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# Digital Thread SPS User Guide

February 2017  
V.14

**Imagination at work**

## Proprietary and Export Categories

### Technical Data: (select one only)

- License Required
- No Technical Information
- No License Required

### Proprietary Information: (select all that apply)

- GE Proprietary - Internal Use only
- GE Proprietary - Acceptable for External Use
- Non-GE Proprietary
- Non-Proprietary

### Audience Includes: (select all that apply)

- GE Non-Aviation
- Non-GE
- Non-US

Export Data	
Tagger:	P. Steiger
Jurisdiction:	N/A
ECCN/ITAR Designation:	
Export License (if applicable):	NSR

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### Export Restrictions:

This content contains no technical data and is therefore not subject to regulation

# Basics

Notes:



# Basics | Training and Access

**Training is required to obtain access to the SPS system  
for your role**

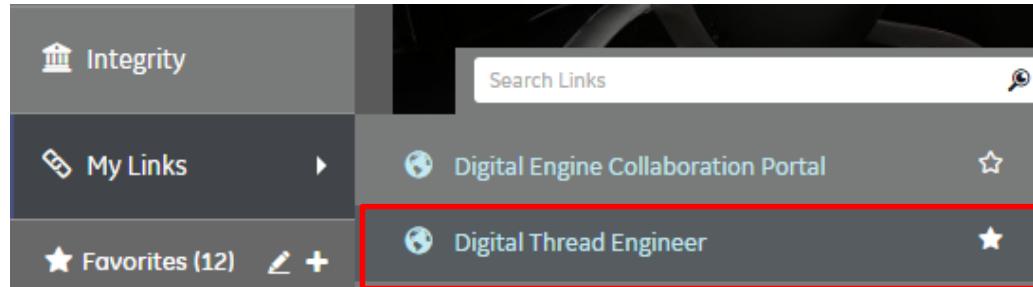
For GE users and Contractors, go to the [SPS SupportCentral site](#) to initiate the certification process and pass through the training.

For Suppliers, go to the [Supplier Support Portal](#) to initiate the certification process and pass through the training.



# Basics | Opening the Application (GE only)

From the GE Home Page, under My Links:



\*\*Vault connection required\*\*

Welcome Patrick Steiger!

My Open SPSs  Click here

SPS Name	Part Number	Source Name	State	Type	Days Open
TEST1-12346-0	TEST1	12346	Initiated	NP	21
L41009G02-TEST9-3	L41009G02	TEST9	Draft	IC	0
L41009G02-TEST9-2	L41009G02	TEST9	Draft	IC	11
L41009G02-TEST9-1	L41009G02	TEST9	Draft	PC	17
L41009G02-TEST9-0	L41009G02	TEST9	KickedOff	NP	24

My Part Info   
Add/Remove  
• Test 1

Click here to add the My Open SPSs card

Accessing this way is only applicable for GE employees in the intranet.



# Basics | Opening the Application (All users)

From SCORE, under Applications:

The screenshot shows the GE SCORE application interface. At the top, there is a navigation bar with the GE logo, the word "SCORE", and the tagline "Supply Chain Online Resource Center". To the right of the main content area, it says "Data @ your fingertips" and "Powered by GE Aviation". Below the navigation bar, there are four menu items: "Home", "Scorecard", "Applications", and "Reports". The "Applications" button is highlighted with a blue background. A dropdown menu titled "All Applications" is displayed below the "Applications" button. Inside this dropdown, the message "No Recent Applications" is shown above a blue button labeled "View All", which is outlined with a red border.

## CONFORMANCE

- ② ePCV - Planning Change Verification
- ② Special Process Codes
- ② Engineering Specifications
- ② FAA Conformity (eConformity) - Aviation
- ② FI - Farmout
- ② eCAV - Characteristic Accountability/Verification
- ② eSPR - Source Problem Reports
- ② eVSE - Vendor Substantiation Engineering
- ② Digital Thread Engineer - Significant Process Substantiation (SPS)

Click here



# Basics | Opening the Application

The screenshot shows the Digital Thread Engineer homepage at <https://digitalthread.geaviation.com/home>. The top navigation bar includes links for Home, Intelligence, Design, Quality, and Test. A search bar labeled 'FindIT' and a dropdown menu for 'NMS' are also present. On the right side, there are buttons for 'My Tasks', 'My Favorites', 'My Queries', and a user profile for 'Robert Epperson'. A red circular badge with the number '1' is positioned in the top right corner, indicating a new notification. The main content area displays a welcome message: 'Welcome Robert Epperson!' followed by the text 'You don't appear to have any cards on your Home dashboard. To add cards click the + button.'

1. Click here to access your available DTE cards Expanding cards will display details about that operation. New Digital Thread Engineer Homepage no longer has the “My Open SPSs” card available by default.



# Basics | Opening the Application

Welcome Robert Epperson!

You don't appear to have any cards assigned.

To add cards click the + button.

1. Select “My Open SPSs”.
2. Click this arrow to move it from the left list to the right. The card name should now appear on the right list
3. Click the Close button to close the module.



# Basics | Opening the Application

The screenshot shows the Digital Thread Engineer application interface. At the top, there is a navigation bar with the GE logo, the title 'Digital Thread Engineer', a search bar labeled 'FindIT', and various user navigation links like 'My Tasks', 'My Favorites', 'My Queries', and a profile for 'Patrick Steiger'. Below the navigation bar, there is a secondary header with links for 'Home', 'Intelligence', 'Design', 'Quality', and 'Test'. A welcome message 'Welcome Patrick Steiger!' is displayed. On the right side of the screen, there is a '+' button. The main content area features a card titled '1 My Open SPSs' with a red border. This card contains a table listing five SPS entries:

SPS Name	Part Number	Source Name	State	Type	Days Open
TEST1-12346-0	TEST1	12346	Initiated	NP	21
L41009G02-TEST9-3	L41009G02	TEST9	Draft	IC	0
L41009G02-TEST9-2	L41009G02	TEST9	Draft	IC	11
L41009G02-TEST9-1	L41009G02	TEST9	Draft	PC	17
L41009G02-TEST9-0	L41009G02	TEST9	KickedOff	NP	24

1. Click this card header title is an active hyperlink to take you to the SPS Homepage



# Basics | Dashboard

Digital Thread Engineer

Findit NMS

Home ?

What would you like to do?

New Part SPS

Process Change

Inadvertent Change

Part Number Conversion SPS

Concurrent Process Development

Initiate a new SPS

View/Edit Standard Requirements

Manage Reviewers

View all my SPS packages

Need Help?

Search Significant Process Substantiation [Advanced Search](#)

Search By Part Number

Search By Source

Search By Package Id

Search for an SPS package

Search

My Open SPSs

SPS Name	Part Number	Source Name	State	Type	Days Open	Notes
<a href="#">1708M21P01-BRO-3.0</a>	1708M21P01	BRO	Source Data Phase	PC	0	
<a href="#">1708M21P01-BRO-5.0</a>	1708M21P01	BRO	Source Data Phase	PC	0	
<a href="#">1708M21P01-BRO-8.0</a>	1708M21P01	BRO	Review and Acknowledgement	PC	0	
<a href="#">1708M21P01-BRO-9.0</a>	1708M21P01				0	
<a href="#">1708M21P01-BRO-4.0</a>	1708M21P01				0	
<a href="#">1708M21P01-BRO-6.0</a>	1708M21P01	BRO	Review and Acknowledgement	PC	0	
<a href="#">1708M21P01-BRO-7.0</a>	1708M21P01	BRO	Review and Acknowledgement	PC	0	

See your current open SPSs

Requirements Pending Approval

SPS Name▲	Part Number▲	Source Name	Type	Days Open	
1711M71G07-84015-10	1711M71G07	84015	PC	33	<a href="#">REVIEW</a>
1711M71G07-84015-10			PC	33	<a href="#">REVIEW</a>
1711M71G07-84015-10			PC	33	<a href="#">REVIEW</a>

Requirement Reviewer role only: See pending requirements needing review

Export Tagging Requests

▼SPS Name	Part Number	Type	Items To Be Tagged

Export Tagger role only: See quantity of untagged attachments



# Basics | Search



Search for any document (even eVSE records) by part number or by source name/code.

## Search Significant Process Substantiation [Advanced Search](#)

Search By Part Number

Search By Source

- 35489 (ELECTRO-JET TOOL CO)
- T3489 (GRC INTERNATIONAL)
- 72189 (Q-TECH)
- T2893 (CONTITECH AGES SPA)

Search By Package Id

Search

Note: Document visibility is restricted by source code

## Search Significant Process Substantiation

Search By Part Number

2474M07G01

Search By Source

EMO

Search By Package Id

Search

Select the SPS Below

▼ Part Number	Description	Source
<a href="#">2474M07G01</a>	FTC ASSY	EMO

When looking for an eVSE record, type the eVSE package ID and add “-Partnumber”

Available SPS for that part number and source combination



# Basics | Process History

Selecting a part number from the search results brings you to the process history page for that component

The screenshot shows the Digital Thread Engineer interface with the following details:

- Left Sidebar:** SPS Dashboard, Initiate SPS, Process History (selected), Include Voided SPS, Initiate Process Change.
- Search Bar:** FindIT, NMS.
- Header:** My Tasks, My Favorites, My Queries, User Profile.
- Part Number:** L41009G02-98263-13.0, BLADE, HIGH PRESSURE- TURBINE ROTOR.
- Process Changes:**
  - 1:** L41009G02-98263-21, Process Change 15.0 : VOIDED, Initiated On : 26-Oct-2016, Closed On : 15-Nov-2016, SN : 0.
  - 2:** L41009G02-98263-20, Process Change 14.0 : OPEN, Initiated On : 25-Oct-2016, SN : 0.
  - 3:** L41009G02-98263-19, Process Change 13.0 : OPEN.
- Buttons:** Expand All, Show Operation Flow, Inadvertent Change.
- List of Operations:**
  - Universal General | 98263 - SOUTHERN GEAR AND MACHINE, REV 11 - 25-Oct-2016 (highlighted by red box, circled 3).
  - General | 98263 - SOUTHERN GEAR AND MACHINE, REV 11 - 25-Oct-2016.
  - ▶ 1 | Electrochemical Marking(2) | 98263 - SOUTHERN GEAR AND MACHINE, REV 1 - 25-Oct-2016 (highlighted by red box, circled 2).
  - 2 | Electrochemical Marking | 98263 - SOUTHERN GEAR AND MACHINE, REV 3 - 25-Oct-2016.

1. Process history will show open and closed New Part, Process Change, Inadvertent, Sig ops List and Part number conversion substantiation packages
2. Expanding cards will display details about that operation 
3. Revision shows how many times that operation has been changed and the date of last change



# Basics | Process History

Selecting a part number from the search results brings you to the process history page for that component

L41009G02-98263-13.0

BLADE, HIGH PRESSURE- TURBINE ROTOR

Process Change  
98263

Universal General | 98263 - SOUTHERN GEAR AND MACHINE

General | 98263 - SOUTHERN GEAR AND MACHINE

► 1 | Electrochemical Marking(2) | 98263 - SOUTHERN GEAR AND MACHINE

2 | Electrochemical Marking | 98263 - SOUTHERN GEAR AND MACHINE

1. Each package shows initiation, closure date and status (Open, Closed, Void)
2. The package can be opened to view source data by selecting **Details Page**
3. The package being viewed is highlighted
4. For Process Changes and Inadvertent, the impacted operations are highlighted



# Basics | Process History

Selecting a part number from the search results brings you to the process history page for that component

L41009G02-98263-13.0

BLADE, HIGH PRESSURE- TURBINE ROTOR

Process Change  
98263

[Details Page](#)

Include Voided SPS

[Initiate Process Change](#)

**L41009G02-98263-21**

Process Change 15.0 : VOIDED  
Initiated On : 26-Oct-2016  
Closed On : 15-Nov-2016

[SN : 0](#)

**L41009G02-98263-20**

Process Change 14.0 : OPEN  
Initiated On : 25-Oct-2016

[SN : 0](#)

**L41009G02-98263-19**

Process Change 13.0 : OPEN

[① Help](#)

Universal General | 98263 - SOUTHERN GEAR AND MACHINE REV 11 - 25-Oct-2016

General | 98263 - SOUTHERN GEAR AND MACHINE REV 11 - 25-Oct-2016

► 1 | Electrochemical Marking(2) | 98263 - SOUTHERN GEAR AND MACHINE REV 1 - 25-Oct-2016

2 | Electrochemical Marking | 98263 - SOUTHERN GEAR AND MACHINE REV 3 - 25-Oct-2016

▼ Expand All

Show Operation Flow

Inadvertent Change

1. You can change the process history display by enabling the “Include Void SPS” toggle button
2. You can view the current workflow by clicking the “Show operation flow” button
3. Help button is here!



# Basics | Archived eVSE Records

All closed and voided eVSE records are accessible through SPS after a data migration.

The screenshot shows the Digital Thread Engineer interface. On the left, a sidebar lists 'SPS Dashboard', 'Initiate SPS', 'Process History' (which is expanded), 'Include Voided SPS' (with a green button 'Initiate Process Change'), and a blue box containing part information: 'ALB-VSE-09-00338-TEST1M44', 'New Part : LEGACY VOIDED', 'Initiated On : 20-May-2016', 'Closed On : 20-Jan-2009', and 'SN : 3'. A red circle labeled '1' points to the 'Process History' section. A red circle labeled '2' points to the main content area where 'TEST1M44-ALB-0.0' is displayed with options like 'See Drawing', 'New Part', 'ALB', and 'Details Page'. A red circle labeled '3' points to the bottom of the sidebar. The main content area also includes a '▼Expand All' button, a 'Show Operation Flow' button, and a green 'Inadvertent Change' button. At the bottom, it says 'VSE General | ALB - ALBUQUERQUE' and 'REV 0 - 20-May-2016'.

1. Link to source data files for this eVSE record
2. All requirements and data categorized as “General” for eVSE records
3. List of all eVSE records for this Part-Source combination



# Basics | Help Resources

## Support Central (GE User link):

[http://supportcentral.ge.com/products/sup\\_products.asp?prod\\_id=380855](http://supportcentral.ge.com/products/sup_products.asp?prod_id=380855)

- FAQ
- User Guide
- Policy and Procedure list
- Link to Quality University
- Certification Process to obtain access

## Supplier Support Portal (Non-GE User link)

[http://supportcentral.ge.com/products/sup\\_products.asp?prod\\_id=268881](http://supportcentral.ge.com/products/sup_products.asp?prod_id=268881)

Look under SPS – Significant Process Substantiation

## Contacts:

Cody Epperson (Functional Owner)

Email: [Aviation.sps@ge.com](mailto:Aviation.sps@ge.com)



# Process Map

Note:

These process maps give each role direction on their responsibilities on each page



# Source Contact (Representative at source)

## Functions:

### SPS Home Page

- Search for a new SPS or migrated eVSE record
- Initiate New Part\*, Process Change, Inadvertent, Process Change (Rework), Part Number Conversion, or Administrative

### Requirements

- Work with Engineering to identify significant processes
- Define manufacturing sequence
- Identify sub-tier suppliers (optional – not always appropriate for suppliers)

### Acknowledgement

- Indicate you understand the significant processes, sequence, requirements, milestones, risks, and timing expectations

### Source Data

### SN Release

- Provide source data in the desired format and against the appropriate requirement
- Provide Serial or Lot Numbers for hardware that meets all requirements

### Package closure

- No responsibilities in this page

### Export Tagging

- If qualified, apply export classifications to attachments

\* For Suppliers, refer to S-1001 for guidelines on New Part initiation



# GE Quality Engineer

## Functions:

### SPS Home Page

- Search for a new SPS or migrated eVSE record
- Initiate New Part, Process Change, Inadvertent, Process Change (Rework), Part Number Conversion, or Administrative

### Requirements

- Work with source to identify significant processes
- Ensure correct usage of sub-tier supplier functionality
- Link user-entered operations to standard operations
- Verify requirements are appropriate and reasonable

### Acknowledgement

- Indicate you understand the significant processes, sequence, requirements, milestones, risks, and timing expectations

### Source Data

### SN Release

- Review source data to verify it has been provided in the desired format and is listed against the appropriate requirement
- Provide Serial or Lot Number approval for hardware that meets all requirements

### Package closure

- Provide Full Approval or SN Closure when appropriate

### Export Tagging

- If qualified, apply export classifications to attachments



# GE Design and Materials Engineering

## Functions:

### SPS Home Page

- Search for a new SPS or migrated eVSE record

### Requirements

- Work with source to identify significant processes
- Link user-entered operations to standard operations
- Verify requirements are appropriate and reasonable
- Modify requirements as needed and consult with requirement reviewers

### Acknowledgement

- Indicate you understand the significant processes, sequence, requirements, milestones, risks, and timing expectations

### Source Data

### SN Release

- Review acceptability of source data for each requirement
- Provide Serial or Lot Number approval for hardware that meets all requirements

### Package closure

- Provide Full Approval or SN Closure when appropriate

### Export Tagging

- If qualified, apply export classifications to attachments



# Significant Operations List

Note:

- **This is for the source that makes the part complete only – not sub-tiers**
- This is the core of SPS – the part “recipe”
- All migrated VSEs must have a Significant Operations List assigned before full SPS application functionality becomes available
- If there is a sub-tier, the prime source needs to set them up.
- Significant Operations Lists can be created by any function/role and must be approved by a Quality Engineer
- Shortened here as Sig Ops List going forward



[Click here to download Sig](#)  
[Ops List instructions](#)



# New Complete Part at Source

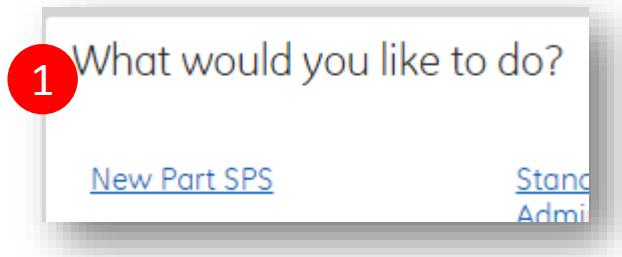
## - Initiation

### Notes:

- Use all SPS types in accordance with S-003 and S-1001 only
- “Source Change” type no longer exists – use New Part type
- The *New Part Reason* field cannot be seen by suppliers but sensitive information **should not** be added here



# New Complete Part at Source | Initiation



Part Information

Part Number *	<input type="text" value="1708M21P10"/> <span style="border: 2px solid red; padding: 2px;">2</span>	Add + <span style="border: 2px solid red; border-radius: 50%; padding: 5px; margin-left: 10px;">3</span>
Part Description	BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2	
Commodity *	Turbine Airfoils	
Part Family *	Turbine Blade, Cooled	
Engine Program	GE90	
New Part Reason *	New part at source... or source change from, to...	

This is not a military-controlled part.

4 New Part Reason \*

Cancel Next

1. Select “New Part SPS”
2. Fill out Part Information

- Part number will validate against DWB
- System will detect if part is military controlled

3. Add additional Part Numbers if the parts are made at the same source, have the same significant operations, and can be approved together. More PNs can be selected after the Part family and commodity have been selected.

4. Indicate if source change or alternate source in “New Part Reason”. This field is not visible to Suppliers but do not enter sensitive information here.



# New Complete Part at Source | Initiation

## New Part: Add Part Numbers

Copy & paste the list of part numbers into the text box below. These will be verified in the next page.

Part Number
17Q8M21P11
17Q8M21P12
17Q8M21P14
17Q8M21P15
17Q8M21P16
17Q8M21P17
17Q8M21P20

1

CANCEL

NEXT

1. Add additional part numbers and click NEXT. Part numbers will be validated to verify they are active in Digital Work bench
2. NOTE you can also add additional part numbers in the Details page



# New Complete Part at Source | Initiation

New Part:  
Add Part Numbers

Add one or more part numbers to this New Part workflow. Parts should only be added if they share the same source(s), significant operations and manufacturing process.

<input checked="" type="checkbox"/>	Part Number	Description	Engine Program	Comments
<input checked="" type="checkbox"/>	1708M21P02	BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2	GE90	Valid Part Number

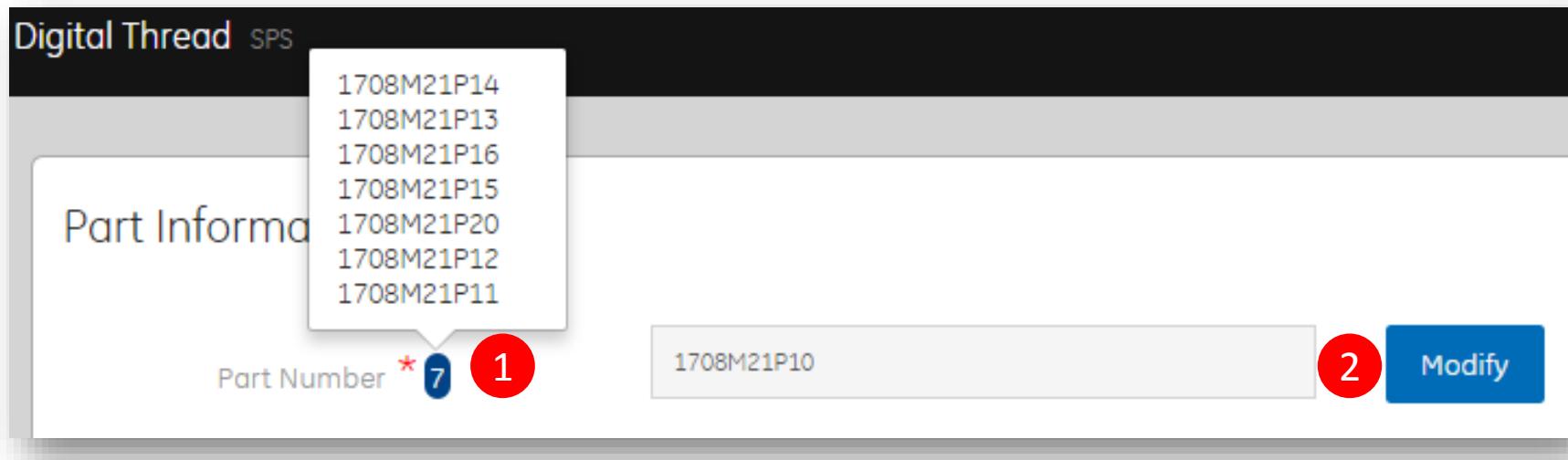
**1** CANCEL **2** OK

This list shows the list of validated part numbers entered on the previous page

1. Select the validated Part Numbers to add to the SPS package
2. Select OK when complete to return to the SPS initiation



# New Complete Part at Source | Initiation



1. Added Part Numbers are shown as a quantity and hovering over with the mouse will show the Part Number list
2. Click MODIFY to make edits to the Part Number list – this can also be done later
3. Click NEXT to go to the Source Information page



# New Complete Part at Source | Initiation

1

## Source Information



This SPS will be sent to the tagging focal when the SPS is submitted.

