characteristics for Each Tool Category	Body Diameter Damage Check Flute Length Identification Material Type Over-All-Length Surface Treatment Thread Size Key Characterisitcs	Back Taper Cutting Diameter Damage Check Flute Length Hardness Helix Angle Identification Material Type Over-All-Length Relief/Clearance Angles Run-Out (Concentricity) Surface Finish Key Characteristics
Straight Shank Drills	Shank Diameter Point Type Drill Diameter Pilot Diameter and Length	Lip Height Variance Chisel Edge Centrality Web Thickness (W2) Point Type Shank Diameter Margin Width Surface Treatment Alignment of Secondary Cutting Edges
Threaded Shank Drills	Point Type Seat Angle Hex Diameter and Length Pilot Diameter and Length	Lip Height Variance Chisel Edge Centrality Web Thickness (W2) Point Type Seat Angle Shank Hardness Margin Width Surface Treatment Thread 2A Fit Alignment of Secondary Cutting Edges
Chucking Reamers	Flute Configuration Shank Diameter Pilot Diameter and Length Reamer Diameter	Chamfer Lip Height Pilot Diameter Margin Width Shank Diameter Core Diameter Concentricity of Pilot/Cutter/Shank Diameters (between centers)

	MARIETTA, MERIDIAN, & CLARKSBURG	FORT WORTH
	Outside Diameter Arbor Hole Kerf Width Number of Teeth Magnetic Particle Inspection (per ASTM-E-1444)	
Hole Saws	Diameter End Configuration Arbor Threads	
Routers	Diameter End Configuration	
Bucking Bars	Surface Finish Hardness	
Drill & Reamer Bushings	Inside Diameter Outside Diameter Length	
KellBushing	Inside Diameter Outside Diameter Length	
	Size Logo	
	Dimensional Check with Tape Measure or Equivalent	
	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