

**PROCEDURES FOR ALTERNATIVE SKIP-LOT END-ITEM INSPECTION
REQUIREMENTS FOR GOVERNMENT END-ITEM VERIFICATION
INSPECTIONS FOR OPERATIONAL RATIONS**

May 01, 2020

- I. GENERAL:** These Alternative End-Item Inspection guidelines were developed using the guidance of ASQ/ANSI S1, *An Attribute Skip-Lot Sampling Program* (with modifications), and the general requirements cited in operational rations contracts. These procedures apply to Government end-item verification inspections only. It is the intent of the Government to rely on the contractor/subcontractor's examination inspection results and minimize Government end-item verification inspection. All requests for clarification/ interpretation of the procedures cited herein shall be directed to the Contracting Officer, DLA Troop Support. NOTE: For the purposes of this program, the definition of inspection includes examinations only.
- A. End-item Inspection Requirement:** All operational rations contractors/ subcontractors performing under the higher level contract quality requirements are required to perform or have performed by their suppliers, contractually required component or end-item examination inspections in accordance with the contract and its technical specifications and technical requirements documents containing contractually required quality assurance provisions, unless in-process inspection results are authorized by the Contracting Officer for use as a substitute for contractor/subcontractor end-item verification inspection. NOTE: Substitute in-process contractor/subcontractor end-item conformance verification is not authorized for use by the contractor/subcontractor for the purposes of initially qualifying for, or requalifying for, State 2 Government skip-lot end-item verification inspection.
- B.** There are three basic states for skip-lot inspection:
- 1 **State 1: Lot-by-lot inspection.** This is the starting point for skip-lot inspection.
 - 2 **State 2: Skip-lot inspection.** When the contractor/subcontractor and the product qualify for skip lot inspection, with the approval from DLA Troop Support-FTRC, the program switches to State 2.
 - 3 **State 3: Skip-lot interrupt.** Skip-lot inspection may be temporarily interrupted, under circumstances described below, resulting in a transfer to State 3.
- C. Products/Characteristics Eligible for Skip-lot Inspection:** Skip-lot procedures are applied to a product's characteristics examinations on a product by product basis. Each individual type of product (identifiable by its NSN) is composed of categorically independent parts, principally in the form of packaging characteristics and product characteristics inherent to a product, which are measurable by their respective filled and sealed and product examinations. A product's approval for Government skip-lot inspection, in addition to the necessity of meeting pre-

conditions cited in this document, is determined by DLA by evaluating individual characteristic examination results, determining eligibility by characteristic examination, and by harmonizing the individual characteristic findings to assign the appropriate State and inspection frequency for a given item. An individual characteristic examination is defined, in general, as the examination required under each separate paragraph or table of examination listed in the contract/specification/CID/PKG&QAP. NOTE: Under no circumstances may two different skip-lot inspection frequencies be used for a product at the same time, i.e. a product's individual characteristics examinations may not be on more than one skip-lot frequency simultaneously. However, once a product is qualified for a specific State 2 skip-lot inspection frequency, although examination for characteristic "X" may be interrupted and subsequently undergo a requalification process for "X", inspection of a second characteristic, "Y", may continue using skip-lot inspection during the "X" requalification process provided "Y" itself is not interrupted. NOTE: There are three skip-lot frequencies used with the procedures described in this document: 1-in-1 (lot-by-lot), 1-in-4, and 1-in-6.

D. Products/Characteristics Ineligible for Skip-lot Inspection: The products packaged in flexible pouches subject to pouch integrity examinations that include critical category defects DO NOT qualify for skip-lot inspection for filled and sealed examination. NOTE: Internal pressure testing is considered to be a test, ineligible for this skip-lot program.

E. Approval for Skip-Lot Inspection (Flow # 1): DLA Troop Support - FTSB will approve and assign QSP ratings. DLA Troop Support-FTSB will notify the Government Quality Assurance Representative (GQAR) and contractor/subcontractor when the contractor's/subcontractor's Quality System Plan (QSP) was rated acceptable by DLA Troop Support-FTSB. GQAR shall review the QSP rating and the product's quality history. If the QSP is not acceptable, the contractor/subcontractor does not qualify for skip-lot inspection. When the contractor/subcontractor determines that a product becomes eligible for skip-lot inspection in compliance with the provisions of Section V of this document, the contractor/subcontractor may petition the Contracting Officer (DLA Troop Support-FTRC) to have the GQAR initiate 1-in-4N skip-lot inspection.

F. Compliance of A Product: When, for a specific product, the State 2 skip-lot inspection provisions contained in this document are approved by DLA Troop Support-FTRC for use by the Government Quality Assurance Representative (GQAR), acceptance of material by the Government as complying with required end-item requirements cited in the contract/technical specifications and technical requirements documents shall be based on the contractor/subcontractor's (1) end-item inspection results or (2) substitute in-process inspection results (if approved by DLA Troop Support-FTRC). As long as the contractor/subcontractor's inspection system is determined by DLA to be reliable, and the GQAR is authorized to perform State 2 skip-lot end-item verification inspection, the GQAR will sample and inspect the product for verification end-item inspection on a skip-lot basis. The GQAR for

the Government agency having jurisdiction for performing Government QA at the contractor's or subcontractor's plant may, upon ascertaining end-item compliance, permit shipment, provided all other requirements of the contract are met. NOTE: Substitute in-process inspection results are only permitted for use as contractor/subcontractor end-item conformance verification (1) when authorized by the Contracting Officer as a substitute for end-item inspection and (2) when the contractor/subcontractor is currently qualified for State 2 skip-lot inspection when participating in the Government skip-lot end-item inspection program, i.e., substitute in-process inspection results are not authorized for use by the contractor/subcontractor when in either State 1 or State 3.

NOTE: Section I, paragraph F., is not applicable to end-item verification testing. Skip-lot scheduling of end-item verification tests that are required to be conducted by contract and when permitted so by the contract, are to utilize contract Provision 9024 - Alternative Inspection Requirements for Selected Items.

G. Standby Component or End-Item Samples. The Government reserves the right to withdraw and hold standby samples of component or end-item product or both (quantity of which shall be the same sample size as that required for end-item inspection for the lot size represented) for Government end-item verification inspection purposes. Unused samples will be returned to the contractor/subcontractor after inspection indicates product compliance.

