

Quality Clause 240807 - Rolls-Royce Indy Originated Parts Quality Requirements (08/20/18)

Subject to US export requirements, dimensional logs or inspection reports must be emailed to RRNMI.Certs@Rolls-Royce.com.

The Rolls-Royce purchase order (PO) number and Rolls-Royce part number shall be referenced in the email subject line in the following format: "Report(s) for PO XXXXXXXXXXXX Part Number YYYYYYYYYY" or "Report(s) for PO XXXXXXXXXXXX, Multiple Part Numbers".

Supplier emails with attached files must be less than 10 MB in size due to Rolls-Royce email system limitations. We recommend the email subject line format: "Report(s) for PO XXXXXXXXXXXX, Part Number YYYYYYYYYY 1st of X Emails" should multiple emails be required due to file size limitations. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.

Dimensional Requirements (08/20/18)

Unless an approved sampling plan is approved in writing by Rolls-Royce Quality one hundred percent (100%) dimensional inspection is required for each part.

The dimensional log or inspection report shall reference the following:

- 1) Supplier name and/or logo
- 2) Purchase order number, part number and revision
- 3) Quantity in the shipment (X of Y)
- 4) Serial or identification number of part(s)
- 5) Heat lot numbers of raw material if applicable
- 6) Authorized Quality approver
- 7) Recorded actual dimensions for each characteristic shown on the drawing with the correct number of significant digits
- 8) Out-of-tolerance dimensions shall be circled. Requests for waivers shall be submitted to Rolls-Royce for non-conforming dimensions.
- 9) Actual dimensions and locations referenced either by a ballooned number corresponding to the measurement on the part drawing or by the quadrant for the dimension
- 10) Individual measurements for multiple place characteristics (ranges or averages are not acceptable)
- 11) Measurements in the same units of measure as shown on the drawings or specifications

Suppliers may provide individual dimensional logs per part or may provide a spreadsheet with multiple parts, provided that each part is clearly identified in the column. The dimensional log or inspection report shall have an approved Rolls-Royce concession referenced on the log prior to non-compliant part or product shipment.

Test or Functional Procedures (08/20/18)

Suppliers will perform and provide supporting documentation for specified procedures, tests or activities. Examples of this documentation may include first article, functional, noise, pressure, electrical, non-destructive testing (NDT), weld, or leakage testing reports. Welding personnel and procedures shall be qualified in accordance with the current standard specified on the print and approved by Rolls-Royce Quality prior to welding. NDT personnel and procedures shall be qualified in accordance with the current standard specified on the print and approved by Rolls-Royce Quality prior to testing.