X

Source Code \*

STR

Source Description

STROTHER

Value Stream

PRODUCT DLVRY & DVLPMNT

2

Sponsor Source Code

Optional

Sponsor Source Description

Back

Cancel

Next

1. Fill out Source Information - Source will autofill based on GE Yellow Page directory
2. If this is a sponsor SPS, add the sponsor source code here



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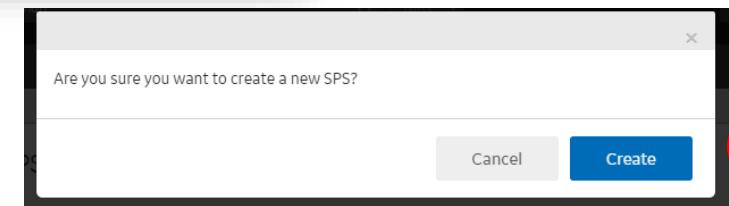
GE Aviation

# New Complete Part at Source | Initiation

1 SPS APPROVAL TEAM

BUYER	<input type="text" value="Select a Buyer in the list or search his name/s..."/>	3
2 QUALITY ENGINEER *	<input type="text" value="Select a Quality Engineer in the list or search ..."/>	
DESIGN ENGINEER	<input type="text" value="Select a Design Engineer in the list or search h..."/>	
MATERIALS APPLICATION ENGINEER	<input type="text" value="Select a Design Engineer in the list or search h..."/>	
SOURCE CONTACT	<input type="text" value="Select a Source Contact in the list or search h..."/>	
EXPORT TAGGING FOCAL	<input type="text" value="Select an Export Tagging Focal in the list or se..."/>	

BACK CANCEL REVIEW 4



1. Add team members that will work the document

2. Quality Engineer is the only required field at this point

3. If appropriate, the BUYER field can be made “Not Applicable”

Note: They SPS will be created in a DRAFT state until all the team members have been identified

4. Click Review and then Create to be able to create the SPS and be able to see the details of the information provided



# New Complete Part at Source | Initiation

**Caution** - Use or disclosure of the data on this page is subject to the restrictions defined in the export control section of this document.

1708M21P01-BRO-0.0 1

BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
SPS Type: New Part  
Source: BRO-BROMONT  
Status: OPEN

[View Process History](#)

[View eCAV Data](#)

[View Drawing](#)

[View Specification](#)

[Download Attachments](#)

2

**Submit**

## • SPS Approval Team

Buyer

Not Applicable

Quality Engineer

Carlota Vazquez

Email: carlota.vazquez@ge.com, Phone:null

Design Engineer

Patrick Steiger

Email: Patrick.Steiger@ge.com, Phone:null

1

Materials Application Engineer

Robert Epperson

Email: robert.epperson@ge.com, Phone:null

Source Contact

Jerin Chacko

Email: Jerin.Chacko@ge.com, Phone:null

Export Tagging Focal

Patrick Steiger

Email: Patrick.Steiger@ge.com, Phone:null

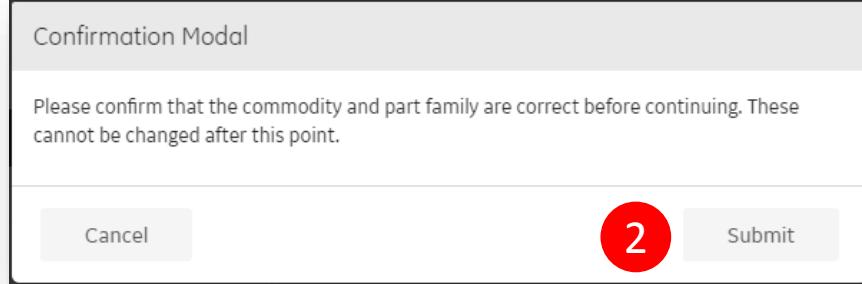
**Void**

- Once all the team members have been placed the **GE quality engineer** will be able to submit the SPS New part package to the initiated state (top right corner)
- by clicking submit on the top of the page.



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1. The Quality engineer will have to confirm the Part family and Commodity previously selected are correct.  
**After clicking submit, the part family can be changed while the SPS is in the Initiated state, before the acknowledgment.**



# Details Page

## Notes:

- View part information, view source information, view or edit approval team members, and use void button here
- View and edit additional Part Numbers here (Only applicable for New part workflow)
- SPS users not on the approval team have “read only” access
- All SPS users can change approval team members



# New Complete Part at Source | Initiation

SPS Dashboard

Initiate SPS

2010M42P02-TEST9-0.0

Details

Export Tagging

Process History

**Caution** - Use or disclosure of the data on this page is subject to the restrictions defined in the export control section of this document.

2010M42P02-TEST9-0.0  
BLADE, HIGH PRESSURE TURBINE ROTOR - STG 1  
SPS Type: New Part  
Source: TEST9-TEST9  
Status: OPEN

[View eCAV Data](#)  
[View Drawing](#)  
[View Specification](#)

[Download Attachments](#)

[View Process History](#)

4 [Submit](#)

1

Part Information

2

Additional Parts

3

Source Information

Reason

SPS Approval Team

Void

?

Help

1. Review Part Information and additional Part Numbers (expand or collapse field)
2. Review Source Information (expand or collapse field)
3. Review and complete approval team (expand or collapse field)
  - All team members must be entered before proceeding. Buyer may be “Not Applicable”
4. Once all team members are complete your GE quality engineer is able to submit to the next stage



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# New part - Multiple Parts

Note:

- Multiple parts can be added to different SPS types, in this section we will cover only the New part workflow
- Parts should be done at the same Source
- Part shall be compatible in SPECS



# Multiple Parts | New Part

## New Part details:

SPS Dashboard

Caution - Use or disclosure of the data on this page is subject to the restrictions defined in the export control section of this document.

Initiate SPS

2100M15P01-46703-0.0 6

SPS Type: New Part  
Source: 46703-HOWMET LAPORTE DIVISION (HLC)  
Status: Pending Quality Approval

View eCAV Data  
View Drawing  
View Specification

Export GT7350 Download Attachments

Details

View Process History

Process History

Part Information

Additional Parts 1

#	Part Number	Description	Engine Program
1	1708M21P03	BLADE,HIGH PRESSURETURBINE ROTOR-STAGE 2	GE90
2	1708M21P02	BLADE,HIGH PRESSURETURBINE ROTOR-STAGE 2	GE90
3	1708M21P05	BLADE,HIGH PRESSURETURBINE ROTOR-STAGE 2	GE90

Add Remove Remove And Create New

2 3 4

1. View additional parts
2. Add more parts
3. Remove selected parts
4. Remove selected parts and separate to a new SPS



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# New part - Multi-part Editing

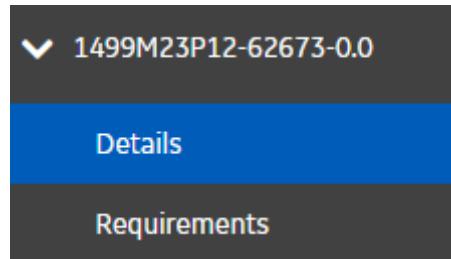
## Notes:

- Part numbers can be added at any time before acknowledgement
- Part numbers can be removed at any time before acknowledgement
- Removing part numbers can be done in two ways
  - 1) Remove: this voids the package for that Part Number only
  - 2) Remove and Create New: This removes the Part Number and creates an independent New Part SPS for it



# Details Page | Multi-part Editing

Remove a part number:



## ▼ Additional Parts

	Part Number	Description	Engine Program
<input type="checkbox"/>	1499M23P11	BLADE, HIGH PRESSURE TURBINE ROTOR	F118, F101
<input checked="" type="checkbox"/>	2 1499M23P10	BLADE, HIGH PRESSURE TURBINE ROTOR	F110
<input type="checkbox"/>	1499M23P09	BLADE, HIGH PRESSURE TURBINE ROTOR	F118, F110

Add Remove Remove And Create New  
3

1. Go to the SPS details tab
2. Select part number(s) to remove
3. Select REMOVE to remove the Part Number from this SPS
4. Select REMOVE AND CREATE NEW to move the Part Number to its own SPS

You will remove this part number from the group SPS and create an individual record.

REMOVE AND CREATE NEW



# Details Page | Multi-part Editing

Add a part number:

## Additional Parts

	Part Number	Description	Engine Program
<input type="checkbox"/>	1499M23P11	BLADE, HIGH PRESSURE TURBINE ROTOR	F118, F101
<input checked="" type="checkbox"/>	1499M23P10	BLADE, HIGH PRESSURE TURBINE ROTOR	F110
<input type="checkbox"/>	1499M23P09	BLADE, HIGH PRESSURE TURBINE ROTOR	F118, F110

1 Add Remove Remove And Create New

Part Number  
1499M23P09

2

New Part:  
Add Part Numbers

Add one or more part numbers to this New Part workflow. Parts should only be added if they share the same source(s), significant operations and manufacturing process.

	Part Number	Description	Engine Program	Comments
<input type="checkbox"/>	1499M23P09			Part Number already Exists

CANCEL OK



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GE Aviation

# Engineer Opt-Out

## Notes:

- Either the MAE or the Design Engineer can opt out of the package, but not both
- By opting out, the engineer is indicating that he/she has reviewed the details and has determined that his/her signature is not required for the subject significant process substantiation package



# New Complete Part at Source | Opt Out

1. Design engineer opt-out button 

2. MAE opt-out button (only visible to user in role)

## ▼ SPS Approval Team

Buyer	Not Applicable	
Quo	You can choose to opt-out of this package as an approver.	
Design Engineer 	Patrick Steiger	Email: Patrick.Steiger@ge.com, Phone:null
Materials Application Engineer 	Carlota Vazquez	Email: carlota.vazquez@ge.com, Phone:null
Source Contact	Robert Epperson	Email: robert.epperson@ge.com, Phone:null
Export Tagging Focal	Jerin Chacko	Email: Jerin.Chacko@ge.com, Phone:null
	Patrick Steiger	Email: Patrick.Steiger@ge.com, Phone:null



# New Complete Part at Source | Opt Out

OPT-OUT X

1 By opting out, you are indicating that evaluation by the Design Engineer function is not required to approve this SPS (Including SN release). This does not re-assign the SPS to another Design Engineer. Do you confirm?