II. DLA TROOP SUPPORT'S RESPONSIBILITIES:

A. Contracting Officers' (DLA Troop Support-FTRC) Responsibilities: The Contracting Officer shall be solely responsible for authorizing the initiation of any **State 2: Skip-lot inspection**. The Contracting Officer can temporarily interrupt, discontinue, or disqualify a contractor/subcontractor from skip-lot inspection if she/he determines that skip-lot is not in the best interest of the Government. The Government verification inspection may also be further decreased (e.g., from skip-lot inspection frequency 1-in-4 at Normal Inspection (1-in-4N) to 1-in-6 at Normal Inspection (1-in-6N), by the Contracting Officer if she/he determines that this is in the best interest of the Government.

B. DLA TROOP SUPPORT-FTSB Quality Systems Audit Team:

1. DLA Troop Support-FTSB is responsible for maintaining the contractors' QSPs; QSP ratings and evaluations, major noncompliance/deviation to the documented QSP and/or the quality system, and all correspondence submitted to the contractor/subcontractor. DLA Troop Support-FTSB will review all factors of production, inspection, and product failure to determine if the contractor/subcontractor has implemented an adequate quality system that continuously produces conforming products. This determination will be made by obtaining information from the applicable Government inspection agency, and feedback from FTSB and FTSC QAS personnel as applicable. The following information is needed in determining skip-lot

inspection: The contractor/ subcontractor's latest documented Quality System Plan (QSP) evaluation rating, and latest compliance audit results; the quality history of the contractor/subcontractor and of the proposed items tentatively qualified for skip-lot inspection; the period of production; and the data required to implement skip-lot inspection (product name, lot numbers and the inspection agencies' end-item inspection results).

2. DLA Troop Support-FTSB will conduct compliance quality systems audits to evaluate the contractor/subcontractor's implementation of and compliance with the QSP, as well as the effectiveness of the approved documented QSP and other contractual requirements, on an annual basis (at a minimum).

3. DLA Troop Support-FTSB will notify the Contracting Officer of the following: Major deficiencies noted in the documented QSP or implemented quality system; if there are significant changes in the contractor/subcontractor's personnel or quality system; and recommendations concerning whether or not to discontinue skip-lot inspection.

III. INSPECTION AGENCIES' RESPONSIBILITIES:

- A.** The designated GQAR shall review the contractor/subcontractor's documented QSP and verify the quality system for implementation, compliance, and effectiveness in accordance with the approved documented QSP and other contractual requirements. Provide written electronic notification (using the Corrective Action Request Report) to DLA Troop Support-FTSB of a major noncompliance/deviation to the documented QSP and/or the quality system within one working day, as applicable.
- B.** The designated GQAR shall perform Government verification inspection (lot-by-lot or skip-lot as approved by the Contracting Officer) for the products with contractual inspection requirements to assure that the contractor/subcontractor's end-item results are reliable. Copies of the results of the inspections performed by the Government QAR shall be given to the contractor/subcontractor.
- C.** The designated GQAR shall be consulted, as a participant in either a product's initial qualification process or a product's re-qualification process, by DLA for the purpose of DLA's verification that the conditions of Section V,A,1,2,3 and Section V,B,1,2, and Section VI,E,2 have been met or not met, as applicable. This GQAR responsibility does not include the collection of data, or the evaluation of data specifically required to be performed by the contractor/subcontractor, by the Contracting Officer (FTRC) or by DLA Troop Support-FTSB.
- D.** The designated GQAR shall initiate skip-lot inspection when instructed to do so by DLA Troop Support-FTRC once the Contracting Officer determines a product is eligible for skip-lot inspection. Maintenance of a product's inspection data required for DLA Troop Support-FTRC to evaluate the contractor/subcontractor's qualifications for skip-lot inspection shall be the responsibility of the

contractor/subcontractor. **NOTE:** Skip-lot inspection does not apply to record review. The GQAR shall review ALL records pertinent to all lots produced (including those not inspected under skip-lot inspection), issue a corrective action request if applicable (addressing a finding or observation), and provide a copy of the record review to the contractor/subcontractor. During Government joint compliance audits, the GQAR shall make available a copy (to the Government Audit Team) of the results of record reviews for those lots randomly selected **by the Government Audit Team** for record verifications.

- E. The designated GQAR shall interrupt skip-lot inspection for a packaging or product characteristics exam, as applicable, when a product's characteristics exam reverts to "State 3, Skip-lot interrupt" due to a GQAR end-item exam failure. At the request of the contractor/subcontractor, the GQAR shall start lot-by-lot inspection for interrupted packaging characteristics exams and/or product characteristics exams in accordance with Section VI, D. Requalification Procedures. The GQAR shall notify the contractor/subcontractor when skip-lot inspection is interrupted. The GQAR shall notify DLA Troop Support-FTRC when any of the disqualification procedures contained in Section VI, E, are met.
- F. The designated GQAR shall maintain a skip lot ledger for each of the products selected for end-item skip lot procedures. The skip lot ledger should list the lot number, the date the lot was offered, the exams eligible for skip lot, the pass/fail status, exam/skip status and the skip lot state in effect for those exams.
- G. The designated GQAR shall annotate the certification documentation (e.g., USDA-AMS certificate, iRapt, other) for each applicable lot included on the certification documentation to indicate acceptance is based in part on contractor/ subcontractor's (1) end-item examination results or (2) DLA approved substitute in-process inspection results (if substitute in-process inspection is approved by DLA Troop Support-FTRC). Example annotation: "Acceptance of lot ___ or lots _____ listed is based in part on the contractor/subcontractor's end-item examination results in accordance with end-item skip-lot procedures."
- H. Questions or concerns may be referred through the Contracting Officer to the applicable Quality Assurance Specialist assigned to DLA Troop Support-FTSC for Individual Rations or DLA Troop Support-FTSB for quality systems as applicable, Directorate of Subsistence, Operational Rations, 700 Robbins Street, Building 6, Philadelphia, PA 19111-5092.

IV. CONTRACTOR/SUBCONTRACTOR'S RESPONSIBILITIES:

- A. The contractor/subcontractor shall notify the applicable inspection agency, In-Plant GQAR and DLA Troop Support-FTSB, in writing, of any change in the following: QSP; change in the method of manufacture or inspection; significant changes in personnel having an effect on the production and quality of the product; significant changes in tools, gauges, or material related to the production of the product; or

implementation of any change in the specification.

