

Quality Clause 240104 - Dimensional Inspection & Serialization (08/09/18)

Subject to US Export Requirements, dimensional logs or inspection reports must be emailed to [RRNMI.Certs@Rolls-Royce.com](mailto: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.

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 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)
- 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 drawing(s) or specification(s)

Supplier 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.

Parts are to be stamped or etched with the following information:

- 1) Part (drawing) number including revision level
- 2) Rolls-Royce CAGE code (07309), when required by drawing
- 3) Heat number and serial number

Information as to size and location for markings may be shown on drawings or can be obtained from Rolls-Royce QA personnel.

Supplier must request serial numbers (forgings, castings and raw material are exempt) from Rolls-Royce QA via email at [RRNMI.SerialNo@Rolls-Royce.com](mailto:RRNMI.SerialNo@Rolls-Royce.com). Supplier must have the following information available when requesting serial numbers: material heat number, quantity, Rolls-Royce purchase order number, drawing number, part name and revision level.