

# Quality Bulletin



Published by Supplier Quality Assurance Department

## Dear Suppliers.

Because of recent escapes, regarding nonconforming dimensions with tight tolerance zone e.g. 0.0005" / 0,0127 mm please consider following notes.

1. According to ASQR-01, The supplier should select M&TE with an accuracy ratio of 10 to 1 (product tolerance to M&TE tolerance) however accuracy ratios as low as 4 to 1 are acceptable unless otherwise specified. Ref: ASQR-01 para 8.2.4 - 3).
2. Inspection method shall assure verification of drawing requirement on entire surface of component. E.g. in a case of shaft and drawing requirement of outside diameter inspector shall check diameter in few sections of a shaft to detect any shape deformations.
3. Surface roughness on all characteristics with tolerance zones less than 0.002" / 0,05mm, **unless otherwise specified on the drawing**, shall be not more than 63 microinches / 1,6 micrometers according to CPW31 table 6 – parts for PWC and PWA362 table 2 – parts for PWA.
4. Depending on the size, the component shall be kept in a temperature controlled room for sufficient amount of time before measurement.
5. In a case of uncertainty of results being close to required boundary inspector shall use alternative inspection method to ensure clear results.
6. In a case of production of tight tolerance zone characteristics supplier shall verify his production and inspection process to ensure that it is compliant with all above requirements.