DEFENSE SUPPLY CENTER PHILADELPHIA
CRITICAL ITEM PROCUREMENT REQUIREMENTS DOCUMENT

DOCUMENT NUMBER

NAS626H38

TITLE

BOLT-TWELVE POINT –STEEL, EXTERNAL WRENCHING

APPLICABLE TO: **NSN: 5306-01-049-1247**
PART NUMBER: NAS626H38
COMMERCIAL AND GOVERNMENT ENTITY: 14153

CRITICAL APPLICATION ITEM

PREPARED BY:	**DATE:** 12/20/05
APPROVED BY:	**DATE:**

REVISIONS

SYM	DESCRIPTION	DATE	APPROVED

CRITICAL ITEM PROCURMENT REQUIREMENTS DOCUMENT (CIPRD)
NAS626H38

TITLE: BOLT – TWELVE POINT – STEEL, EXTERNAL WRENCHING

NSN - 5306-01-049-1247
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1. **SCOPE:**

This Critical Item Procurement Requirements Document (CIPRD) covers the technical requirements of the item specified in the solicitation or contract. The documents listed in paragraph 2, with current revisions are part of this package to the extent specified herein. All Military, Federal and commercial/industry specifications and standards appearing hereon or on referenced documents, are part of this procurement package to the extent specified and shall be the issue in effect on the date of the solicitation unless otherwise specified. Bolts furnished in accordance with this Critical Item Procurement Requirements Document (CIPRD) shall be products authorized by the qualifying activity.

2. **REFERENCE DOCUMENTS:**

NAS624 THRU 644 – BOLT – TWELVE POINT, EXTERNAL WRENCHING

3. **REQUIREMENTS:**

(1) This CIPRD takes precedence over all documents referenced herein.
(2) All dimensional, performance and verification requirements of NAS 624 THRU 644 apply except as noted herein.
(3) External threads will be inspected for dimensional conformance in accordance with System 23 of FED-STD-H28/20.
(4) All parts will be subject to 100% non-destructive testing in accordance with ASTM E1444. Any part found to have an indication of cracks shall be rejected.
(5) For the purpose of determining conformance, the observed or calculated plating thickness shall be rounded to the nearest 0.0001 inch in accordance with ASTM E-29.
(6) Only the manufacturer's identification logo listed in MIL-HDBK-57 shall be applied directly to the surface of the part. Do not apply on bearing surfaces. The logo shall be listed with the Defense Supply Center Philadelphia, DSCP-ITA.
(7) All specifications, standards, quality assurance provisions and/or drawings referenced in this CIPRD shall be of the latest revision at the time of contract award.

4. **QUALITY ASSURANCE PROVISIONS:**

QAP EQ001 - This Quality Assurance Provision will apply when sampling plans are not specified.
QAP EQ003 - This Quality Assurance Provision establishes requirements for contractors' inspection systems.
QAP 1075 - This Quality Assurance Provision establishes requirements for Product Verification Testing, Certificate of Quality Conformance and Measuring and Test Equipment.

5. **QUALIFIED SOURCES:**

(1) **Only manufacturers listed on the Defense Supply Center Philadelphia (DSCP) Class 3 Threaded Fastener, Qualified Suppliers List for Manufacturers (QSLM) are qualified to manufacture this part.**

6. **QUALIFICATION PROCEDURES:**

(1) **Companies wishing to become qualified shall submit their request to:**

Defense Supply Center Philadelphia
Office of Engineering and Technical Support
Attn: DSCP-ITA
700 Robins Avenue
Philadelphia, PA 19111

8. **CERTIFICATIONS:**

1. **A Certificate shall be prepared in accordance with the format contained in QAP 1075. As a minimum the Certificate will include the following:**

   (a) **Material certification and analysis documentation: Steel in accordance with AMS6322 (G87400), AMS6415 (G43400), AMS6484(G43400), MIL-S-6049 (G87400).**
   (b) **Plating: Cadmium Plate in accordance with NAS672.**
   (c) **Hardness: 39-43 HRC**
   (d) **Threads in accordance with System 23 of FED-STD-H28.**
   (e) **Surface Roughness:**
   Shank, Head bearing surface, Head to Shank fillet, Thread flanks and Thread root radius – 32RMS
   Other Surfaces – 125 RMS
   (f) **Part hardness, tensile strength and certification of part dimensions to the minimum drawing requirements.**

2. **The Certificate must be maintained on file at the manufacturer's plant for a minimum of 10 years and made available to the government upon request.**

3. **Upon request, certify that this product is still available from the listed plant and is being produced using the same manufacturing and quality control processes that were used to fabricate the qualification test sample. Documentation of the manufacturing process substantiating this certification must be on file at the manufacturer's plant for a minimum of 10 years and made available to the government upon request.**