

Dear Supplier,

During latest audits it was noticed that Suppliers do not maintain documented CMM program correlations.

As per ASQR-01 para 7.5.1.3 and ASQR-07.5 para 4.1.3:

- Software for automated inspection (e.g. CMM, etc.) shall be verified by correlation of the test results with the results from an independent method of inspection.
- For P&W suppliers, acceptable correlation requires the difference to be within 10% of the tolerance for each characteristic. Differences greater than 10% but not exceeding 25% may be acceptable with documented justification.
- Variable data shall be recorded and retained.
- The independent method also requires a different person other than the person who created the inspection program to perform the verification.

CMM correlation results must be verified during FAIR approval and must be attached to FAIR package as a standard.

After each CMM program change it's required to verify scope of the changes and perform correlation for affected drawing characteristics.

On Customer request such correlation results must be provided.

This requirement will be checked during quality audits.