- B.** The contractor/subcontractor shall notify the GQAR of scheduled producer's end-item verification inspection, and specific switching procedure (normal, tightened) being utilized for each product qualified under the ASQ/ANSI Standard Z1.4, when applicable. The GQAR shall also be immediately notified whenever the contractor/subcontractor finds a lot to be nonconforming and a disposition is desired under the contractual nonconformance procedures. All nonconforming lots accepted by the Contracting Officer under the nonconformance procedures (reinspection, waiver, rework, etc.), in lieu of inspection by the inspection agency, will be treated as nonexistent for purposes of the skip-lot sampling program (when the nonconformance is found by the contractor/subcontractor's inspection system).
- C.** Contractor/Subcontractor's End-Item Inspection Reports and other documentation. The contractor/subcontractor shall provide the GQAR the following documentation for all lots to be shipped to substantiate lot conformance, whether or not they are inspected by the GQAR (under the skip-lot inspection): A copy of the current production standard (PDM/First Article) formula (including ratios of ingredients and formulation records for each production lot), copies of all data/records of inspections and tests conducted (in-process and end-item and other data applicable to the lot in question as cited in the MPC Clause).
- D.** The contractor/subcontractor shall not ship any lot or any part of a lot until the GQAR has determined lot conformance with all requirements of the contract that are not qualified for skip-lot inspection.
- E.** The contractor/subcontractor shall be responsible for providing to DLA Troop Support-FTRC the contractor/subcontractor and GQAR end-item inspection results data (performance history) required by DLA Troop Support-FTRC for the purpose of evaluating the contractor/subcontractor's petitions requesting initial qualification for skip-lot inspection, re-qualification for skip-lot inspection, or change of skip-lot inspection frequency (ex. 1-in-4N.to 1-in-6N). Section V and Section VI may be used as a guideline for determining the extent of records necessary to support a request (i.e., the contractor/subcontractor is required to supply the end-item inspection data necessary to support a request to DLA for approval to commence State 2 government end-item skip-lot inspection; it is not necessary to supply inspection data unrelated to the specified number of lots required by DLA for the purpose of skip-lot qualification evaluation). DLA Troop Support-FTRC shall contract the contractor/subcontractor if additional information is necessary for the Contracting Officer to determine a disposition of a contractor/subcontractor's request.-Contractor/subcontractor end-item verification examinations are required to be performed for any of the product's characteristics exams if in State 1 or State 3 status – this includes requalification exams. (Example: State 3 is in effect for packaging examination. Both the contractor/subcontractor and the GQAR start end-item packaging examinations for the purposes of re-qualifying packaging examination for State 2 and thus maintaining the product as State 2 qualified. While

packaging is in the process of re-qualification, product examination continues using skip-lot end-item inspection procedures, however should the packaging requalification attempt fail, the product and all its constituent characteristics exams are relegated to State 1.

NOTE: Section IV, E, performance history data must be submitted electronically to DLA Troop Support-FTRC using an EXCEL compatible format. Hand transcription will only serve to delay DLA response time.

The contractor/subcontractor shall provide an inspection data record of the lots offered for first time Government inspection (the record to include such lot's inspection results for both the contractor/subcontractor and the GQAR inspections, organized by correlating a product/item identity (NSN), with its applicable lot numbers, each lot's applicable end-item exams, each exams inspection plan criteria, and the number of defects/nonconformities by defect category and description found in each end-item exam, by lot number, by the product/item, by inspection activity) to DLA Troop Support-FTRC. DLA Troop Support-FTRC shall contact the contractor/sub- contractor if additional information is necessary.

EXAMPLE OF "INSPECTION DATA RECORD": 1/

PCR-C-007, Contractor/Subcontractor, Vanilla Pound Cake, Product examination, TABLE I,

Defect	101	102	103	104	201	202	203	204	205	206	207	208	209	210
Lot No.														
9365	0	0	0	0	0	0	0	0	0	0	0	0	0	0
0031	0	0	0	0	0	0	0	0	0	0	0	0	0	0
0060	0	0	0	0	0	0	0	0	0	0	0	0	0	0

PCR-C-007, USDA, Vanilla Pound Cake, Product examination, TABLE I,

Defect	101	102	103	104	201	202	203	204	205	206	207	208	209	210
Lot No.														
9365	0	0	0	0	0	0	0	0	0	0	0	0	0	0
0031	skipped lot													
0060	0	0	0	0	0	0	0	0	0	0	0	0	0	0

1/ For each lot, include a column citing lot size and/or sample size.

F. It shall be the responsibility of the contractor/subcontractor to request approval for skip-lot eligibility qualifications (initial qualifications, re-qualifications, and change of inspection frequency or severity qualifications) from DLA Troop Support-FTRC and to notify the GQAR of such a contractor/subcontractor's request. As part of the contractor/subcontractor's request, the contractor/subcontractor shall provide DLA and the GQAR with the performance history maintained in accordance with paragraph IV.,E. DLA shall notify the contractor/subcontractor and GQAR as to the product's eligibility for STATE 2 status. If requested by the contractor/sub-contractor, DLA shall provide the contractor with excel data forms to accommodate

those products that are eligible to qualify for government end-item skip-lot inspection.

V. INITIAL END-ITEM SKIP-LOT INSPECTION QUALIFICATIONS. 2/

A. Contractor/Subcontractor Qualification. The contractor/subcontractor shall:

1. Have a documented QSP that was rated acceptable by DLA Troop Support-FTSB. Have implemented and maintained the documented QSP for controlling finished product quality and changes in the system. The quality system shall include inspection by the supplier of every lot produced and recording of inspection results, except where a substitute in-process inspection results method is authorized by the Contracting Officer.
2. Have implemented a quality system that is reliable in terms of consistently producing conforming finished product and that is capable of detecting and correcting shifts in quality levels and monitoring process changes which may adversely affect quality. The supplier's personnel responsible for the application of the system shall exhibit a clear understanding of the applicable standards, systems, and procedures to be followed.
3. Not have experienced an organization change that might adversely affect quality.

B. Product Qualification (Flow # 2):. The product shall have met all contract/specification/CID requirements and ALL of the following requirements previous to determining eligibility for State 2:

1. The product shall be of stable design and not a new item (new item is one that has never been produced for the specific ration program). An item is no longer new and can be considered stable of design if it meets the following paragraphs, 2 through 6 below.
2. The product shall have been manufactured on an essentially continuous basis for a period of not less than six months (whenever production is held pending first article/PDM/PCR/ sample approval, only the time period after approval and resumption of regular production shall be included). Essentially continuous production (for new items – see also VI, B, 2) means that “production is at a steady rate.” Production is considered continuous if at least one lot of that product type (e.g., chicken and rice) is produced or submitted for inspection at a frequency of every month.
3. The previous 10 consecutive lots offered for inspection of the product have

been on normal end-item inspection at the inspection level cited in the contractual documents (see ASQ/ANSI Z1.4 and the specific product's specification/CID or other contractual document where the inspection levels are given).

