DCMA NSEO MANUFACTURING PROCESS SURVEILLANCE (MPS) CHECKLIST #17

FINAL INSPECTION

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| |  |  | | --- | --- | | **SUPPLIER & CAGE:** |  | |  |  | | **LOCATION:** |  | |  |  |   **Program Type:**   |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | |  | Level I/SUSBAFE (LI/SS) |  | Navy Propulsion Program (NPP) |  | Deep Submergence Systems/Scope of Certification Program (DSS-SOC) | |  | Nuclear Plant Material (NPM) |  | Naval Nuclear Propulsion Program (NNPP) |  | Aircraft Launch & Recovery Equipment (ALRE) | |  | Fly By Wire Ships Control Systems (FBWSCS) |  | Ships Critical Safety Items (SCSIs) |  | Other: |   **Contractual Requirement(s) for this process:**   |  | | --- | |  |   **Supplier Procedure Number(s), Title(s) & Revision Level(s)/Date(s):**   |  | | --- | |  |  |  |  |  | | --- | --- | --- | | Surveillance Performed By: |  | | |  |  | | | Date(s) of Surveillance: |  | | | Contract Number(s): | |  | |  | |  | | Part Number(s)/Serial number(s)/NSN: | |  | |  | |  | | Part Nomenclature(s): | |  | |  | |  | | Supplier Personnel Contacted and Titles: | |  | |  | |  | | Drawing Number & Revision: | |  | |  |  |  |

**Process Concerns and Guidance:**

* Inspection and test results and accompanying documentation incorrect, incomplete or missing
* Inspections and tests not performed or performed incorrectly
* Dimensional inspection from incorrect drawing revision
* Incorrect dimensions specifically on pitch, major and minor diameters and also damage on internal and external screw threads, especially when MIL-DTL-1222J requirements are specified
* Visual inspection and cleanliness of items
* Lot sample sizes incorrect
* Contractor personnel may not be properly trained to take accurate measurements.
* Some contractors may rely on the QAR’s inspection records and results to ensure dimensional compliance and justification to deliver products to the Government.
* Damaged parts received by customer due to improper packaging, packing and preservation

**QARs should use the “BASIS OF DETERMINATION” column to document the objective quality evidence and/or clarify the rationale used to support their decision. (e.g. direct observation, documents verified etc.)**

S = Satisfactory U = Unsatisfactory

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| **SURVEILLANCE QUESTIONS** | **S** | **U** | **BASIS OF DETERMINATION** |
| 1. Review a sample of final inspections being performed by supplier personnel. 2. Is there a written procedure/inspection instruction? 3. Are the operators qualified (proper training or certification documentation or equivalent) to perform the final inspections reviewed? 4. Record all operations observed (include the applicable specification or work instruction, where applicable) and the corresponding operators’ names. |  |  |  |
| 1. Is inspection and testing equipment of the required adequacy, accuracy, precision, and range to assure supplies produced comply with specifications and drawings?   *What Items were sampled and were they part of the supplier’s calibration program and within the calibration/check cycle?* |  |  |  |
| 1. Do the supplier’s procedures state final inspection methods and accept/reject criteria, and is it clearly documented and understood by personnel? |  |  |  |
| 1. Are inspection records documented satisfactorily? 2. Are positive final inspection results recorded (i.e. SAT or UNSAT) to clearly indicate the status of the supplies after the inspection or test? 3. Are records annotaed in ink with errors utilizing "line thru", initial and date procedures? 4. Do records include traceability back to the procedure, lot/heat numbers, instruments used? 5. Do records include personnel who performed each inspection and test, and the finished product inspected? |  |  |  |
| 1. Is material/product, which has been through the final inspection process, positively controlled, traceable and identified to indicate its inspection status (e.g. individual operation sign-off/inspection stamping, tag or sticker/accepted or rejected)? |  |  |  |
| 1. Are work instructions, final inspection procedures, routers/travelers, etc. being used current? (latest contractual revision)? 2. Are they clear, concise, and adequate to allow only contractually conforming supplies to be delivered to the Government? ***What documents (identifying number & rev) were reviewed?***      1. Do routers/travelers contain a hold point for final inspection? |  |  |  |
| 1. Is the final product adequately identified with the proper documentation and certifications to provide clear material traceability throughout the products’ processing, and does the product match the documentation at time of packaging and shipment? |  |  |  |
| 1. Are there adequate methods of segregating accepted and rejected material in use? (e.g. materials awaiting inspection, are they identified and segregated from materials that have been accepted or rejected?) |  |  |  |
| 1. Are final inspectors verifying and preserving cleanliness before packaging? Is adequate protection taken to prevent damage of supplies in shipment? |  |  |  |
| 1. Is adequate control provided to assure that contractual packaging, marking, and documentation is in accordance with applicable requirements such as nameplates, traceability markings, etc.? |  |  |  |
| 1. Does the Contractor's operational system(s) detect and avoid counterfeit parts and suspect counterfeit parts? Are processes/procedures acceptable? |  |  |  |
| 1. Does the supplier have an adequate process in place to sufficiently handle parts to prevent damage at the prime and during shipment to a packaging house, if applicable? |  |  |  |
| Other observations: |  |  |  |

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| **Overall MPS Results:** | **SATISFACTORY** |  | **UNSATISFACTORY** |  |

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| **Corrective Action Generated?** | **No** |  |  | **Yes** |  |  | **CAR#** |  |

**FOLLOW-UP ACTION REQUIRED?**

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**SUMMARY/NOTES/COMMENTS/CONCERNS**: