

Temporary Part Marking Compliance - AEM Extended

NTS Number: 211
Issue: 002
Date: May 2, 2007

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For the attention of the Managing Director and Quality Manager

Dear Sir or Madam,

Scope:

- All suppliers who provide products to Rolls-Royce Corporation.
- This document replaces a previous Notice to Suppliers (NTS 209) on the same subject.

Background:

- As a result of an investigation within Rolls-Royce Corporation it is felt appropriate to advise those suppliers with parts referencing EMS 56752 (Low Chloride and Paints-Material Marking) and/or EPS 16012 (Marking of Steel and Nickel Based Components) to pay particular attention to the method of part marking and materials utilized. (These specifications may be enacted through EDT500 section 6.3 or EDT 506 section 10.7.)
- The Advanced Engineering Memorandum (AEM ATP124371) has been **re-issued** in conjunction with revisions to the above referenced specifications to provide temporary direction on marking methods and standards. The special direction given in this AEM expires on June 15th, 2007. The appropriate section of the AEM is attached.



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Notice to Suppliers



Rolls-Royce

Temporary Part Marking Compliance - AEM Extended

Action Required:

All suppliers shall:

- In light of the serious consequences of any potential part marking non-conformances, we ask that each supplier review their part marking process, and those of their sub-tiers, to ensure the ink meets EMS 56752-C and that their application meets standard EPS 16012-B.
- Sign and return this form prior to 30 March 2007, as evidence they have reviewed their processes and are compliant.
- Fax this signed form to 317-230-2750 attn: Mary McDowell or email scanned copy to SuppQualCon@rolls-royce.com.
- Ensure all parts received by Rolls-Royce Corporation on or after June 15th meet the standards set forth in these specifications.
- If any potential part marking non-conformances are found during your investigation or if you cannot confirm compliance to the current EMS 56752-C or EPS 16012-B, please contact immediately Mary McDowell at 317-230-4434.

_____ I have read this NTS and confirm that our products are currently conforming with the attached AEM and will be conforming with EMS 56752-C and EPS 16012-B by June 15th, 2007

_____ These specifications (EMS 56752 and EPS 16012) are not applicable to our products.

Supplier Name Supplier Code

Name (printed) Signature Title Date

Submitted by:

Roger Cooper
Manager Approve and Maintain

Authorized by:

Paul Stevenson
Director, Supplier Quality



Rolls-Royce

(AEM)
ADVANCE ENGINEERING MEMORANDUM

AEM NO. ATP124371

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DEVIATION AUTHORIZATION NOTE:

1. The deviations in this AEM apply to all Rolls-Royce production/spare part drawings with either EDT 500 or EDT 506 "Explanation of Drawing Terms" specification listed as a requirement.

2. The EPS 16012 "Marking of Steel and Nickel Based Components" and EMS 56752 "Low Chloride and Paints-Material Marking" specifications are linked to EDT 500 and EDT 506 as follows:

EDT 500 states in paragraphs 6.3 and 6.3.1:

"6.3 Unspecified Marking- Additional identification marking of parts for purposes of lot verification, process verification, inspection, and/or trademarking is acceptable as follows.

6.3.1 Temporary in-process markings are permissible. Temporary in-process markings shall be per EMS 56752 requirements. In-process markings, in-process acceptance stamps, in-process NDT stamps, and "D" stamps shall be ink stamped (except for titanium items) per EPS 16012."

EDT 506 states in paragraphs 10.7 and 10.7.1:

"10.7 Unspecified Marking- Additional identification marking of parts for purposes of lot verification, process verification, inspection, and/or trademarking is acceptable as follows.

10.7.1 Temporary in-process markings are permissible. Temporary in-process markings shall be per EMS 56752 requirements. In-process markings, in-process acceptance stamps, in-process NDT stamps, and "D" stamps shall be ink stamped (except for titanium items) per EPS 16012."

This AEM authorizes a deviation to EDT 500 paragraph 6.3.1 and EDT 506 paragraph 10.7.1 to use "EMS 56752" ink in place of "EPS 16012" for in-process markings.

3. This AEM authorizes a deviation to EPS 16012 paragraph 3.2.4 to use:

" Allow ink to air dry prior to assembling parts in engine or subassembly. Optional to neutralize with deionized or distilled water."

In place of:

"After ink dries, neutralize mark by wiping with a cotton swab or clean cloth dampened with deionized or distilled water. Wipe dry with a clean cloth or swab."

4. This AEM authorizes the following deviations to EMS 56752:

In paragraph 3.1 "Chemical Composition", omit the requirement of "0.005 (Max percentage by weight) / 50ppm" ("for iron-, nickel-, and cobalt-based alloys, a maximum level of .01% or 100ppm is allowed) for Chlorides".