4. The previous 10 consecutive lots have, at a minimum, been maintained at the Acceptance Quality Limits (AQLs) cited in individual specifications or other contractual documents (see ASQ/ANSI Z1.4). Compliance with AQLs shall be calculated using Government end-item verification inspection results.

5. The previous 10 consecutive lots were found to have end-item inspection results determined to be comparable and reliable when comparing contractor/subcontractor end-item inspection results to GQAR end-item inspection results. The data used for comparison calculations shall be attribute data comprised of major class findings and total class findings, (total class findings consist of either combined major and minor, or stand-alone totals, as applicable). Comparability for each class of defects shall be determined by calculating the standard normal deviate as defined in subparagraph VI.3.a. of SUBSECTION 225.3 of DPSCM 4155.6. The calculated values shall be applied in accordance with VI.A.3.b. through VI.A.3.d. of SUBSECTION 225.3.

SUBSECTION 225.3 of DPSCM 4155.6 is available at:

<https://www.dla.mil/TroopSupport/Subsistence/OperationalRations/qapubs/>

6. The previous 10 consecutive lots were found conforming with all the requirements cited in the contract/specification/CID and were accepted during the initial end-item inspection performed by the assigned In-Plant GQAR.

7. The previous 10 consecutive lots were subject to end-item inspection by the contractor/subcontractor and by the GQAR. No "substitute in-process inspection results" are permitted for use in the initial end-item skip-lot qualification process.

2/ Not applicable to end-item verification testing required by contract to be conducted at USDA National Science Laboratories (NSL) or by in-plant USDA inspectors under the USDA in-plant verification testing protocol.

VI. PROCEDURES FOR GQAR SKIP LOT INSPECTION - Flow # 3 one-in-four skip-lot frequency (normal inspection) and Flow # 4 one-in-six skip-lot frequency (normal inspection):

A. Determining initial skip-lot inspection frequency (for the products that are not new and for which stable design was previously established):

1. Lot-by-Lot Inspection Procedure (State 1): The inspection program for a product's starts in State 1, lot-by-lot inspection. When the supplier and the product qualify for skip-lot inspection, and with the approval from DLA, the GQAR inspection program switches to State 2, skip-lot. Skip-lot inspection may be

temporarily interrupted resulting in a transfer to State 3.

2. Inspection Data Record from the 10 consecutive lots presented for Government verification for the purpose of achieving State 2 Government skip-lot end-item verification inspection shall be recorded and made available to DLA by the contractor/subcontractor for the purpose of DLA's determining and authorizing initial and subsequent skip-lot inspection re-qualifications and inspection frequencies. This data consists of that running record described in Section IV, paragraph E.

NOTE: Lots produced prior to or within the production date boundaries defined by the eldest lot number and the youngest lot number comprising the 10 consecutive lots presented for first-time Government verification inspection, but offered subsequent to the accomplished offering and inspection of the 10 consecutive lots, shall not be eligible for end-item skip lot verification inspection. Inspection dispositions of lots to which this NOTE applies shall not be used for the purpose of determining interrupt as cited in Section VI, paragraph C.

3. (State 2 - 1-in-4N) The initial frequency for skip-lot inspection shall be one lot randomly selected for inspection from a lot population of four. The "lot population" represents lots submitted subsequent to the last GQAR inspected lot. Inspection at the 1-in-4N frequency is conducted at normal inspection/sampling. ("N" signifies "normal" inspection/sampling) If there is a change in status (i.e., State 2 to State 3) incurred during the 1-in-4N frequency period, the State 2 - 1-in-4 frequency may resume if the product meets the 1-in-4N re-qualification requirements (see Flow 3). Under no circumstances may two different skip-lot inspection frequencies be applied to a product at the same time (see Section I, C). For example, a product's packaging examination and its product examination shall use the same skip-lot inspection frequency when in State 2.

4. (State 2 - 1-in-6N) When a product has been at the 1-in-4N frequency for a minimum of one year with no change in status in skip-lot inspection for all requirements/characteristics eligible for skip-lot inspection (i.e. no Government end-item inspection failures), the frequency for skip-lot inspection should be reduced to 1 lot randomly selected for inspection from a lot population of 6 consecutively submitted lots submitted subsequent to the last GQAR inspected lot. Inspection at the 1-in-6N frequency is conducted at normal inspection/sampling. ("N" signifies "normal" inspection/sampling.) All of a product's requirements/ characteristics eligible for skip-lot inspection shall qualify to go to the frequency of 1-in-6N at the same time. If there is a change in status (i.e., State 2 to State 3) incurred during the 1-in-6N frequency period, the State 2 - 1-in-6N frequency may resume if the product's effected characteristic(s) meets the 1-in-6N re-qualification requirements (see Flow 4). Under no circumstances should two different skip-lot inspection frequencies be applied to a product at the same time.

5. Other skip-lot frequencies cited in the standard, *ASQ/ANSI S1*, shall not be

used, unless approved by the Contracting Officer.

B. Lot Selection for Skip-Lot Procedure (State 2):

1 The lots inspected under State 2 (skip-lot) shall be selected in accordance with the inspection agency procedure (e.g. six-sided die or other method provided the contractor/subcontractor does not know which of the lots will be inspected until the lots have been offered for Government inspection). Unless otherwise directed by DLA Troop Support, end-item inspection skip-lot verification shall be done by randomly selecting not less than one lot in four or one lot in six consecutive lots, as applicable, presented for inspection of a specific item. The sampling procedure under skip-lot places the succeeding lots not chosen for inspection back into the universe available for subsequent inspection. For instance, starting with a group of four lots (i.e., 1-4), randomly select one of them for inspection. If lot 2 were selected, the next lot would be selected from lots 3, 4, 5, or 6. If lot 6 were chosen at random, the next selection would be from lots 7, 8, 9, or 10, and so on.