Cancel OK

▼ SPS Approval Team

Buyer	Robert Epperson	Email: robert.epperson@ge.com, Phone:null
Quality Engineer *	Patrick Steiger	Email: Patrick.Steiger@ge.com, Phone:null
2 Design Engineer +	Jerin Chacko This function is not required for approvals in this SPS.	Email: Jerin.Chacko@ge.com, Phone:null
Materials Application Engineer	Carlota Vazquez	Email: Tst32@test.ge.com, Phone:null
Source Contact	Patrick Steiger	Email: Patrick.Steiger@ge.com, Phone:null
Export Tagging Focal	Carlota Vazquez	Email: Tst32@test.ge.com, Phone:null

Void Save 3

1. Confirm that your role is not required to approve the SPS – select OK
2. Function marked as not required for approvals in SPS; Opt back in by selecting the “+”



# Requirements Tab

Related Article: [Forget What you think you know about the requirements page...](#)

Enablers:

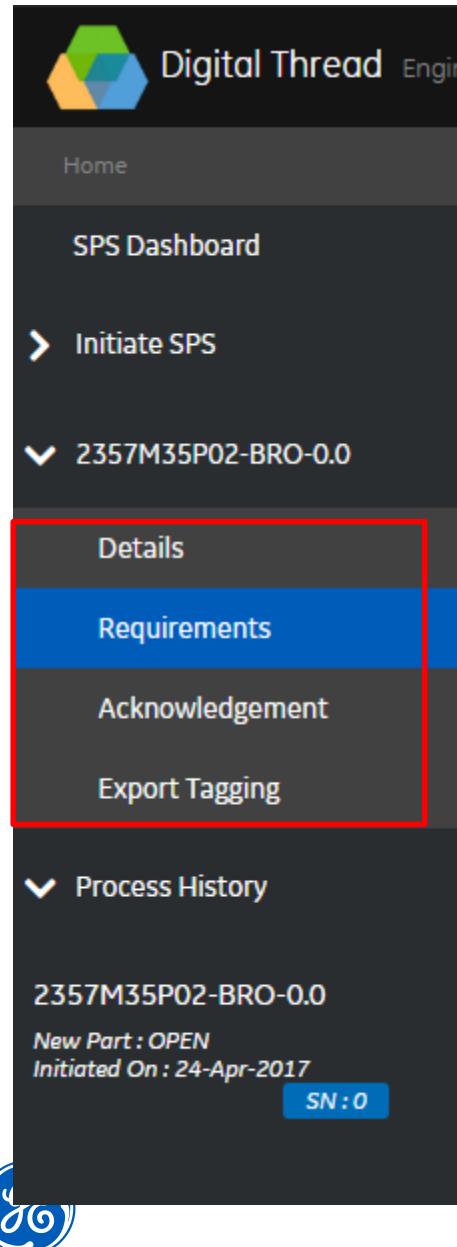
- Details page complete (all team members assigned) and after the

Notes:

- The Source is responsible for providing the manufacturing process and sequence
- Design Engineering, MAE, and Quality Engineer are responsible for evaluating the requirements and editing them if necessary



# Requirements



1. Requirements, Acknowledgment, and Export Tagging pages are enabled after the New part (or any other workflow) has been submitted by GE quality engineer
2. Review standard requirements tab

# Requirements | Page structure

1708M21P26-44567-0.0 3  
BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
SPS Type: New Part  
Source: 44567-MESOTEC INC  
Status: OPEN  
[View Process History](#)

[View eCavData](#) [View Drawing](#) [View Specification](#) [Download Attachments](#)

[Show Operation Flow](#) [Add Operation](#) [Add Subcomponent](#) [Reorder](#)

General | 44567 [Options](#)

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Bonding | 44567 | Sequence # [Options](#) 3

Operation description

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process? [Yes](#) [No](#) 2

Diffusion Coating | 44567 | Sequence # [Options](#)

Operation description [Options](#) 4

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process? [Yes](#) [No](#)

1. If an operation is not used it can be deleted (Options -> Delete operation) by anybody in the approval team
2. See "[Farmout/OV Supplier](#)" section
3. Add a sequence number or the operation number from the router (if known)
4. Add operation description (if known)



# Requirements | Copy Operation

SPS Dashboard

Initiate SPS

1499M23P11-T9354-0.0

Details

Requirements

Acknowledgement

Export Tagging

Process History

1499M23P11-T9354-0.0  
BLADE, HIGH PRESSURE TURBINE ROTOR  
SPS Type: New Part  
Source: T9354-GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC  
Status: OPEN

[View eCavData](#)  
[View Drawing](#)  
[View Specification](#)

[Download Attachments](#)

[View Process History](#)

Show Operation Flow   Add Operation   Add Subcomponent   Reorder

General | T9354

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Chemical Cleaning | T9354 | Sequence # 15

Operation description: Chem cleaning after edm

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process?  Yes  No

Options

Copy Operation

Delete Operation

Edit Requirements

Mark as Rework

Define Alternate Path

Assign Subcomponent

1. Select “Options” if the operation is performed twice
2. Select “Copy Operation” to duplicate the operation card



# Requirements | View

SPS Dashboard

Initiate SPS

1499M23P11-T9354-0.0

BLADE, HIGH PRESSURE TURBINE ROTOR  
SPS Type: New Part  
Source: T9354-GENERAL GEAR-DIVISION OF GENERAL DONLEE  
CANADA INC  
Status: OPEN

[View eCavData](#)  
[View Drawing](#)  
[View Specification](#)

[Download Attachments](#)

[View Process History](#)

Details

Requirements

Acknowledgement

Export Tagging

Process History

Show Operation Flow Add Operation Add Subcomponent Reorder

1 ▾ Chemical Cleaning | T9354 | Sequence # 15 Options

Operation description Chem cleaning after edm

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process? Yes No

Requirements

Chemical Cleaning	Provide copy of Technical Plan, Operation Sheet or Process Control Document with significant processes identified. The technical plan must include a summary of the change history and show approvals by supplier and GE Aviation certifying agent.	Qty Required:
Technical Plan		
Generic Template:	<a href="#">Add</a>	Source Data Template: <a href="#">Drag &amp; drop or Browse</a>
Acceptance Criteria:	<a href="#">Drag &amp; drop or Browse</a>	Part Specific Template: <a href="#">Drag &amp; drop or Browse</a>

Chemical Cleaning	Fill out attached template with operating parameters	Qty Required:
Operating Parameters		
Generic Template:	<a href="#">Add</a>	Source Data Template: <a href="#">Drag &amp; drop or Browse</a>
Acceptance Criteria:	<a href="#">Drag &amp; drop or Browse</a>	Part Specific Template: <a href="#">Drag &amp; drop or Browse</a>

1. click Drop down button to expand requirements



This step can  
only be done by  
GE DE/QE/MAE

# Requirements | Review Reqs.

Chemical Cleaning | T9354 | Sequence # 15

Options ▾

Operation description

Chem cleaning after edm

**i** To remove operations, you must now delete them using the Options menu at the top right corner of the operation card. X

**i** Add a sub-tier supplier for this process? Yes No

## Requirements

Chemical Cleaning  
Technical Plan

Provide copy of Technical Plan, Operation Sheet or Process Control Document with significant processes identified. The technical plan must include a summary of the change history and show approvals by supplier and GE Aviation certifying agent.

Qty Required:

1

Generic Template: Add

Source Data Template: Drag & drop or Browse

3

Acceptance Criteria: Drag & drop or Browse

Part Specific Template: Drag & drop or Browse

2

## Review requirements

1. Add data templates (optional – viewable by source)
2. Add acceptance criteria (optional – not viewable by source)
3. Specify a certain format for the data to be provided by the supplier

Related Article: [Avoiding Requirement Review \(1 over 1 Approval\)](#)



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# Requirement Editing

## Enablers:

- Available to GE Design Engineer, MAE, and Quality Engineer role only
- Depending on change, edits are subject to review by a Requirement Reviewer. Refer to the Engineering Handbook, Section 6.1.3 for more information

[Link to Engineering Handbook](#)



# Requirements | Requirement Editing

Electrical Discharge Machining (EDM) - Wire | TEST9 | Sequence #

Operation description

Add a sub-tier supplier for this process?  Yes  No

**Requirements**

**Edit Requirements for EDM - Electrical Discharge Machining**

All text added below should be non-technical. Technical data can be included in the attachments.

Adding, editing, or removing standard requirements may invoke review by an SPS approved requirement owner. New or modified requirements should be written such that they can apply to the entire part family or all parts subjected to a given specification. !

Requirements	Description	Qty	Specification	Action
Feature Form Photos	Submit photographs of feature form, including a scale for measurement reference. Text change	3		

**Close** **Add**

1. Under “Options” - Select “Edit Requirements”
2. Use Action buttons to remove edit e requirement
3. Select ADD to create a new requirement



# Requirements | Requirement Editing

Edit existing requirement

## Edit Requirements for Electrical Discharge Machining (EDM) – Wire

All text added below should be non-technical, but Technical data can be included in the attachments.

**Basic**

Commodity*	Part Family*	Operation
ALL	ALL	Electrical Discharge Machining (EDM)
Requirement Name*	Specification	
Process Sheets	GSSE	
Requirement Description*	Quantity Required	
Provide copy of technical plan with significant processes identified. The technical plan must include a summary of the change history and show approvals by supplier and GE Aviation certifying agent.	0	
198/4000	DAN Code*	

1      2      3

**Buttons:** Close, Back, Next

1. Make edits to requirement name, description, or quantity
2. Enter DAN Code for requirement reviewer. This should be the engine program charge number.
3. Select NEXT



# Requirements | Requirement Editing

Edit Requirements for Electrical Discharge Machining (EDM) – Wire

**Attachments**

File Type	Browse/Upload	File Type	Browse/Upload
Generic Template	<input type="button" value="Browse..."/> Drag and Drop file(s) here	Source Data Template	<input type="button" value="Browse..."/> Drag and Drop file(s) here
Part Specific Template	<input type="button" value="Browse..."/> Drag and Drop file(s) here	Acceptance Criteria	<input type="button" value="Browse..."/> Drag and Drop file(s) here

**Product Info**

Specify whether the requirement is specific to a part(s) or should be leveraged across the part family and/or commodity and/or specification.\*

Please provide a recommendation of the scope of the requirement change.

Why are you adding/editing the requirement?\*

Please provide a reason.

1. Add a template or acceptance criteria for the requirement
2. Describe when the requirement should be automatically loaded in
3. Justify the edit to the requirement
4. Submit to reviewer



# Requirement Refreshing

Go here



# Add Significant Operation

Enablers:

- Available to Source, Design Engineer, MAE, and Quality Engineer role
- Add operation can be done in a Sig ops list in the details tab, when a Process change\* is initiated and in the requirements tab of a New Part and an a Part number conversion workflow.

\*Note: for multipart add operation go [here](#)



# Requirements | Add a Standard Operation

The screenshot shows the GE SPS Dashboard interface. On the left, a sidebar lists navigation options: SPS Dashboard, Initiate SPS, 1708M21P01-BRO-0.0 (selected), Details, Requirements (highlighted in blue), Acknowledgement, and Export Tagging. The main content area displays a requirement card for '1708M21P01-BRO-0.0 1' with details: BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2, SPS Type: New Part, Source: BRO-BROMONT, Status: OPEN. It includes links for View eCAV Data, View Drawing, View Specification, and Download Attachments. Below the card is a 'View Process History' link. A red circle labeled '1' highlights the 'Add Operation' button in the top navigation bar of the main content area. A modal window titled 'Add Operation' is open, containing a search bar 'Search for Standard Operations:' and a table with columns 'Operation' and 'Specification Number'. The table lists five rows: GSSE, P17TF1, P29TF73, and S232. A red circle labeled '4' is over the row for P17TF1. A red circle labeled '2' highlights the search input field in a dropdown menu. The dropdown menu lists several operations, with 'Electrical Discharge Machining (EDM) – Hole Drilling' highlighted in blue. A red circle labeled '3' is over this highlighted item. At the bottom of the modal, there's a question 'Do you need to add a new operation to the list above? Define the proposed operation name below:' followed by radio buttons for 'Yes' and 'No'. Red circles labeled '5' are over the 'Cancel' and 'Ok' buttons.

