

Subject:

**Supplier Quality Alert -Written**

Supplier Alert No. 00003

Issued: 08 Month 2023

To: All T-7A Suppliers

Cc: Qarbon Supplier Quality

Subject: Proper saving and storage of data/files per D6-51991

Requirement:

Scope to defined requirement is presented below.

"All Inspection and Test Records" is defined as:

The digital data from measured points, data processing of measured points to engineering requirements (how the Measured Data was changed from Measured Points to Final Engineering Requirements), and data in the final report. This digital data is to include (but not limited to):

- 1) All Original Measured Data digitally in the CMS software (CMS software examples are: PCDMIS, VeriSurf, Spatial Analyzer, etc.). The supplier needs to be able to provide digitally, the actual measured points prior to any processing to design requirements. The supplier must be able to supply the Nominal data associated to the Measured data. The data needs to be in the Engineering Part or Aircraft reference system. The format of the data provided must be in IGS, if IGS is not available then a STP format, if STP is not available, then the data must be provided in an Excel format. The Actual data must be tied to the measuring device and capable of showing time and date of measured data.
- 2) All Engineering Design Processing requirements need to be documented digitally in the CMS software and in the output report to show how the original measured data was processed into the data associated with the engineering requirement in the final report. The Data Process needs to show the distance in X, Y, Z, I (rotation about the X Axis), J (rotation about the Y axis), & K (rotation about the Z axis) used to process the data from Original Measured Data to Final Engineering Requirement (Translation and Rotation used to process the data). The data also needs to identify all degrees of freedom and all degrees locked per the engineering requirement. Bottom line, all translation & rotation calculations (digitally in the inspection software and in the output report) that moves the Original Measured Data to the Final Reported data to the engineering requirement.

- 3) All Final data needs to be maintained digitally inside of the CMS software and in final reports. The final report must be exportable into IGS, STP, or Excel so that it can be imported into another CMS system.
- 4) The supplier is required to show and maintain all digital data from original measured data, how the data was calculated (fit), and final reported data. The Supplier must be able to regenerate a final report from the original data, through the translation & rotation, through the final report for the life of the contract. The CMS digital file that created the deliverable report must be able to reproduce the exact same report provided for the life of the contract. All log files and file history must be maintained. A deleted log file or history file will constitute a non-conforming report and will require a remeasurement with a complete log and history file. Log and History files are objective evidence to prove the integrity of the original data and the process used to create the reported. Stated another way, the CMS File used to generate the Final Report must be stored for the life of the program. That same CMS file must also be able to generate the exact same Final Report as the Original Final report for the life of the program. All Log & History files are to remain intact. Any modification/removal of Log or History data constitutes an automatic rejection of the report and require a remeasurement of the product.

## Definitions:

**Original Measured Data-** Measured Output from the measuring device prior to any processing of the data per engineering requirements. Original data must show traceability back the device and to the time and date the measured data was taken

Regards,

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