2. A product must be produced on an essentially continuous basis. Essentially continuous basis (for the products that are not new – see also V, B, 2) means that, for a specific product, at least 1 lot of that specific product, or 1 lot of a product of similar nature (produced for the rations programs), is produced and/or submitted for Government verification inspection every 2 months (unless contracted quantity is completed for that specific line item or as directed by DLA Troop Support). A product shipped to other parties (other ration contractors/subcontractors) shall be considered in the determination of essentially continuous production. **NOTE: A product of similar nature:** All MRE placeable and multi-stage entrees can be grouped together and considered of similar nature; all MRE pumpable entrees can be grouped together and considered of similar nature; all MRE thermostabilized fruits can be grouped together and considered of similar nature; all MRE cakes can be grouped together and considered of similar nature; all MRE cookies/brownies can be grouped together and considered of similar nature for the purpose of determining if a product meets essentially continuous production criteria.

3. The contractor/subcontractor shall provide Inspection Record Data (the record to include such lot's inspection results for both the contractor/subcontractor and the GQAR inspections, organized by correlating a product/item identity (NSN), with its applicable lot numbers, each lot's applicable end-item exams, each exams inspection plan criteria, and the number of defects/nonconformities by defect category and description found in each end-item exam, by lot number, by the product/item, by inspection activity) to DLA Troop Support-FTRC. DLA Troop Support-FTRC shall contract the contractor/sub-contractor if additional information is necessary.

4. Acceptance or rejection of lots identified by the contractor/subcontractor (based on their inspection in lieu of submitting the lot for Government inspection) shall not affect skip-lot status. The contractor/subcontractor may request that the

Contracting Officer accept a lot without Government verification inspection (rework/waiver based on the contractor/subcontractor's inspection results). Such a lot will be treated as nonexistent for the purpose of the skip-lot procedure. However, paperwork concerning the nonconforming lot and the final disposition shall be placed in the contractor/subcontractor's quality history file. The contractor/subcontractor shall not, knowingly, submit lots found nonconforming by their end-item inspection system or in-process inspection data (if permitted in lieu of end-item inspection) for Government inspection. If a lot is inspected by the Government, rejected, and later accepted as nonconforming (ex. waived), the Government initial inspection results shall be used to determine skip-lot status.

C. Interrupt Procedures (State 3): Skip lot shall be interrupted and lot-by-lot inspection implemented (for that set of requirements or characteristics) in accordance with the contractual requirements when the data from the last inspected lot does not meet the requirements of the contract.

D. Requalification Procedures: Skip lot requalification requires that, within the next 10 consecutive lots presented for first time Government inspection, five consecutive lots are presented for Government verification inspection and are accepted during State 3 (lot-by-lot inspection); process AQLs, as measured by Government inspection results, are at or below required AQLs, and the contractor/subcontractor's and the Government's requalification inspections findings are comparable 3/. A written request for resumption of GQAR skip-lot inspection, along with the data necessary to support the achievement of the criteria cited in the foregoing sentence, shall be submitted to DLA Troop Support-FTRC for approval by the Contracting Officer. Upon re-qualification, skip-lot inspection should be resumed using the State 2 skip-lot frequency in effect at the time of skip-lot interruption (1-in-4N resumes 1-in-4N, 1-in-6N resumes 1-in-6N) as applicable. **NOTE: ANSI/ASQ Z1.4 Switching Procedures apply to the Requalification Procedures.**

3/ End-item inspections conducted for the purpose of skip-lot requalification shall commence with the use of normal inspection sampling plans, regardless of the State 2 skip-lot frequency in place at time of a specific product's disqualification. Contractor/subcontractor end-item verification inspection is required for the purpose of re-qualifying for State 2 GQAR skip-lot end-item verification inspection. **NOTE: ANSI/ASQ Z1.4 Switching Procedures apply to the Requalification Procedures.**

NOTE: Lots produced prior to or within the production date boundaries defined by the eldest lot number and the youngest lot number comprising the lots inspected by the GQAR for the purpose of meeting requalification criteria but offered subsequent to the requalification or disqualification criteria being met, shall not be eligible for end-item skip lot verification inspection. Inspection dispositions of lots to which this NOTE applies shall not be used for the purpose of determining interrupt as cited in VI.,C.

E. Disqualification Procedures: A product shall be disqualified for skip-lot inspection

and lot-by-lot inspection procedures reinstated when one or more of the following three conditions occurs:

1. Requalification is not achieved within 10 lots for a product (e.g., chicken and rice); or the product, once placed in State 3, is not produced for more than two months; and/or, the procedures shift between State 2 and State 3 more than once within a period of two months. NOTE: ANSI/ASQ Z1.4 Switching Procedures are applicable during Requalification.

2. **The Government detects irregularity in the following:** (a) The contractor/subcontractor's quality system during joint Government compliance audits or verification/audits conducted by the assigned In-Plant GQAR; (b) decrease in product quality noted during Government product reviews; (c) contractor/subcontractor deviates from the approved documented QSP without Government review and approval or deviates from the contractual requirements; (d) a customer complaint received, validated and determined to have a serious effect on the quality of the product; and/or (e) the contractor/subcontractor fails to address corrective action requests (CARs) or to take effective corrective and preventive action (CPA) to correct deficiencies noted by the inspection agencies (after GQAR's CAR has been validated by DLA Troop Support-FTSB), customers, and/or during DLA Troop-Support-FTSB compliance audits.

3. The Contracting Officer determines that skip-lot is not in the best interest of the Government and decides to return to lot-by-lot inspection.

4. If lot-by-lot inspection is discontinued because of one of the events cited in the three preceding Section VI, E, paragraphs, the qualification requirements cited in the initial qualification requirements (Section. V.) shall apply. Upon re-qualification under the initial qualification requirements, skip-lot inspection should be resumed using the skip-lot frequency achieved prior to disqualification (i.e., resumption as described in this paragraph is applicable to 1-in-4N and 1-in-6N).

**VII. EXAMPLE OF GOVERNMENT END-ITEM EXAM SCHEDULING
CONDUCTED FOR THE PURPOSE OF QUALIFYING A PRODUCT FOR
STATE 2 SKIP-LOT INSPECTION – AN INITIAL QUALIFICATION AND A
RE-QUALIFICATION SCHEDULE**

NOTE: This following example is limited in its scope to the illustration of the scheduling of GQAR exams conducted during qualification and re-qualification phases of the skip-lot qualification process.