1. To add an operation, select the “Add Operation” button at the bottom of the requirements page
2. Use the search box to search for a process by typing the name or searching by specification
3. Select the appropriate operation name
4. Select the appropriate specification in the results table
5. Select “OK”



# Requirements | Add a NON-Standard Operation

The screenshot shows the SPS Dashboard interface. At the top, there's a header with the part number "1708M21P01-BRO-0.0.1" and a description: "BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2". Below the header are links for "View eCAV Data", "View Drawing", and "View Specification", along with a "Download Attachments" button. On the left sidebar, under the "Requirements" section, the "Add Operation" button is highlighted with a red circle labeled "1". The main content area is titled "Add Operation" and contains a search bar for standard operations. A large blue callout box with a white border and a black border contains the text: "Contact [Aviation.SPS@ge.com](mailto:Aviation.SPS@ge.com) to arrange for new standard operations to be added to SPS". Below the search bar, there's a note: "Can't find the operations above? Describe the proposed operation below." A form field for "Operation Name" is shown with a red circle labeled "2" over it. At the bottom right of the dialog are "Cancel" and "Ok" buttons, with a red circle labeled "3" over the "Ok" button.

1. To add an non-standard operation, select the “Add Operation” button at the top of the page
2. If the operation is not listed, add a new standard process name:
3. Select “OK”



# Requirements | Link a NON-Standard Operation

This is only available for older packages if the operation was added manually. This is not applicable to packages created after 8/1/17

The screenshot shows a software interface for managing requirements. At the top, there is a header with a red circle containing the number '1'. Below it, a row of buttons includes 'Shot Peen on root' (with a right arrow), 'STR', 'Sequence #', a dropdown menu, and a blue 'Link' button. To the right of the 'Link' button is a red circle containing the number '2'. A vertical red arrow points upwards from a yellow callout box to the 'Link' button. On the far right, a green 'Options' button has a dropdown menu with five items: 'Copy Operation', 'Delete Operation', 'Edit Requirements' (which is highlighted with a red circle containing the number '3'), 'Mark as Rework', and 'Define Alternate Path'. In the center, there is a light blue panel with the text 'Add a sub-tier supplier for this process?' followed by 'Yes' and 'No' buttons. A red arrow points from the 'Edit Requirements' menu item to this panel.

1 Shot Peen on root | STR | Sequence #  2

Operation description

Add a sub-tier supplier for this process? [?](#)

Yes No

Options ▾

- Copy Operation
- Delete Operation
- Edit Requirements
- Mark as Rework
- Define Alternate Path

This function only available to Design, MAE, and GE Quality

Adding a custom process name:

1. The new operation now appears in the requirements page
2. Non standard operations should be linked to a standard operation. To do so, click "Link"
3. If the operation does not exist in the SRD, then continue by using "Edit Requirements" to add requirements



# Requirements | Add a NON-Standard Operation

This is only available for older packages if the operation was added manually. This is not applicable to packages created after 8/1/17

Linking to a standard operation...

**Add Operation**

Please add requirements Manually X

User Entered Requirements Will Not Be Available In Future Process Changes Unless They Are Added To The Standard Requirements Database.

1 Is This Operation Associated With A Specification? \*  Yes  No

Specification Number  Q

Please Choose The Intended Operation:

	Spec	Operation
<span style="border: 1px solid red; border-radius: 50%; padding: 2px 5px;">2</span>	P17TF2	Laser Drilling or Cutting

If the new operation is not associated with a GE specification, requirements will have to be added manually.

Cancel 4 Ok



# Adding Sub-tier Supplier

Enablers:

- Toggle available in operation card
- Source code validates against GE Aviation Source Yellow Pages
- Source Contact validates against list of approved source contact users
- Sub-tier operations will not be visible to Suppliers once they are enabled  
(QE can disable them)
- **Optional functionality**



# Requirements | Add a sub-tier

To assign an operation to a farm-out source (sub-tier):

Creep Feed Grinding (CFG) | 12346 | Sequence # 10 | Options

Operation description

**1** To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

**1** Add a sub-tier supplier for this process? Yes No

**2** Supplier source code: STR

**3** Supplier source description: STROTHER

**3** Supplier source contact: Jerin Chacko

**4** Ok

1. Indicate that the operation is a farm-out/sub-tier operation by selecting “Yes”
2. Enter farm-out/sub-tier source code or the name of the farm-out (validated by GE Yellow Pages)
3. Enter farm-out/sub-tier source contact
4. Select “OK”



# Requirements | Add a sub-tier

The operation is assigned to the farm-out source and enables the farmout functionality

Diffusion Coating | STR | Sequence # 12 Options

Operation description

STR

Add a sub-tier supplier for this process?

Yes No

Undo or modify the farmout by selecting “No”

Diffusion Coating | STR | Sequence # 12 Options

Operation description

"No" disables requirements for this process

Add a sub-tier supplier for this process?

Yes No



# Define Alternate Path(s)

## Enablers:

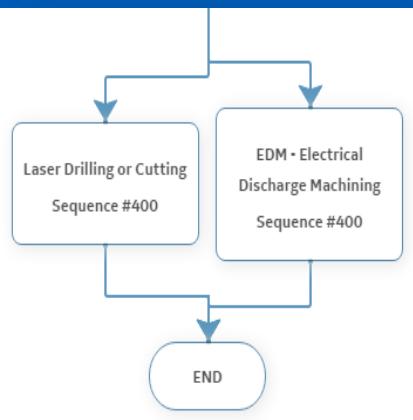
- Available to Source, Design Engineer, MAE, and Quality Engineer role
- An alternate path can be used for processes that are similar or that go to multiple suppliers



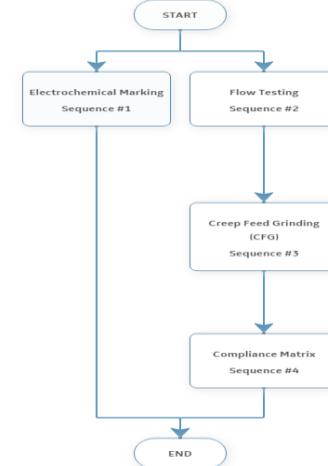
# Requirements | Alternate paths

1. Before setting up an alternate path make sure all the operations are listed and they have a sequence number.
2. Then select the alternate path that you want to set up (click the title)

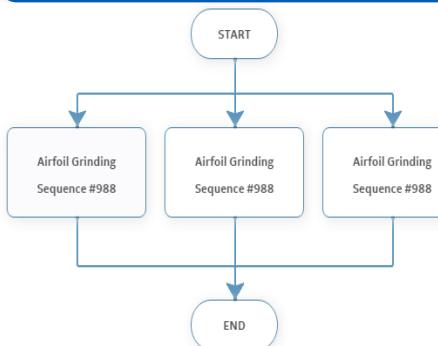
## 1 alternate path



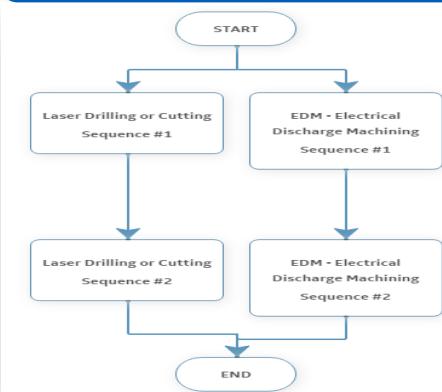
## Add multiple operations to an alternate path



## More than 1 alternate path



## More than 1 operation for each alternate path



# Acknowledgement

Enablers:

- Details page complete and all team members assigned
- SPS initiated



## 1499M23P11-T9354-0.0

BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE

2

SPS Type: New Part

Source: STROTHER

Status: OPEN

[View eCavData](#)[View Drawing](#)[View Specification](#)[Download Attachments](#)[View Process History](#)

1

Details

Requirements

Acknowledgement

Export Tagging

Process History

## ▼ Requirements Pending Approval

Requirements shown with proposed changes.

Operation	Requirement	Description	Approval Status	Approver	Review
Electrochemical Marking	f9e8047d-66a8-48a7-9e9d-91929908367c	Provide documentation showing Certifying Agent approval on use of electrolytes and cleaners used in operation.	Draft	Carlota Vazquez ▾	3
Electrochemical Marking	Null-NDE- sequence only	Provide photos or sketches and describe the specific location and method of attachment of the electrodes to the part and equipment.	Draft	Carlota Vazquez ▾	4

1. Requirements Pending Approval card appears after requirements were edited under Acknowledgement tab
2. The list shows all requirements that were removed, changed, or added, including those in new operations
3. Here everyone (including the source) can see the proposed changes and the approval status
4. Design Engineer, MAE, or Quality can select a qualified reviewer for each requirement change

**NOTE:** The Reviewer cannot act on requirements pending approval until after the acknowledgment



# New Complete Part at Source | Acknowledgement

SPS Dashboard

Initiate SPS

1499M23P11-T9354-0.0

Details

Requirements

Acknowledgement

Export Tagging

Process History

Milestones 1

Are there any key milestones or required commitment dates that should be discussed with the SPS team? These may include tooling lead times, scrap requirements, or process change freeze dates.

Milestone Name	Date ▲	Comments	Operation
Closure Required Before <small>i</small>	08-17-2018 <input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Kickoff Required Before <small>i</small>	10-01-2016 <input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Kickoff Discussion	<input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Hardware Need Date	<input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Add milestone	<input type="button" value="Calendar"/>		<input type="button" value="Add"/> 4

## Milestones:

1. Define important milestones for process completion
2. A kickoff discussion is required to occur within 45 days of initiation – the document will track this timeline.
3. Closure is required with 2 years of document initiation – the document will track this timeline
4. Select Add to add additional milestones



# New Complete Part at Source | Acknowledgement

The screenshot shows the SPS Dashboard with the following interface elements:

- SPS Dashboard** (Header)
- Initiate SPS** (Link)
- 1499M23P11-T9354-0.0** (Section)
- Details** (Link)
- Requirements** (Link)
- Acknowledgement** (Link) **2** (highlighted in blue)
- Export Tagging** (Link)
- Process History** (Link)

**Risk Planning** (Section) **1**

Are there any risks to meeting full source substantiation approval by the material required date? Please list these below along with any requirement or operation descriptions and abatements if available.

Risk	Description	Abatement plan
<input type="text" value="Enter Risk Name"/>		<input type="text" value="Enter Abatement Plan"/>

**Add** **3** (Blue button)

**Upload Risk Assessment (if applicable) ?** **4**

Drop File here or [Browse](#)

## Risk Planning (Optional)

1. Identify and document risks to approval, schedule, resources, etc.
2. Enter risk name, description, and abatement plan
3. Select “ADD” to add risk to table
4. For military – upload a risk assessment when required



# New Complete Part at Source | Acknowledgement

The screenshot shows the SPS Dashboard interface. On the left, a vertical navigation bar lists: SPS Dashboard, Initiate SPS, 1499M23P11-T9354-0.0 (expanded), Details, Requirements, Acknowledgement (selected), Export Tagging, and Process History. A red circle labeled '1' is positioned above the Requirements Acknowledgement section. The main content area displays a Requirements Acknowledgement form with a checkbox: "I acknowledge the significant operations, the significant operation sequence, the substantiation requirements, and the timing expectations." Below the checkbox is a button labeled "I agree". A red circle labeled '2' is placed over the table header. The table lists four team members with their roles and acknowledgement dates:

Team Member	Role	Acknowledgement Date
Patrick Steiger	Quality Engineer	Approved on Feb 12, 2016
Patrick Steiger	Design Engineer	
Patrick Steiger	Source Contact	
Patrick Steiger	Materials Application Engineer	

A red circle labeled '3' is placed over the date in the first row. At the bottom right is a blue "Send Reminder" button, with a red circle labeled '4' above it.

