

Quality Clause 241202 - Valve Rod Tubing Requirements (08/23/18)

- 1) All segments to be marked with the ASTM number and heat number.
- 2) Each segment shall be marked (tagged or labeled) with the Rolls-Royce part number and purchase order (PO) number.
- 3) If required by specification referenced in the ordering data, ALL sections to be pressure and ultrasonic tested. Valve rod (V/R) tubing to be pressure tested for 1500 psi for 30 minutes. In lieu of pressure testing to 1500 psi for 30 minutes, eddy-current inspection per ASTM E 309 (or in accordance with EN10204 3.1) or flux leakage inspection per ASTM E 570 can be completed by a certified NDT Level 2 or Level 3 Inspector. Pressure testing will then be completed by Rolls-Royce at completion of V/R section. The supplier must provide test results to Rolls-Royce.
- 4) Inside and outside diameters of tube to be clean, free of foreign matter, and coated with 4FVD9 Mobilcut 100, Quaker FERROCOTE 61 MAL HCL 1 (product code 011527-11 03) or FERROCOTE EGL-1 (product code 003385-20). Both ends must be capped (Rolls-Royce part number shall appear on each cap).
- 5) Mill certification of actual chemical, physical and required testing MUST be emailed to RRNMI.Certs@Rolls-Royce.com with the PO number and part number referenced in the email subject line in the following format: "Documentation for PO XXXXXXXXXX, Part Number YYYYYYYY". Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.
- 6) Supplier shall preserve, protect, and package materials to prevent damage during transit from any elements that may affect future manufacturing steps. No rust or surface contamination is permitted.