Lot No.	Characteristic of the Product: Filled & Sealed Examination, Table II				Characteristic of the Product: Product Examination, Table I				The Product
	State	Exam	GQAR Exam Disposition	Do end-item exam results indicate exam characteristic is skip eligible?	State	Exam	GQAR Exam Disposition	Do end-item exam results indicate exam characteristic is skip eligible?	Is the product skip eligible?
Presupposing that all qualification factor save the 10 consecutive acceptable GQAR end-item inspections have been met:									
1	State 1	End-item	Accept	no	State 1	End-item	Reject	no	no
2	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
3	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
4	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
5	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
6	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
7	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
8	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
9	State 1	End-item	Accept	no	State 1	End-item	Accept	no	no
10	State 1	End-item	Accept	yes	State 1	End-item	Accept	no	no
11	State 1	End-item	Accept	yes	State 1	End-item	Accept	yes	yes
Contractor/subcontractor submits request (including data to support request) to Contracting Officer for his approval to start GQAR end-item skip-lot inspection of all the product's characteristics. Under no circumstances may two different skip-lot inspection frequencies be used for a product at the same time									

Presuming Contracting Officer approves the contractor/ subcontractor's request to begin State 2, 1-in-4 Normal Inspection:									
12	State 2	Skip		yes	State 2	Skip		yes	yes
13	State 2	Skip		yes	State 2	Skip		yes	yes
14	State 2	End-item	Accept	yes	State 2	End-item	Accept	yes	yes
15	State 2	Skip		yes	State 2	Skip		yes	yes
16	State 2	End-item	Accept	yes	State 2	End-item	Accept	yes	yes
17	State 2	Skip		yes	State 2	Skip		yes	yes
18	State 2	End-item	Reject	no	State 2	End-item	Accept	yes	yes
Due to GQAR end-item rejection of a product's characteristic exam, filled & sealed exam, State 2 is interrupted for packaging exam. State 3 is in effect for packaging examination. GQAR starts the product's re-qualification inspection for packaging. Product examination continues using end-item skip-lot inspection.									
19	State 3	End-item	Accept	no	State 2	Skip		yes	yes
20	State 3	End-item	Accept	no	State 2	Skip		yes	yes
21	State 3	End-item	Accept	no	State 2	End-item	Accept	yes	yes
22	State 3	End-item	Accept	yes	State 2	Skip		yes	yes
Contractor/subcontractor submits request (including data to support request) to Contracting Officer for his approval to start GQAR end-item skip-lot packaging inspection									
23	State 2	Skip		yes	State 2	Skip		yes	yes
24	State 2	End-item	Accept	yes	State 2	End-item	Accept	yes	yes
25	State 2	Skip		yes	State 2	Skip		yes	yes
26	State 2	End-item	Accept	yes	State 2	End-item	Accept	yes	yes

COORDINATION AND APPROVAL OF SKIP LOT INSEPTION (SLI) FLOW 1

DLATS-FTSB approves QSP and notifies GQAR and contractor of QSP rating and other actions. 1

GQAR reviews QSP rating, product QH, Requests clarification from supervisor, or DLATS if necessary. Is QSP acceptable? 2

Contractor does not Qualify for skip-lot Inspection 3

NO

YES

GQAR inspection results indicate that the last 10 consecutive lots by item presented for 1st Govt. verification inspection were acceptable and continuous production criteria met? 4

NO

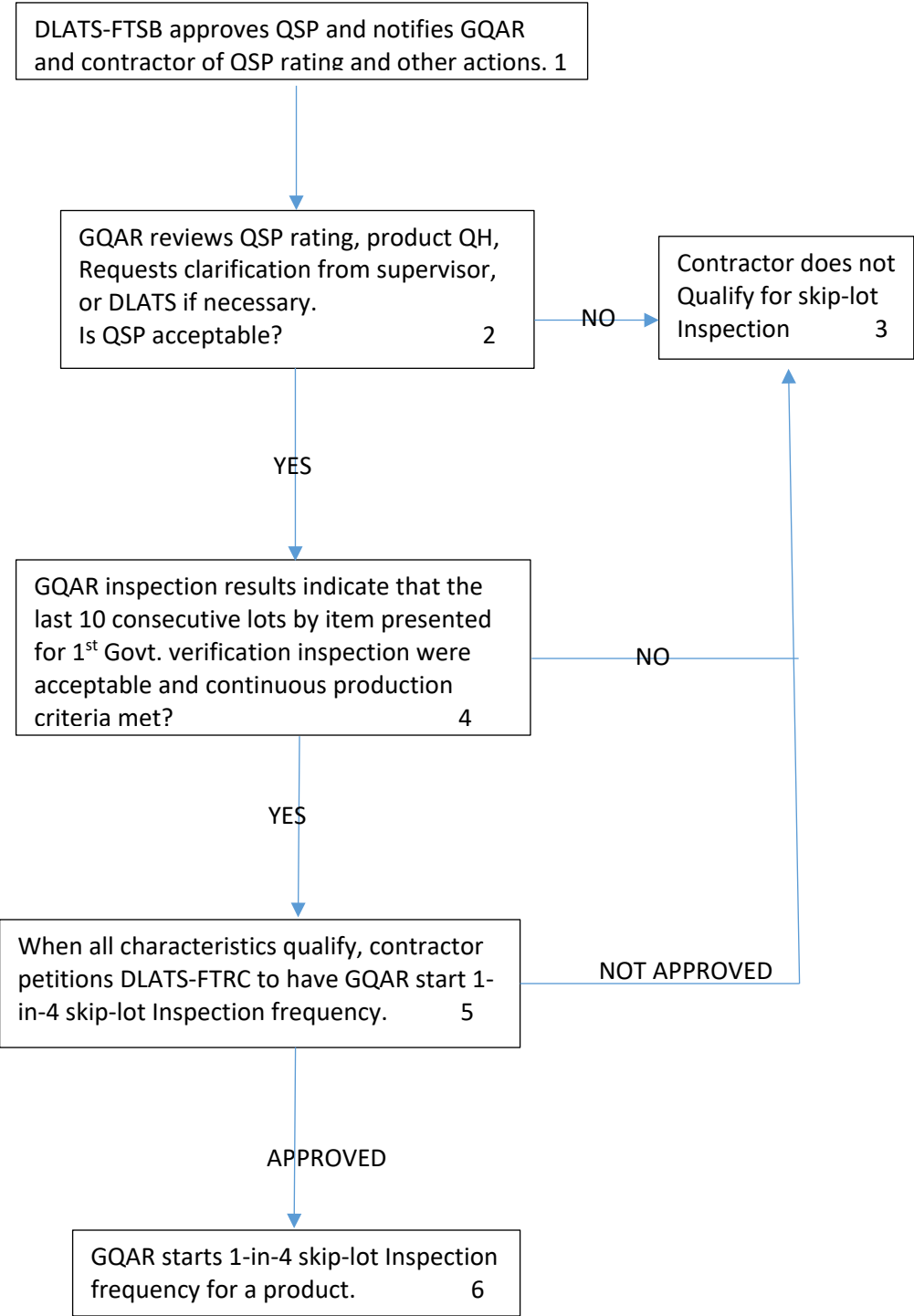
YES

When all characteristics qualify, contractor petitions DLATS-FTRC to have GQAR start 1-in-4 skip-lot Inspection frequency. 5

