

Engineering Control of Manufacturing Source and Method.

NTS Number: 220
Issue: 001
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For the attention of the Managing Director and Quality Manager.

Dear Sir or Madam,

Scope:

- All suppliers operating to SABRe processes in accordance with Rolls-Royce approval and purchase order requirements
- All components with a Rolls-Royce Engineering requirement for the Control of Manufacturing Source and Method.

Background:

NTS 212 advised suppliers that Rolls-Royce is moving to a global suite of specifications with the intent of harmonising and simplifying Quality Management Processes and specifications within its global businesses.

In April 2007, the first of these specifications RRES 90000 was released, replacing specifications JES 125, JES 206, JES 207 and EDS 1306. In addition, SABRe's Engineering Control of Manufacturing Source and Method process replaced SABRe Classified Parts process.

RRES 90000 introduces new terminology which may be unfamiliar to some suppliers, but the intent is as per the previous requirements i.e. a documented manufacturing method prepared by the supplier (Fixed Process Document) that is frozen and subsequently "change approved" by Rolls-Royce Engineering (i.e. Fixed Process Approval).

As a result of this change, we are beginning to receive enquiries, mainly from the UK Aerospace supply chain, with respect to the format and content of a Fixed Process Document and integration of existing Manufacturing Plans (i.e. MCPP / MSPP).

Action Required:

To minimise disturbance to their existing practices, those suppliers accustomed to using the JES system may wish to adopt the following practices:

New Parts subject to RRES 90000 as indicated on the component definition

The new specification requires a Fixed Process Document (see RRES 90000 para. 5.1.3) to be submitted, with a Fixed Process Approval Form to Rolls-Royce for authorisation. When approved, this will be revision 'baseline' of the FPD.

Any subsequent change to a feature designated "EC" (Engineering Control) will require submission of a new FPA and revised FPD.

The approved FPA, FPD and any substantiating data should be retained together in a "Fixed Process" file.

To enable changes to be tracked and to identify documentation applicable to each revision, Forms 1 and 2, appended to this NTS, may be utilised and become the lead documents in the file.

- Form 1: Fixed Process File - Change History and Revision Control.
- Form 2: Fixed Process File - Contents Page.

Existing Parts with an approved MCPP / MSPP to JES 206 / JES 207

The approved MCPP / MSPP will be recognised by Rolls-Royce as a Fixed Process Document Rev. 0 (Baseline). No further action required.

At the next requirement for change to source or method to that contained in the MSPP / MCPP, the supplier will:

- 1) Raise an FPA form and submit to Rolls-Royce together with a copy of the new Fixed Process Document.

NB: All operations will be considered as EC (i.e. subject to Engineering Control), unless component definition identifies specific processes or features.

- 2) Raise Form 1 and against FPD Revision Number 0

- i) enter the MCPP / MSPP number where indicated
- ii) under Date Approved - enter date last MCR was approved.

- 3) Raise Form 2 –

- i) in column headed REV. 0 (Baseline) enter "Refer to MCPP XXX / MSPP XXX".
- ii) in column headed REV. 1 add the FPA information related to the change.

Please cascade the content of this notification to all relevant personnel within your company - as / where necessary.

**Yours faithfully,
for Rolls-Royce plc**



**P. Latham.
MEP Leader Defence**



**M. Bathurst.
MEP – Purchase**

Authorised by:



**Lawrence Jenkins.
Global Supplier Development
& Quality Operations Director.**



SABRe: ENGINEERING CONTROL OF MANUFACTURING SOURCE AND METHOD
FIXED PROCESS FILE - CHANGE HISTORY AND REVISION CONTROL

FPD Reference:	Classification of Part: Critical / Reliability Sensitive / Unclassified *	Rolls-Royce Reference Number:
Part Number:		Part Name:

FPD Revision Number	FPA - RR reference	Description of Change	Date Approved	Date Implemented
0	N / A	<i>Baseline document (Existing MCPP / MSPP) *</i>		N / A
		Baseline document (new part) *		
1				

SABRe : ENGINEERING CONTROL OF MANUFACTURING SOURCE AND METHOD
FIXED PROCESS FILE - CONTENTS PAGE

FPD Reference:	Part Number:	Part Description:
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DOCUMENTS		REV 0 Baseline	REV 1	REV 2	REV 3	REV 4	REV 5	REV 6	REV 7	REV 8	REV 9	REV 10
1	Fixed Process Approval (FPA) forms											
2	Fixed Process Document (RRES 90000 5.1.3) Operation sequence / Method of Manufacture clearly identifying EC/MEC operations and machining parameters (feeds, speeds, depth of cut)											
3	Substantiating Data (RRES 90000 5.3.2.4)											
3a	Agreed Fixed Process Initiation Agreement (FPIA) form											
3b	Laboratory Validation Report(s) - evidence of approval :											
	Material - Casting.											
	- Forging.											
	Special processes.											
	Surface condition.											
3c	Copy of First Article Inspection Report											
3d	Copy of Quality Control Test Procedure (QCTP)											
3e	Component specific RQS / QAS - evidence of approval											
3f	Component definition drawing											
3g	Approved Condition of Supply Drawing(s)											
3h	Historical Component Proving data for CCFs											

Documents 1 & 2 are mandatory for all revisions. Documents 3 are as required by the FPA. Enter either 'Yes' or 'n/a' into the relevant cell. Any additional documents required by an FPA should be added to the bottom of this list.