

Quality Clause 241701 - Paint Certification (08/24/18)

Supplier must paint per paint requirements of the drawing, any additional quality requirements, and procurement instructions. Certificates must be supplied by and marked with purchase order (PO) quantities, line items, batch lot number, part serial numbers when applicable, and 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 XXXXXXXXXXX, Part Number YYYYYYYYY". A certified process report and validation of each batch of coatings is required. QPL numbers, revision and manufacturer must be included with the certification. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables. No hard copy certifications are required to accompany the shipment.

New builds (part numbers without a VL suffix) require 10 random paint thickness readings and the results of visual inspection. Overhauls, specified by a VL suffix on the part number, require visual inspection only. Thickness readings must have the gage serial number recorded on the certification.

All non-masked surfaces on the item must be prepared and painted in accordance with the paint specification referenced on the purchase order or specification. Non-masked surfaces include wiring, tubing, handles, piping, electrical boxes, connectors, fabrications, welds, inserts, nuts, bolts, fasteners, fittings, non-plugged and threaded holes, tops, bottoms, and sides. One hundred percent (100%) paint coverage is required.

No paint defects are allowed. Examples of paint defects are as follows: runs, sags, clouding, orange peeling, foreign matter on surface, poor coverage, over-thinned coatings, flaking, wrinkling, pin holing, bleeding, loss of adhesion, external source spotting, fisheyes, blistering solvent pops or boils, loss of gloss, chalking, cracking or cratering.