Notice to Suppliers

Rolls-Royce

V2500 Design Transfer from Rolls-Royce to PWAEI

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Job Title: Quality Manager
Business Unit: Civil Aerospace

NTS Number: 403
Issue: 2
Date: 21 April 2017

For the attention of the Managing Director and Quality Manager

Dear Sir or Madam,

Scope/Applicability:

All suppliers within our aerospace supply chain that manufacture and/or supply parts for the V2500 series of engines.

Introduction:

As previously communicated via NTS 394, the transfer of design responsibility for the V2500 high pressure compressor module and all associated components to Pratt & Whitney Aero Engines International (PWAEI) has now been completed.

Consequently, the disposition of non-conformances and deviation permits, and the approval of Fixed Process Approvals (FPAs) will now be performed by PWAEI. However all communication on such matters should be directed to Rolls-Royce Deutschland.

There will be no requirement to change the manufacturing process for parts currently being manufactured. Change will only occur if PWAEI issues a new part number, which will then be issued on Pratt & Whitney drawings with Pratt & Whitney specifications.

Rolls-Royce continues as the purchasing organisation for all V2500 parts associated with the high pressure compressor. Communication and agreements between suppliers and Rolls-Royce remain unchanged, and suppliers should not contact PWAEI directly.

Actions Required:

Non-conformance and Deviation Permit requests affecting V2500 parts shall be submitted to Agency.RRD-Concession@Rolls-Royce.com, using the SABRe template on the Global Supplier Portal. The email must identify in its title the supplier's unique document reference and whether it is a Concession or Deviation Permit. The document shall be completed in accordance with the 'Comments' contained in the template. Prior to submission, the applicant must confirm that the required information is clear and available, by following all the items on the checklist on pages 2 and 3 of this NTS.

Fixed Process Approvals shall continue to be submitted to RRD-Qual.POAH@Rolls-Royce.com for approval.

Be aware that we will communicate any other future changes directly to you, if you are affected.

NTS Category:

General Information / Communication

Authorised by:

Cesar Ludeña
Chief Project Engineer - Regional Fleet

Checklist for V2500 concessions and deviation permits (2 pages)

Concessions Quality Checklist for V2500		18.04.2017		Issue 2
1	Requirements for the front sheet			
	Checking Feature	Description	✓	Remarks
1a	Clarify if the request is for a Deviation Permit or a Concession	If a Deviation Permit (Waiver) request, then make sure quantity of parts affected represents a maximum of one year of production.		
1b	If the application is for a revision of an earlier concession, check that a reason is being provided.	The application must contain all information from the initial application.		
1c	To check if all information at the frontsheet is readable and complete			
1d	To check if set of box 1 ("document identification") is filled in complete and correctly.	□- identification of customer □- identification of supplier/subcontractor □- document reference number □- document issue □- number of sheets		
1e	"Identification of product affected" To check if set of box 2 is filled in complete and correctly.	□- model of product/number □- part number including drawing issue □- part description □- part serial number, batch and effectivity □- quantity □- product number □- for forgings, end product part number □- work/purchase order number □- assembly serial number □- assembly drawing number		Check if latest drawing issue is used. Quantity in boxes 2.5 and 3 must be identical, quantity should fit to stated serial numbers. Raise concession on part as it currently is (Assembly, sub-part, forging etc) For concessions affecting "NQF part numbers", Assembly Part numbers and how the deviation affects the end product must be informed.
1f	"Description of Non-confirmity" To check if box 3 is filled in complete and correctly.	- A clear and detailed description of the non-conformity- - To ensure that all deviations are given correctly. - To ensure that reference to previous concessions and actual item are given. - For concessions affecting "NQF part numbers", it must be informed how the deviation affects the end product.		Provide complete description (Measurements, pictures, cut-ups etc).
1g	To check if the root cause analysis and corrective actions (if identified) are given on Box 4, or that a PIR/8D is attached.			Copy/paste of the root cause from an old concession is not acceptable.
1h	To check if the responsible originator is given in box 6.			
2	General requirements			
	Checking Feature	Description	✓	Remarks
2a	Ensure all supporting documents are in English			This includes all documents, such as route cards, travellers, data cards and investigation reports.
2b	To check if assessment statements are provided with further substantiation.	Examples: - traceability calculation - understandable causes - PIR (not generic if the defect is new, or if the concession is an up-issue).		
2c	Ensure that all sent data is in good / workable quality.	Text, diagrams, photographs, pictures, sketches, CMM reports etc.		
2d	Ensure that the correct drawing issue is being used, and that non-conformances are in line with it.			The Agency often receives deviations tht are out of date, which are not in line with the current released definition (drawing or specification).

3	Geometric defects (including those affecting wall thickness)			
	Checking Feature	**Description**	**✓**	**Remarks**
3a	Provide the affected dimension	- Part number (if assembly). - Sheet and grid references. - Feature reference on drawing (if available).		
3b	Provide information of the deviation (dimensional errors supply CMM report).	- Call nominal dimension and the tolerance on the drawing, and the actual dimension found on part(s) affected. - At position tolerance, include the direction of deviation with coordinates ("X", "Y" or radial). - Provide wall thickness of the affected area. - At hole pattern, provide all measurements of the affected holes (hole pattern analysis). - Provide original CMM report as a .pdf file, or as a minimum provide a fully-readable CMM report. - Ensure that serial number(s) in the front sheet is the same as on the CMM report.		
3c	Check the exact area of the thickness deviation.	Drawing, picture, sketch.		
4	Non-conformances affecting cosmetic / surface defects			
	Checking Feature	**Description**		**Remarks**
4a	Inform the exact position of the defect on the part.	Indicate the position affected on the part drawing and on the detail view of the area.		
4b	Specify all dimensions of the defect.	- Length, width, depth (attention: defects stated as having "no depth" and/or "no width" are not acceptable and will be rejected). - state if raised material is present. If any is present, then provide dimensions.		
4c	Provide a colour picture of the defect, with scale (mandatory step).	Position of the picture taken must be clear, showing a general picture of the area that clearly identifies the location affected on the part (e.g. flange, face, casting face etc), and a detailed picture to clearly see the defect. - Any part markings are to be photographed (p/n, s/n etc).		
4d	If defect is on a functional feature, show that the funcion is not affected.	- Statement whether sealing e.g. to show if sealing surface is affected or not (show position of seal ring); show test results to demonstrate sealing is conforming. - Show the distance to close areas (e.g. bolt holes, end of flange etc).		
4e	If defect is due to handling issue, inform inspections performed.	If NDT was performed, state that such was performed and results are acceptable per spec.		
5	Salvage and reworks			
	Checking Feature	**Description**	**✓**	**Remarks**
5a	Clear description why salvage / rework is required.	- type of defect - all information must be available.		
5b	Suitable salvage plan provided by the supplier	- clear description, diagrams etc. - information must be in English. - use a standard format.		
5c	If salvage with reference number (e.g. standard process), ensure that the reference document is available for assessor.	as digital data, or scanned copies of paperwork.		
5d	Provide pictures "before" and "after" for the salvage performed (if already done).			
5e	If a welding salvage is performed, provide the welding report and data card.			
5f	If a repeat salvage, provide previous RRD concession number.			