

THE SOCIETY OF BRITISH AEROSPACE COMPANIES, LTD.

29, KING STREET, ST. JAMES'S, LONDON, SW1Y 6RD

DIRECTOR:  
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ENG2/3 SPS

5 April 1995

Mr J A Newnham  
Quality Assurance Director  
SPS Technologies  
TJ Brooks Division  
191 Barkby Road  
Troon Industrial Area  
Leicester LE4 7HX

Dear Mr Newnham

ATTACHED MCR

The attached MCR, forwarded under cover of your letter of 21 November 1995, has been approved by the SBAC Technical Standards Sub-Committee, subject to the proviso that the change of coolant does not affect the finished product in any way.

Yours sincerely



J W McCULLOCH  
Technical Officer

Enclosure:

MCR ref. 0207 dated 5 April 1995.



THE SOCIETY OF BRITISH AEROSPACE  
COMPANIES LTD  
29 King Street, St. James's, London SW1Y 6RD  
**MANUFACTURING CHANGE REQUEST (MCR)**

M.C.R. Ref

0207

**PART 1**

MANUFACTURERS NAME, ADDRESS AND TELEPHONE NUMBER

**DATE**

21.11.94

SPS Technologies Ltd.,  
191 Barkby Road,  
Leicester. LE4 9HX

**PART NO or MANUFACTURING SPEC**

**PART DESCRIPTION**

**PROPOSED CHANGE(S) REF:-** Supporting data, Associated part numbers, Costs  
Target date for implementation etc.

Change of coolant to Kuwait Petroleum Beethoven VNF-2 for grinding, and  
to Beethoven VHD on CNC Turning, instead of Metosol 506.

This to apply to all bolt parts to TS21, TS22, TS23, TS24, TS25 and TS145  
(i.e. HR650, Nimonic 80A, Inco 718, Waspaloy, Jethete and FV535).

Details of the coolants are attached.

**REASON FOR CHANGE(S)**

Benefits in producing the parts include better service from supplier  
(they will check coolant condition every 2 weeks), operator preference  
(less fuming and smell), less aggressive on the machine (metosol tended  
to strip paint), and about 10% less in price. For grinding, Beethoven  
VNF-2 will replace a neat oil, so there is no fire risk, and less  
tendency for grinding burns.

**MANUFACTURERS AUTHORITY: NAME**

J. A. NEWNHAM

CAPITALS

SIGNATURE

**PART 2 DESIGN AUTHORITY**

\* APPROVED / ~~NOT APPROVED~~

\* DELETE AS APPLICABLE

**DESIGN AUTHORITY SIGNATURE**

*J. McCulloch*

J. McCulloch

SBAC

29 King Street

St. James's London SW1Y 6RD

**DATE**

5 April 1995