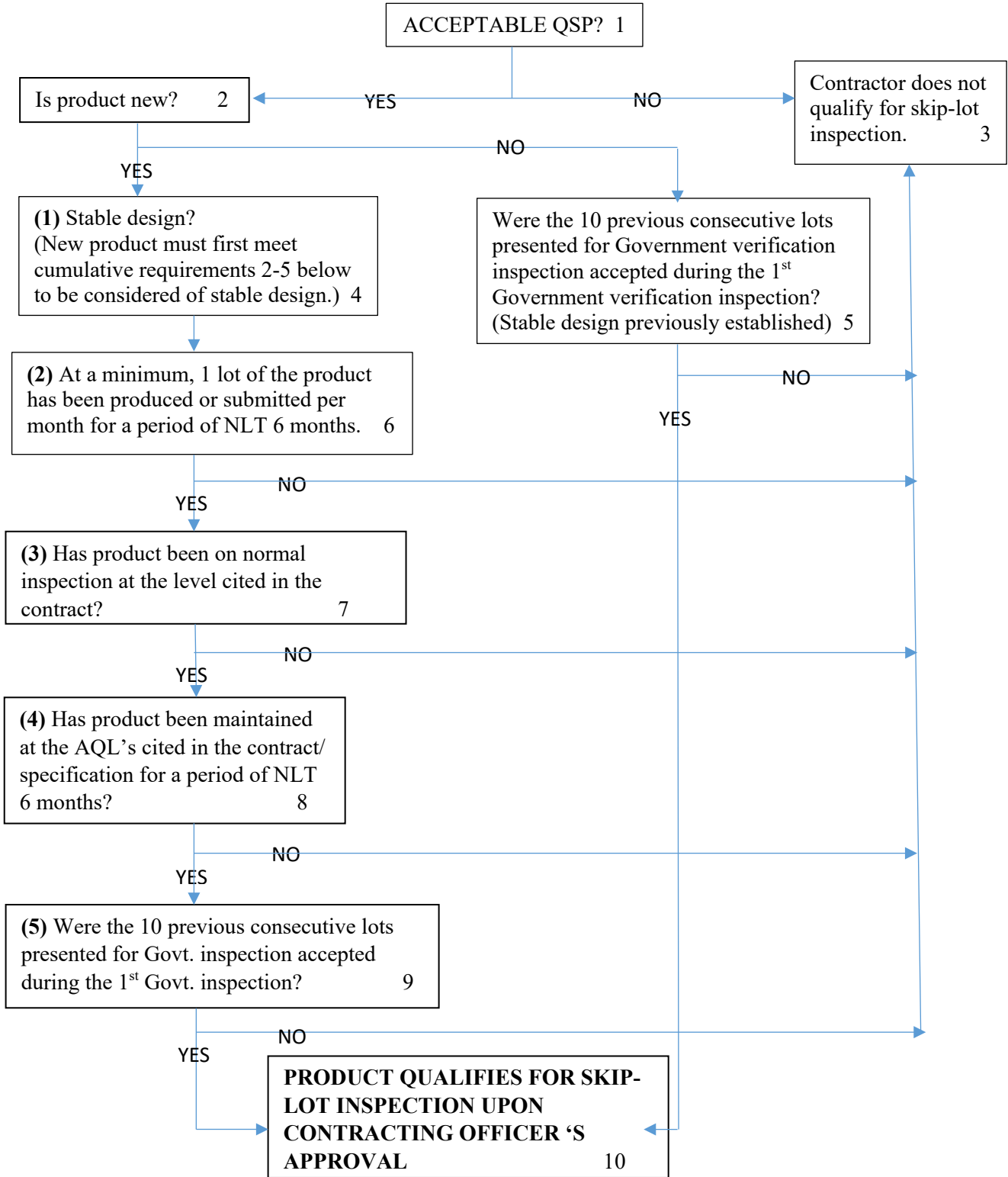
NOT APPROVED

APPROVED

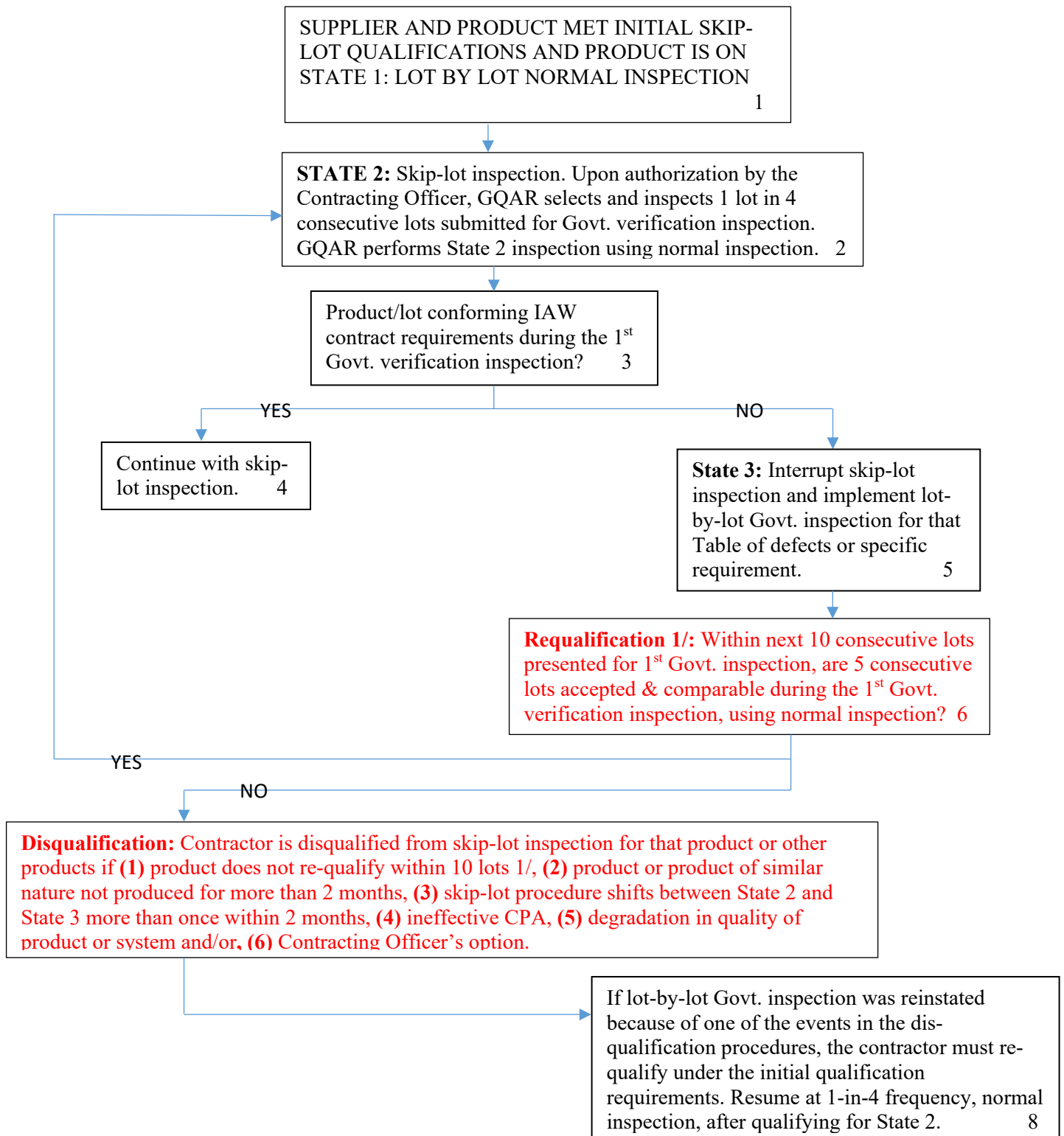
GQAR starts 1-in-4 skip-lot Inspection frequency for a product. 6



INITIAL QUALIFICATION FOR PRODUCT SKIP LOT INSPECTION FLOW 2

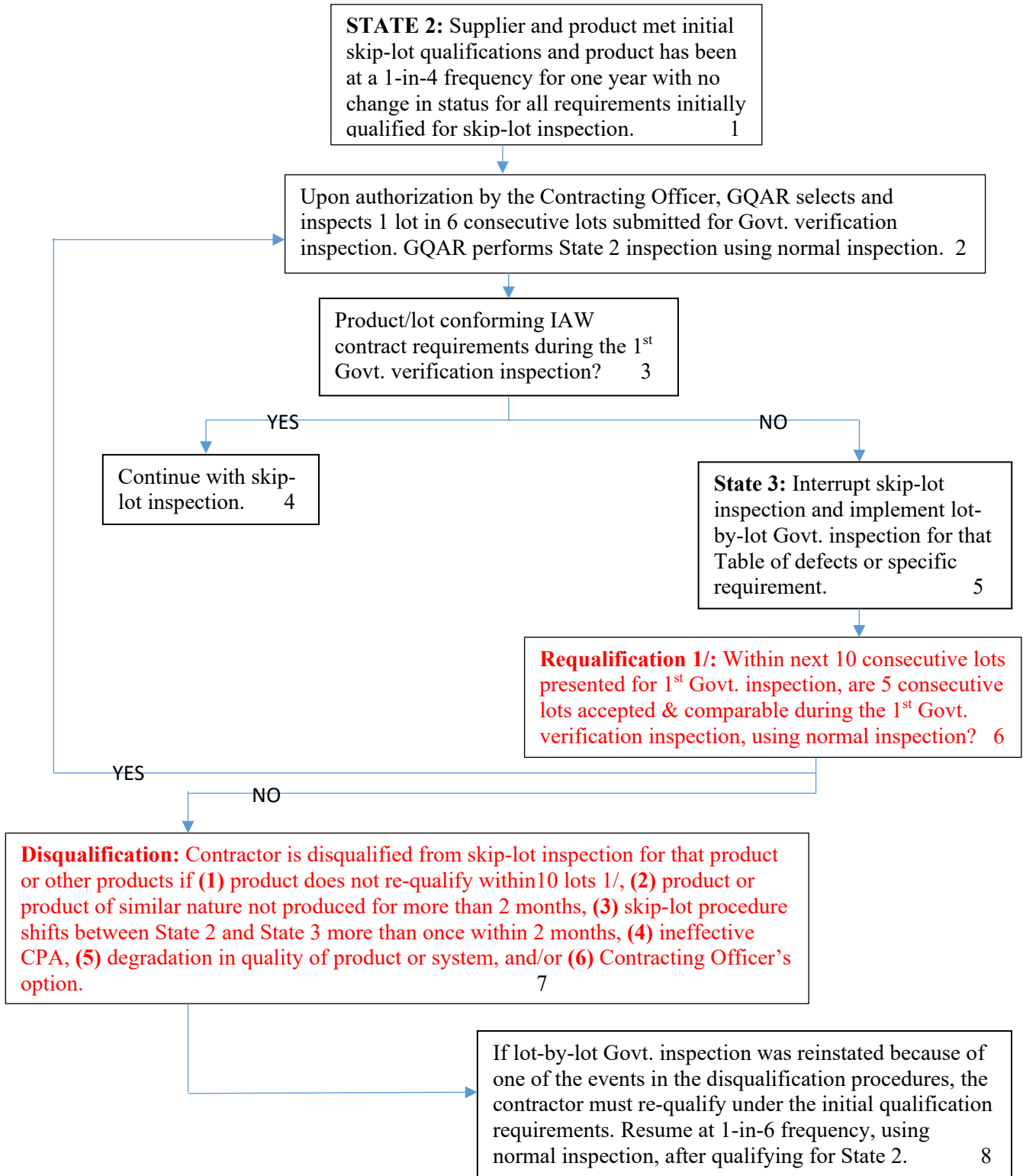


SKIP LOT INSPECTION (1-IN-4 FREQUENCY) NORMAL INSPECTION PROCEDURES FLOW 3



1/ The Switching Procedures cited in ANSI/ASQ Z1.4 apply to Requalification

SKIP LOT INSEPTION (1-IN-6N FREQUENCY) NORMAL INSPECTION PROCEDURES FLOW 4



1/ The Switching Procedures cited in ANSI/ASQ Z1.4 apply to Requalification