## Requirement Acknowledgement

1. The acknowledgement is required to proceed to the source data section of the document
  2. Team members and their roles are listed in the table
  3. Once a team member acknowledges, the acknowledgement date appears in the table and is visibly by all
  4. Use the “Send Reminder” button to send an email to team members who have not yet signed. The mail is automatic
- NOTE: All team members are required to acknowledge in order to enable the Data source



# Source Data

## Enablers:

- Kickoff acknowledged by all team members
- All roles on SPS can upload source data
- Source data review check boxes are custom for each role
- Source data review check boxes do **not** indicate approval



# Source Data

The screenshot shows the SPS Dashboard interface. On the left, a sidebar lists various menu items: SPS Dashboard, Initiate SPS, 1499M23P11-T9354-0.0 (selected), Details, Requirements, Acknowledgement, Source Data (highlighted in blue), SN Release, Package Closure, Export Tagging, and Process History.

The main content area displays the following information:

- Article Number:** 1499M23P11-T9354-0.0  
BLADE, HIGH PRESSURE TURBINE ROTOR  
SPS Type: New Part  
Source: T9354-GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC  
Status: OPEN
- Actions:** View eCavData (1), View Drawing, View Specification
- Attachments:** Download Attachments (2)
- Request Action:** Request Action (3)
- Operations:** Chemical Cleaning | 71878 | Sequence # 15 (4)
- Operation Description:** Chem cleaning after edm (5)
- Requirements:**
  - Chemical Cleaning Technical Plan:** Provide copy of Technical Plan, Operation Sheet or Process Control Document with significant processes identified. The technical plan must include a summary of the change history and show approvals by supplier and GE Aviation certifying agent.
    - Source Data:** Drop file here or [Browse](#)
  - Chemical Cleaning Operating Parameters:** Fill out attached template with operating parameters
    - Source Data:** Drop file here or [Browse](#)

1. Access eCAV for first article and quality plan, download drawing, and view/download drawing specifications
2. Download multiple attachments at once
3. (Source Only) Send email notification to reviewers to indicate data is ready for review
4. Reorder operations that have sequence numbers
5. See how many requirements are still missing source data



# Source Data

Click

DOWNLOAD ATTACHMENTS

## SPS Attachments

X

1

2

3

		▼Attachments	Type	Uploaded On	Operation
		<i>Filter by Attachment name</i>	<i>Filter by Type</i>	<i>Filter by Date</i>	<i>Filter by Operation</i>
<input type="checkbox"/>	5881438	Visual Review Template.ppt	Generic Template	10-05-2016	General
<input type="checkbox"/>	678588	Thermal Spray Coatings - SSL Requirements - Rev0.xlsx	Generic Template	04-03-2016	Thermal Spray Coatings
<input type="checkbox"/>	678524	Thermal Spray Coatings - Metallographic Template - Parent-Rev0.pptx	Generic Template	04-03-2016	Thermal Spray Coatings
<input type="checkbox"/>	5724242	Blisk.xlsx	Generic Template	08-17-2016	Fluorescent Penetrant Inspection (FPI)

Selected 0 Attachments

[Close](#)

[Download Selected](#)

### Download Attachments:

1. Select all function
2. Sort by clicking column headers
3. Filter columns by typing into filter box



GE PROPRIETARY INFORMATION

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# Source Data

SPS Dashboard

Initiate SPS

1499M23P11-T9354-0.0

BLADE, HIGH PRESSURE TURBINE ROTOR  
SPS Type: New Part  
Source: T9354-GENERAL GEAR-DIVISION OF  
GENERAL DONLEE CANADA INC  
Status: OPEN

[View eCavData](#) [View Drawing](#) [View Specification](#)

[Download Attachments](#) [Request Action](#)

[View Process History](#)

Details

Requirements

Acknowledgement

Source Data 2

SN Release

Package Closure

Export Tagging

Process History

Chemical Cleaning | 71878 | Sequence # 15 1 3

Operation description

Requirements

Chemical Cleaning Technical Plan Qty Required:  Qty Fulfilled:

Provide copy of Technical Plan, Operation Sheet or Process Control Document with significant processes identified. The technical plan must include a summary of the change history and show approvals by supplier and GE Aviation certifying agent.

Source Data:  3

Chemical Cleaning Operating Parameters Qty Required:  Qty Fulfilled:

Fill out attached template with operating parameters

Source Data:

1. Enter Operation or sequence number (required before approval)
2. Enter Operation Description (optional)
3. Upload source data against each requirement – browse or “drag and drop”



# Source Data

## Requirements

Engineering Visual Review	<p>Complete the attached photo template to provide high resolution visual documentation of the part, including part marking. This requirement can also be satisfied by a GE Engineering statement of visual inspection. GE Engineering: Use the generic template to create a part specific template that specifies what views the source must provide. TIP: use similar parts or 3D model views as examples in the template.</p> <p><b>3</b></p> <p><a href="#">Generic Template</a> <a href="#">Source Data Template</a> <a href="#">Acceptance Criteria</a> <a href="#">Part Specific Template</a></p>	<b>1</b>	Qty Required: 1	
		<b>2</b>	Qty Fulfilled: <input type="text" value="1"/>	<b>4</b>

1. Quantity of samples needed to satisfy the requirement. If there is a number in this cell, the QTY FULFILLED function must be used to enable SN Release or Package closure
2. Quantity of samples fulfilled toward meeting the requirement (partial fulfillment will enable SN release)
3. Requirement templates and acceptance criteria will appear here to download, if applicable
4. (Check the boxes for all requirement in a card with one click by using the check box in the table header)



# SN Release

## Enablers:

- Attachments for all source data requirements
- Quantity fulfilled entered for all source data requirements (if applicable)
- All requirements pending approval in either Approved or Rejected state
- All roles can upload SNs
- Only Design, MAE, and Quality can remove SNs listed
- Design, MAE, and Quality required to sign SNs – unless Design or MAE opt-out of approvals
- SN release must be completed before an SPS can be closed if there are any SN's present
- Separate cards requiring SN release will be displayed if there are sub-tier suppliers enabled



# SN Release

When uploading information remember is  
only SN OR (Lot and Qty)

SPS Dashboard

Initiate SPS

1499M23P11-T9354-0.0

BLADE, HIGH PRESSURE TURBINE ROTOR  
SPP Type: New Part  
Source: T9354-GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC  
Status: OPEN

View eCavData  
View Drawing  
View Specification  
Download Attachments

View Process History

Details  
Requirements  
Acknowledgement  
Source Data  
SN Release  
Package Closure  
Export Tagging  
Process History

1499M23P11-T9354-0.0

71878-PROTECTIVE COATINGS INC

Approve Selected Remove Selected Select My Unapprovals Add LOT Or Serial Numbers

Serial Number	Lot Number	Qty Parts	Date Added from : mm/dd/ to : mm/dd/	Final Approval Date from : mm/dd/ to : mm/dd/	Approvals
123456			12/15/2016		

Total Items: 1

T9354-GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC

Approve Selected Remove Selected Select My Unapprovals Add LOT Or Serial Numbers

1. A separate SN release card exists for each source (Prime + farmouts); Source Contact can only see and upload parts to their own SN release card
2. Approve or remove SN functions (approve available to reviewer functions only – all reviewers must approve)
3. Add Serial or Lot numbers – shown on next page
4. (Source only) Request approval button notifies reviewers when parts are ready for release
5. Export list of approvals



# SN Release

When uploading information remember is only SN OR (Lot and Qty)

Add LOT Or Serial Numbers

1

1. Click Add Lot or SN Numbers Note: both SN and lot are not acceptable to identify a part

2. Download and use the excel file to upload many serial or lot numbers at once

OR

1. Use this area to input individual serial or lot numbers
2. Select ADD ROW to add more serial or lot numbers
3. CLEAR GRID removes all data in the table
4. Click SUBMIT when complete

Add LOT Or Serial Numbers

Upload Excel For Bulk Data Entrance

SPS SN Upload Template.xlsx

Drop file here or  
Browse

Type Serial Number Or Lot Number With Qty Parts

Serial Number	Lot Number	Qty parts
2122		
4412		
1231		

Total Items: 2

Serial Numbers meet requirements but additional data may be needed to meet all requirement quantities

Submit Lot/Serial Numbers

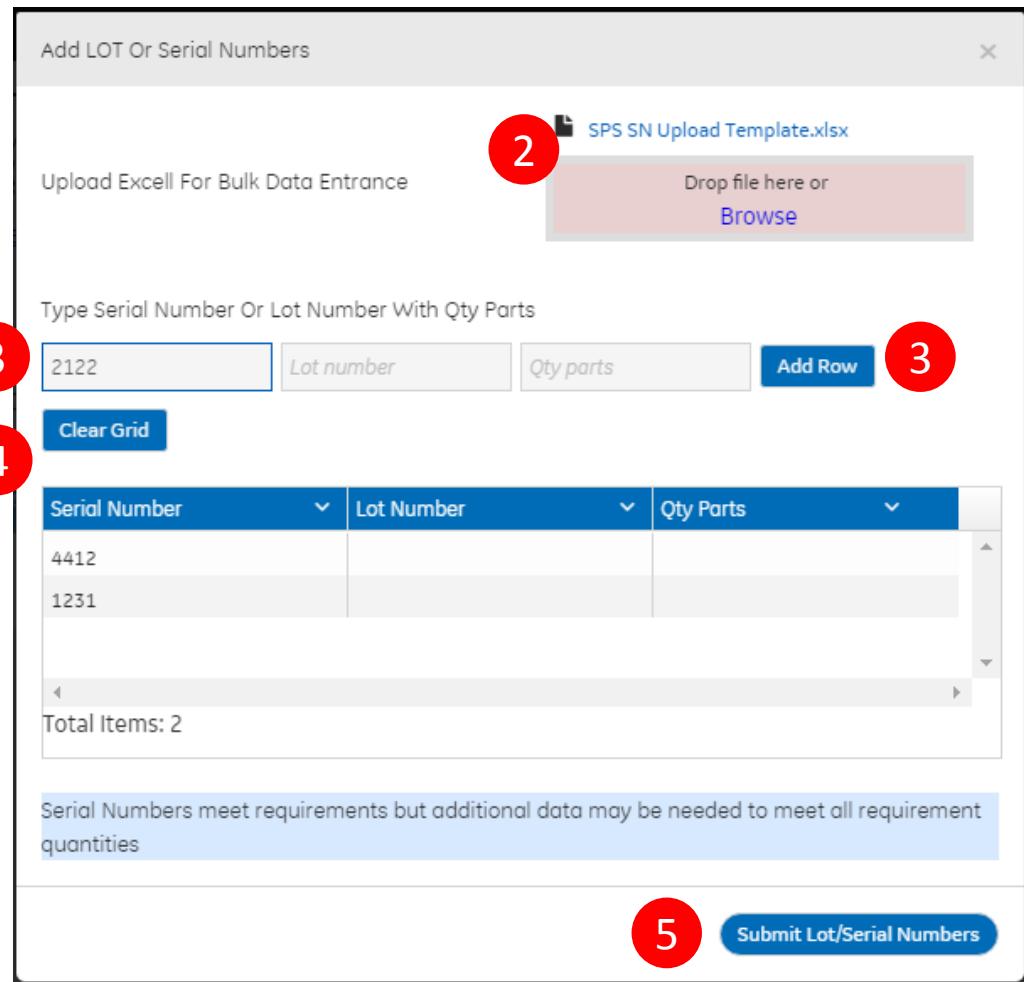
3

2

3

4

5



# SN Release

When uploading information remember is  
only SN OR (Lot and Qty)

