

Rolls-Royce Plc: Magnetic Particle Procedure EIS 901, replacing EIS 900

NTS Number: 246
Issue: 001
Date: 31 July 2008

Originator: Mike Wagner, Manager NDT Engineering
Business Unit: Operations Quality
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For the attention of: Quality Manager and Non-destructive Testing Level 3

Dear Sir or Madam,

Scope:

- All suppliers providing product to Rolls-Royce Corporation having magnetic particle inspection requirements to EIS 900 or AMS 2640.
- This document replaces a previous Notice to Suppliers (NTS 151) covering product having the requirement of AMS 2640 – Magnetic Particle Inspection.

Background:

- July 12, 2004—NTS 151 was issued in response to the cancellation of AMS 2640.
- EIS 901 was written to replace EIS 900 in order to better align processes with the fluorescent wet portions of ASTM E1444. Likewise, the additional Nadcap/aerospace requirements for magnetic particle inspection have been incorporated.
- Any questions relating to interpretation of the new requirements can be directed to Jim Graves. Phone: (317) 230-8823, (e-mail: james.e.graves@rolls-royce.com).

Action Required:

- All Rolls-Royce Corporation part numbers that have a part drawing flow down of AMS 2640 for magnetic particle inspection requirement shall now utilize Rolls-Royce Corporation specification EIS 901 (latest revision). Use EIS 901, Section 3.10.8, for accept/reject criteria if specific acceptance criteria is not referenced on the applicable blueprint.
- All Rolls-Royce Corporation part numbers that have a part drawing flow down of EIS 900 for magnetic particle inspection requirement shall now utilize Rolls-Royce Corporation specification EIS 901 (latest revision).

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- Revise all magnetic particle techniques previously developed in accordance with EIS 900 and AMS 2640 by employing the requirements of EIS 901. Keep in mind:
 - Per RPS 906, changes to an NDT Technique Instruction Card may only be made by re-issuing the technique in its entirety.
 - For Engineering Source Approved (*Fixed Process Controlled*) parts, ensure:
 - the requirements for **Engineering Controlled (EC)** processes are properly authorized in accordance with the applicable fixed process specification.
 - the documentation for **Manufacturing Engineering Controlled (MEC)** processes are properly maintained in accordance with the applicable fixed process specification.
 - Ensure the Magnetic Particle Level 3 representing your company, (*or the Quality Manager, where magnetic particle requirements are not imposed on any parts supplied by your company,*) reads, signs, and returns the attached Acknowledgement Letter to Rolls-Royce Corporation NDT department by one of the following two methods:
 - E-mail a signed, scanned copy form to: Carolyn.A.Lawry@rolls-royce.com
 - Fax a signed copy of the form to: (317) 230-2872

Correction to EIS 901 (Initial issue):

- The hole dimensions for the TP-4 Test Piece (listed in Appendix II) should be 0.040" +/- 0.001.
- The hole spacing (listed in Appendix II) of 0.0787" (2.0 mm) is incorrect. It should be 0.787" (20 mm) apart.

Additional Information:

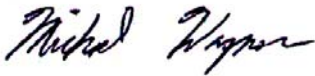
- The material used to make the TP-4 Test Piece (Listed in Appendix II) should be a low carbon steel (*up to 0.1% carbon*).
- Clarification of Inspection Sequence: When reading paragraph 3.7 of EIS 901, black oxide coating is considered an operation that could cause or reveal discontinuities. Therefore, magnetic particle inspection is required after black oxide coating.

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- The following Rolls-Royce Corporation specifications are being revised to incorporate the magnetic particle processing requirements of EIS 901:

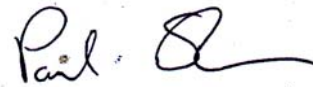
EIS 940	EIS 951	EIS 952	EIS 953
EIS 955	EIS 957	EIS 975	EIS 976
EIS 977	EIS 980	EIS 981	EIS 982
EIS 985	EIS 1000	EIS 1002	EIS 1003
EIS 1016	EIS 1017	EIS 1030	EIS 1035
EIS 1040	EIS 1042	EIS 1050	EIS 1051
EIS 1070	EIS 1092	EIS 1094	-----

Yours faithfully,
For Rolls-Royce Corporation.



Mike Wagner,
Manager, NDT Engineering

Authorised by:



Paul Stevenson
Director, Supplier Quality

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Acknowledgement of NTS:

_____ We do not provide any material that requires magnetic particle inspection.

_____ We have read this NTS and confirm that we understand the requirements of EIS 901 and will implement them immediately.

_____ Other / Reference comments below (such as: timeline for implementation).

Additional Comments / Concerns:

Supplier Name

Supplier Code

Name (Printed)

Signature

Title

Date