



Quality Procedures Manual

Statistical Sampling Inspection

1. POLICY.

Future Design & Engineering (FDE) uses Statistical Process Control (SPC) to provide assurance of compliance with reliability, quality, and functional requirements. Sampling inspection is a part of this program and may include inspection by attributes, inspection by variables, or control chart techniques. Sampling inspection is not used where prohibited by the contract or customer (e.g., 100% final test) but is primarily considered during the receiving inspection of purchased parts. The purpose of this procedure is to establish an approved method for sampling inspection of purchased or in-house assembled material or end items. The philosophy of FDE is to improve processes to reduce non-compliant items through affirmative action rather than acceptance of various levels of rejections.

2. RESPONSIBILITY.

The Quality Assurance Manager has overall responsibility for the implementation of this procedure, including the evaluation of alternate sampling plans to insure compliance to contractual requirements.

The Operations Manager is responsible for insuring that the requirements of this procedure are complied with in all production operations.

3. DEFINITIONS.

See MIL-HDBK-1916

4. IMPLEMENTATION.

- A. Typically the quantities of items purchased or assembled by FDE do not warrant a sampling plan other than 100% inspection. If 100% inspection is not feasible on specific programs, the QA Manager will implement a sample plan based on guidelines from MIL-STD-1619.
- B. Nonconforming material is to be marked and stored in a prescribed location in accordance with FDE Quality Procedure QPM-010, Disposition/Corrective Action of Nonconforming Material.

5. REFERENCE.

MIL-STD-1916
MIL-HDBK-1916