

Notice to Suppliers



Thermal Spray Process Minimum Standard

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Business Unit: Civil & Defence Aerospace

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For the attention of the Quality Manager and Thermal Spray Process Owner.

Scope/Applicability:

All suppliers of the thermal spray process for Rolls-Royce Aerospace programmes.

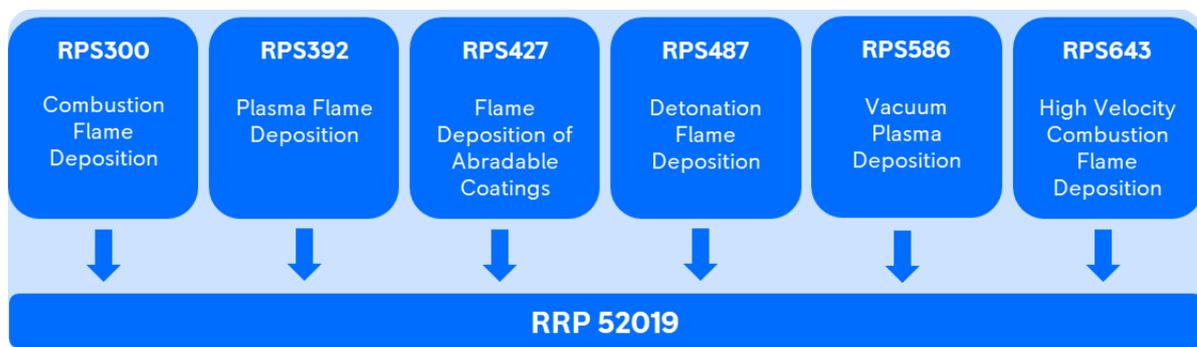
Dear Supply Partner,

Introduction:

This NTS is to formally communicate the issue of Thermal Spray Process Specification RRP52019 Revision C and supersession of: RPS300, RPS392, RPS427, RPS487, RPS586 and RPS643. Rolls-Royce Corporation (EPS) specifications are not affected at this time.

There are a number of significant differences between RRP52019 Revision C and the specifications it supersedes. Some of these differences are a result of consolidating legacy specifications and some have been necessary to address high levels of non-conformance and major quality incidents across the thermal spray supply chain.

Summary of Key Points :



RRP52019 Revision C onwards supersedes the legacy (RPS) thermal spray specifications shown above.

Suppliers have the standard 6 months from the issue date of RRP52019 revision C (in accordance with RRP50000) to comply with the process and facility requirements of RRP52019.

No new or up issued datacards to RPS300, RPS392, RPS427, RPS487, RPS586 and RPS643 will be approved from the end of November 2023 (RRP52019 only from this date). Existing process data cards to the legacy specifications listed above will need to be updated to comply with RRP52019 by the end of January 2025.

RRP52019 contains requirements and recommendations for the Finishing (i.e. machining) of coatings. Suppliers with coating Nadcap Accreditation AC7109 who perform the grinding operations of coating are required to be accredited to AC7109/8 consistent with MLC127. Machinists of coatings only are not approved to RRP52019 and not eligible for Nadcap accreditation to AC7109 or AC7109/8 hence this requirement does not apply currently.

Nadcap coatings task group (CT TG) auditors will be briefed at the October 2023 conference on the changes.

A known conflict exists with the current RPS front sheets, which may result in both CME5033 and RRQ752035 being applicable for general coating requirements, this will be addressed such that:

- The general coating requirements of RRQ752035 shall apply.
- The relevant material/component section CME5033 shall be used for drawings which state legacy specifications.
- Testing shall be in accordance with RRMS30037 unless RPS927 is specifically referenced in a coating/component specific CME.

NTS Category:

Engineering/Technical

Authorised by:

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