

Notice to Suppliers



Dimensional Measurement Rounding Rules

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For the attention of the Managing Director.

Scope/Applicability:

All Rolls-Royce Civil Aerospace and Defence Aerospace suppliers

Dear Supply Partner,

A review has shown that the number of decimal places used in reporting dimensional measurement is often beyond design requirements. Rolls-Royce has released a new version of the dimensional measurement rules on rounding that are now based on the size of the feature tolerance. The rules take account of ISO14253-6 (Generalized decision rules for the acceptance and rejection of instruments and workpieces) and can be applied to all computer-controlled measurement processes.

The new rules are now available in SABRE

ACTION:

- Please download the new rules on rounding from the SABRe portal and supply to your Manufacturing Engineering teams.
- Please ensure that each member fully understands how these are to be applied.
- Retrospective application is advised where the new rules would aid throughput but is not mandated as the rules represent a “minimum required number of decimal places”. Where retrospective application is enacted – change authority rules must be followed.
- Please ensure procedures are compliant to the new standard for all new manufacturing processes.

It is vitally important that we continue to manufacture and service products that are fit for purpose and compliant to the stringent regulatory requirements we must all comply with. The new rules have been carefully chosen and tested to ensure there is no effect on design or component function.

Any questions should be raised with your Rolls-Royce Technical Authority

NTS Category:

Manufacturing Engineering

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