Add LOT Or Serial Numbers

SPS SN Upload Template.xlsx

Upload Excel For Bulk Data Entrance

Drop file here or  
Browse

Type Serial Number Or Lot Number With Qty Parts

Serial Number	Lot Number	Qty parts
2122	1	
4412		
1231		

**1**

**2**

Total Items: 2

Serial Numbers meet requirements but additional data may be needed to meet all requirement quantities

Submit Lot/Serial Numbers

1. Add either Serial Number OR Lot number and quantity, not Serial Number and Lot number
2. Edit directly in the table by clicking on the field



# Multiple Parts | SN Release

When uploading information remember is only SN OR (Lot and Qty)

Add LOT Or Serial Numbers

SPS SN MultiPart Upload Template.xlsx

Upload Excel For Bulk Data Entrance

Drop file here or  
Browse

Type Serial Number Or Lot Number With Qty Parts

Part number	Serial number	Lot number	Qty parts	Add Row
2084M61P01	1111			

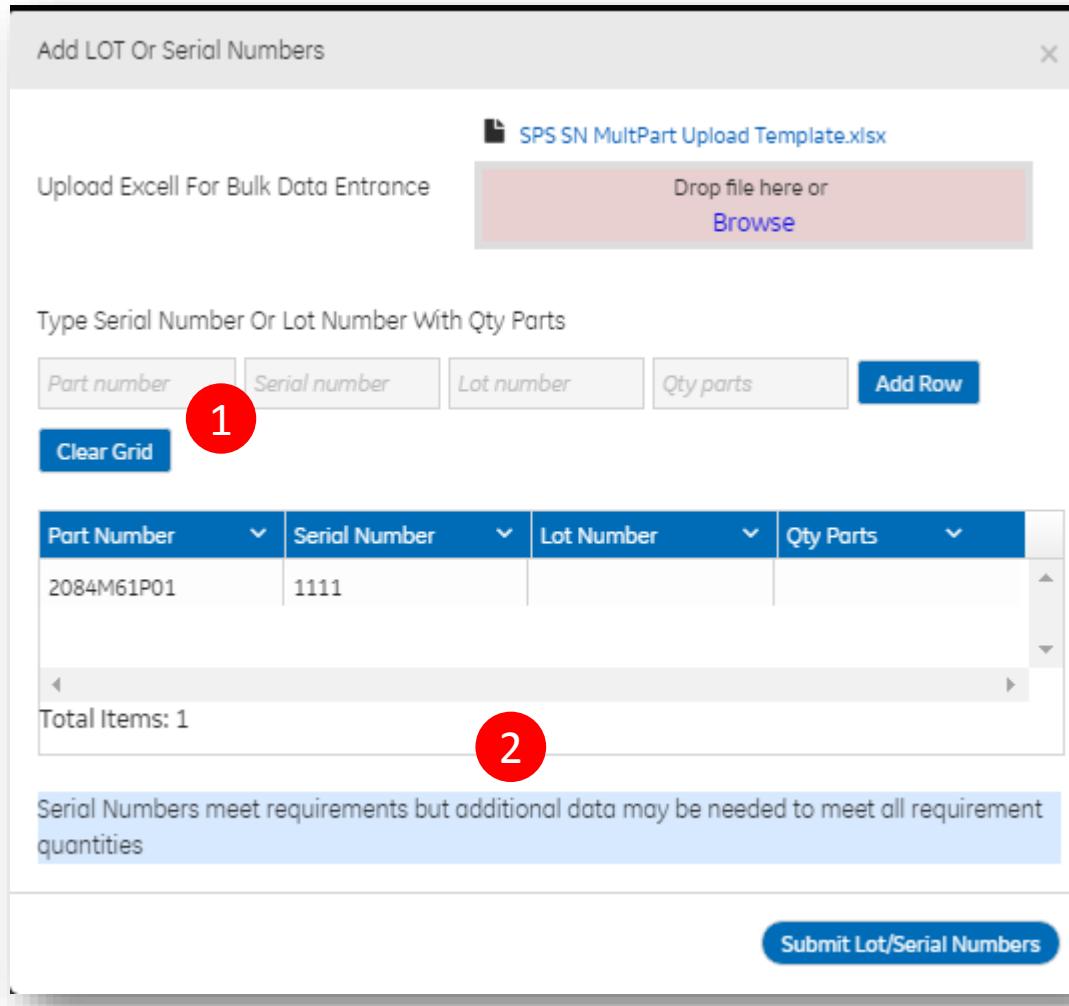
Total Items: 1

1

2

Serial Numbers meet requirements but additional data may be needed to meet all requirement quantities

Submit Lot/Serial Numbers



1. Part Number is required for SN release on multiple part SPSs
2. Complete the remainder as normal, see [SN Release](#)



# SN Release

K086P06-RUT-2  
VANEIG  
SPS Type: Process Change  
Source: RUT-RUTLAND  
Status: OPEN

[View eCavData](#)  
[View Drawing](#)  
[View Specification](#)

[Download Attachments](#)

[View Process History](#)

**RUT-RUTLAND**

[Approve Selected](#) [Remove Selected](#) [Select My Unapprovals](#) [Add LOT Or Serial Numbers](#)

	Serial Number	Lot Number	Qty Parts	Date Added from : mm/d to : mm/d	Final Approval Date from : mm/d to : mm/d	Approvals
✓	1341			10/07/2016	10/07/2016	<a href="#">Design Engineer</a> <a href="#">Materials Engineer</a> <a href="#">Quality Engineer</a>
✓	1215			10/07/2016	10/07/2016	<a href="#">Design Engineer</a> <a href="#">Materials Engineer</a> <a href="#">Quality Engineer</a>
✓	1459			10/07/2016	10/07/2016	<a href="#">Design Engineer</a> <a href="#">Materials Engineer</a> <a href="#">Quality Engineer</a>
✓	1231			10/07/2016		

Total Items: 1052 (Selected Items: 3)

1. Quickly select all unapproved SNs for your role
2. Filter or sort to manipulate table
3. Approver function appears in APPROVALS column; name and date appears when hovering over function name
4. Final approval date shows when the final signature was made for that part or lot
5. Source can send email when SNs are ready for approval



# SN Release

## Note:

- Cannot edit requirements after Lot or Serial Number release
- Cannot add additional part numbers to a new part workflow
- DE or MAE cannot opt out after SN release has been completed
- **When uploading information remember is only SN OR (Lot and Qty)**



# Package Closure

Enablers:

- Attachments for all source data requirements
- Quantity fulfilled = Quantity required for all requirements, if applicable



# Closure

Pro- tip!

Orange notifications will not prevent you from closing an SPS package!!!

The screenshot shows a software interface for managing closure. On the left, a vertical menu lists: Details, Requirements, Acknowledgement, Source Data, SN Release, Package Closure (highlighted in blue), Export Tagging, and Process History. The main area displays a section for 'STROTHER' (1) containing a list of operations: Universal General (checked), SEQUENCE# 1, Shot Peen (checked), SEQUENCE# 2, Brazing (checked), and SEQUENCE# 3, Part Marking (checked). A red circle with the number 3 is over the third operation. A red circle with the number 4 is over the 'Approve' button at the bottom. A red circle with the number 5 is over the 'Serial Number Closure' button at the bottom. To the right, a yellow starburst icon contains the text 'Pro- tip!'. Below it, a blue box contains the text 'Orange notifications will not prevent you from closing an SPS package!!!'. A sidebar on the right lists four notifications: 'Source Data is not marked as approved' (orange box), 'Operation has not been assigned to any subcomponent yet' (orange box), 'Op Numbers are missing' (red box), and 'Source Data is missing' (red box). A red circle with the number 2 is over the 'Op Numbers are missing' notification.

1. An approval card will appear by source (farmouts will have separate approvals)
2. System checks will make sure source data is complete, sequence and requirement quantities have been met
3. The system will notify the reviewer if he/she has not used the green check boxes for requirement review – this will not prevent approval since use is not required.
- 4. Full approve** the significant operations for this source
5. Close the package for the released SNs only



# Closure

123-TEST9-2

X  
SPS Type: Process Change  
Source: TEST9-TEST9  
Status: Closed - Full Approval

[View Process History](#)

[View eCAV Data](#)  
[View Drawing](#)  
[View Specification](#)

[Export GT7350](#) [Download Attachments](#)

## ▼ TEST9-TEST9

The following operations meet all requirements:

- General
- Sequence# 05, Forging – Closed/Open Die
- Sequence# 15, Anodizing

Patrick Steiger approved as Quality Engineer 12-12-2016

Patrick Steiger approved as Design Engineer 12-12-2016

Patrick Steiger approved as Materials Application Engineer 12-12-2016

[Approve](#) [Serial Number Closure](#)

1. An approval card will appear by source (farmouts will have separate approvals)
2. System checks will make sure source data is complete, sequence and requirement quantities have been met
3. The system will notify the reviewer if he/she has not used the green check boxes for requirement review – this will not prevent approval since use is not required.
- 4. Full approve** the significant operations for this source
5. Close the package for the released SNs only



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# Process Change

## Enablers:

- New Part workflow complete or in process (past acknowledgement)
- Part Number Conversion SPS complete or in process
- Previous process change complete or in process
- Significant Operations List approved (for migrated eVSE records)
- Prime source that manufactures the part complete must create the Significant Operations List for subtier/farmout suppliers



# Process Change | Initiation

What would you like to do?

New Part SPS

1 Process Change

Inadvertent Change

Part Number Conversion SPS

View Draft Requirements

View/Edit Standard Requirements

Manage Reviewers

SEARCH BY PART NUMBER

SEARCH BY SOURCE

2

OR

SEARCH BY PACKAGE ID

3

SEARCH

1. Select PROCESS CHANGE from the SPS dashboard
2. Search for part number and source where you'd like to create a process change
3. SEARCH
4. Select Part Number and Source from search results – this takes you to the process history page



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# Process Change | Initiation

The screenshot shows the SPS Dashboard with the following details:

- SPS Dashboard**
- Initiate SPS**
- Process History**
- Include Voided SPS** (unchecked)
- Initiate Process Change** (green button with a red circle containing the number 1)
- 1499M23P11-T9354-0.0**
- New Part : OPEN**
- Initiated On : 14-Dec-2016**
- SN : 0**

The main content area displays the part number **1499M23P11-T9354-0.0** and description **BLADE, HIGH PRESSURE TURBINE ROTOR**. It shows a New Part entry for **T9354** and provides a [Details Page](#).

Two process steps are listed:

- Fluorescent Penetrant Inspection (FPI) | T9354 - GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC** (REV 0 - 14-Dec-2016)
- Electrochemical Marking | T9354 - GENERAL GEAR-DIVISION OF GENERAL DONLEE CANADA INC** (REV 0 - 14-Dec-2016)

Buttons for **Show Operation Flow** and **Inadvertent Change** are also present.

1. Select INITIATE PROCESS CHANGE from the process history page

NOTE: If the package has been voided the “initiate process” button will be disabled



# Process Change | Initiation

SPS Dashboard

Initiate SPS

Process History

Hide Voided SPS

Initiate Process Change

1708M21P01-BRO-18.0

Process Change:  
On Process : 09-Aug-2017  
SN:

1708M21P01-BRO-17.0

Process Change 17.0 : OPEN  
Initiated On : 27-Jul-2017  
SN: 0

1708M21P01-BRO-16.0

Process Change 16.0 : OPEN  
Initiated On : 27-Jul-2017  
Closed On : 27-Jul-2017  
SN: 0

1708M21P01-BRO-14.0

Process Change 14.0 : CLOSED  
Initiated On : 27-Jul-2017  
Closed On : 27-Jul-2017  
SN: 1

1708M21P01-BRO-18.0 **5**  
BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
SPS Type: Process Change  
Source: BRO-BROMONT  
Status: Review and Acknowledgment

[View eCAV Data](#)  
[View Drawing](#)  
[View Specification](#)

[Export GT7350](#)

[View Process History](#)

Add Operation Reorder

Change Operation → Change Benefits → Approval Team

Initiate Process Change

Change Operation

Select the operation(s) affected by the process change by clicking CHANGE OPERATION in the Significant Operation List or add a new operation using the ADD OPERATION button above.

Do you want to add part number/s?  Yes  No **1**

Electrochemical Marking | BRO | Sequence # **2** 1 **3**  Change Operation  REV 0 - 27-Jul-2017

Operation description

Process Change Description

What is the current process or parameter?

What is the proposed process or parameter?

Why is the Process changing?

Will this be a rework operation? \* **4**  
 Yes  No **5**

OK

1. Choice to add part numbers (PN should be spec compatible)
2. View approved or in-process significant operations
3. Select CHANGE OPERATION on the applicable operation
4. Fill out PROCESS CHANGE DESCRIPTION information, which will pop up
5. If adding an operation, indicate if this will be a **rework operation**

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# Process Change - Delete operation



# Process Change | Initiation – Delete operation

SPS Dashboard

Initiate SPS

Process History

Hide Voided SPS

Initiate Process Change

1708M21P01-BRO-18.0 [5]  
BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
SPS Type: Process Change  
Source: BRO-BROMONT  
Status: Review and Acknowledgment

View eCAV Data  
View Drawing  
View Specification  
Export GT7350

Add Operation Reorder

Change Operation → Change Benefits → Approval Team

Initiate Process Change

Change Operation

Select the operation(s) affected by the process change by clicking CHANGE OPERATION in the Significant Operation List or add a new operation using the ADD OPERATION button above.

Do you want to add part number/s?  Yes  No

Electrochemical Marking | BRO | Sequence # 1  Change Operation 3

REV 0 - 27-Jul-2017

Operation description

Process Change Description

What is the proposed process or parameter?

Why is the Process changing?

OK

3

4

1. Select DELETE OPERATION on the applicable operation
2. Fill out PROCESS CHANGE DESCRIPTION information, which will pop up
3. Click OK



# Process Change | Initiation – Delete operation

1708M21P01-BRO-18.0  
Process Change:  
On Process : 09-Aug-2017  
SN :

1708M21P01-BRO-17.0  
Process Change 17.0 : OPEN  
Initiated On : 27-Jul-2017  
SN : 0

1708M21P01-BRO-16.0  
Process Change 16.0 : OPEN  
Initiated On : 27-Jul-2017  
SN : 0

1708M21P01-BRO-14.0  
Process Change 14.0 : CLOSED  
Initiated On : 27-Jul-2017  
Closed On : 27-Jul-2017  
SN : 1

### Change Operation

Select the operation(s) affected by the process change by clicking CHANGE OPERATION in the Significant Operation List or add a new operation using the ADD OPERATION button above.

Do you want to add part number/s?  Yes  No

**1** Electrochemical Marking | BRO | Sequence # 1 Delete Operation REV 0 ▾ - 27-Jul-2017

Operation description

1. This icon will display in the operation that was deleted
2. To cancel the deletion of the operation you will have to cancel the record.
3. Deleting a new added operation will remove the operation from the process change



# Process Change | Initiation

1

Add Operation

Reorder

Change Operation

Change Benefits

Approval Team

Make The Required Changes To Operations Listed Below. Choose The Current Revision Of The Significant Operations If They Are Not Changing.

Do you want to add part number/s?

Yes  No

General | 12346

REV 2 ▾ - 14-Dec-2016

Options ▾

Fluorescent Penetrant Inspection (FPI)

| BRO

| Sequence #

656

Change Operation

REV 0 - 27-Jul-2017

Operation description

Laser Drilling or Cutting

| BRO

| Sequence #

400

Change Operation

REV 0 - 27-Jul-2017

Operation description

2

3

Next >

1. Add an operation or operations if necessary (Adding of an operation can only be done in this screen)
2. Select CHANGE OPERATION again to modify previous inputs and change other operations or operation sequence as needed
3. Click NEXT



# Multiple Parts Process change on an SPS

Note:

- Parts should be done at the same Source
- Part shall be compatible in SPECS
- If there is a prior open new Part SPS; multipart can only be initiated after the New part has been acknowledged



Click here to download  
Multipart Process change  
instructions



# Process Change Quality Screening



# Process Change | Quality Screening

Process change proposals are submitted to the Quality Engineer for screening before being assigned requirements.

SPS Dashboard

1234M56P01-12346-3.0  
BRKT  
SPS Type: Process Change  
Source: 12346-JOES FLAP SHOP  
Status: OPEN

[View Process History](#)

Details

Export Tagging

Process History

Proposed Process Changes

Part Information

Process Change Impact

Is this process change the result of a CID?  
 Yes  No 1

Are there benefits to GE?  
 Yes  No

Are there benefits to the manufacturing source?  
 Yes  No

Are there any risks associated with the process change?  
 Yes  No

Sequence# 10 | Abrasive Blasting | JOES FLAP SHOP

REVO / 12-15-2016

Click to expand details

1. Quality Engineer: Review Process Change Impact and change details within each operation
2. Quality Engineer: Submit
3. Quality Engineer: Return and void proposal or return for clarification



# Process Change | Quality Screening

Return and Void

1

2

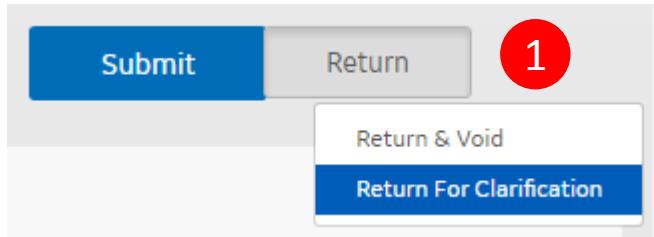
3

1. Quality Engineer: Select **Return** and then **Return & Void**
2. Quality Engineer: Explain why the process change proposal is not being accepted
3. Quality Engineer: Select **Reject & Void** to send back to the originator



# Process Change | Quality Screening

Return for  
clarification



A screenshot of a 'Reject Process Change' dialog box. The title bar says 'Reject Process Change'. Below the title is a grey text area with the placeholder 'What Needs To Be Clarified?'. In the center of this area is a large red circle containing the number '2'. At the bottom of the dialog box are two buttons: a light grey 'Cancel' button on the left and a blue 'Return For Clarification' button on the right. To the right of the 'Return For Clarification' button is another red circle containing the number '3'.

1. Quality Engineer: Select **Return** and then **Return For Clarification**
2. Quality Engineer: Explain what clarification is needed regarding the change
3. Quality Engineer: Select **Reject & Request More Information** to send back to the originator



# Process Change | Quality Screening

Accept

1

Submit

Return

1. Quality Engineer: Select **Approve**
2. Quality Engineer: Assign the team
3. Select **Submit**– this initiates the process change

Emails are sent to the team members at initiation

## Approve Process Change

The Process Change Will Be Assigned To The Following Team. Please Verify That The Names Are Correct.

Design Engineer 

Carlota Vazquez

2

Email:  
carlota.vazquez@ge.com,  
Phone:null

Materials Application Engineer

Jerin Chacko

Email: Jerin.Chacko@ge.com,  
Phone:null

Export Tagging Focal

Patrick Steiger

Email: Patrick.Steiger@ge.com  
Phone:null

Cancel

Submit

3



# Process Change | Requirements

SPS Dashboard

1234M56P01-12346-3.0

BRKT  
SPS Type: Process Change  
Source: 12346-JOES FLAP SHOP  
Status: OPEN

View eCavData  
View Drawing  
View Specification  
Download Attachments

Show Operation Flow Add Subcomponent Reorder

General | 12346 Options

Abrasive Blasting | 12346 | Sequence # 10 Options

Operation description

Requirements

Process change only	Description test	Qty Required:
Generic Template:	Source Template.doc Sep 8, 2016	Source Data Template: Drag & drop or Browse
Acceptance Criteria:	Drag & drop or Browse	Part Specific Template: Drag & drop or Browse

Process change only	Description	Qty Required:
Generic Template:	Add	Source Data Template: change.txt Aug 19, 2016
Acceptance Criteria:	Drag & drop or Browse	Part Specific Template: Drag & drop or Browse

1. Requirements automatically pull in for the affected operation. General requirements also load in automatically. The Edit Requirements function and Acceptance Criteria, Source Data Template, and Part Specific Template areas are reserved for the GE Quality, Design and Material Application Engineering roles.

Remaining functionality shown in New Part overview



# Process Change | Full Approval

▼ STROTHER

- 1 The following operations meet all requirements:

OP#, General  

OP#, VSE General  

OP# 10, Balance

- 2  OP# 20, Grind

OP# 30, Heat Treating

OP# 75, Blue Etch Anodize (BEA)

OP# 40, Shot Peen  

A Process Change SPS will only require substantiation associated with the operations that are changing, but approval of the process change is an approval of the full process that includes the changing operation.

If any interactions exist between the changing operation and the rest of the significant operations used to make the component, evaluation of those interactions should be considered before approval.

1. Unchanging operations are shown but no requirements are provided to be substantiated. These are shown so the change can be seen in the context of the full approved process.
2. Unchanging operations show with the green check to indicate they are unchanging and therefore substantiation is based on similarity to the already approved process

Approve



# Rework – Process Change

Note:

- NOT REPAIR – Repair must be done through the Nonconformance Management System (eNMS); refer to S-065
- Similar to a process change but adds *optional* significant operations that can be used to reprocess a part



# Rework | Add Operation

SPS Dashboard

Initiate SPS

Process History

Include Voided SPS

1

Initiate Process Change

1234M56P01-12346-3.1  
Inadvertent Change 3.1 : OPEN  
Initiated On : 16-Dec-2016  
SN : 0

1234M56P01-12346-2.1  
Inadvertent Change 2.1 : OPEN  
Initiated On : 16-Dec-2016  
SN : 0

1. Start by selecting INITIATE PROCESS CHANGE



# Rework | Set an operation as rework

SPS Dashboard

Initiate SPS

New Part

Process Change

Inadvertent Change

Part Number Conversion

Process History

Include Voided SPS

Initiate Process Change

1234M56P01-12346-4.0

Process Change:  
On Process : 16-Dec-2016

SN :

1234M56P01-12346-3.1

Inadvertent Change 3.1 : OPEN  
Initiated On : 16-Dec-2016

SN : 0

Help

1234M56P01-12346-4.0

BRKT  
SPS Type: Process Change  
Source: 12346-JOES FLAP SHOP  
Status: OPEN

[View eCavData](#)  
[View Drawing](#)  
[View Specification](#)

[View Process History](#)

Add Operation    Reorder

Change Operation    Change Benefits    Approval Team

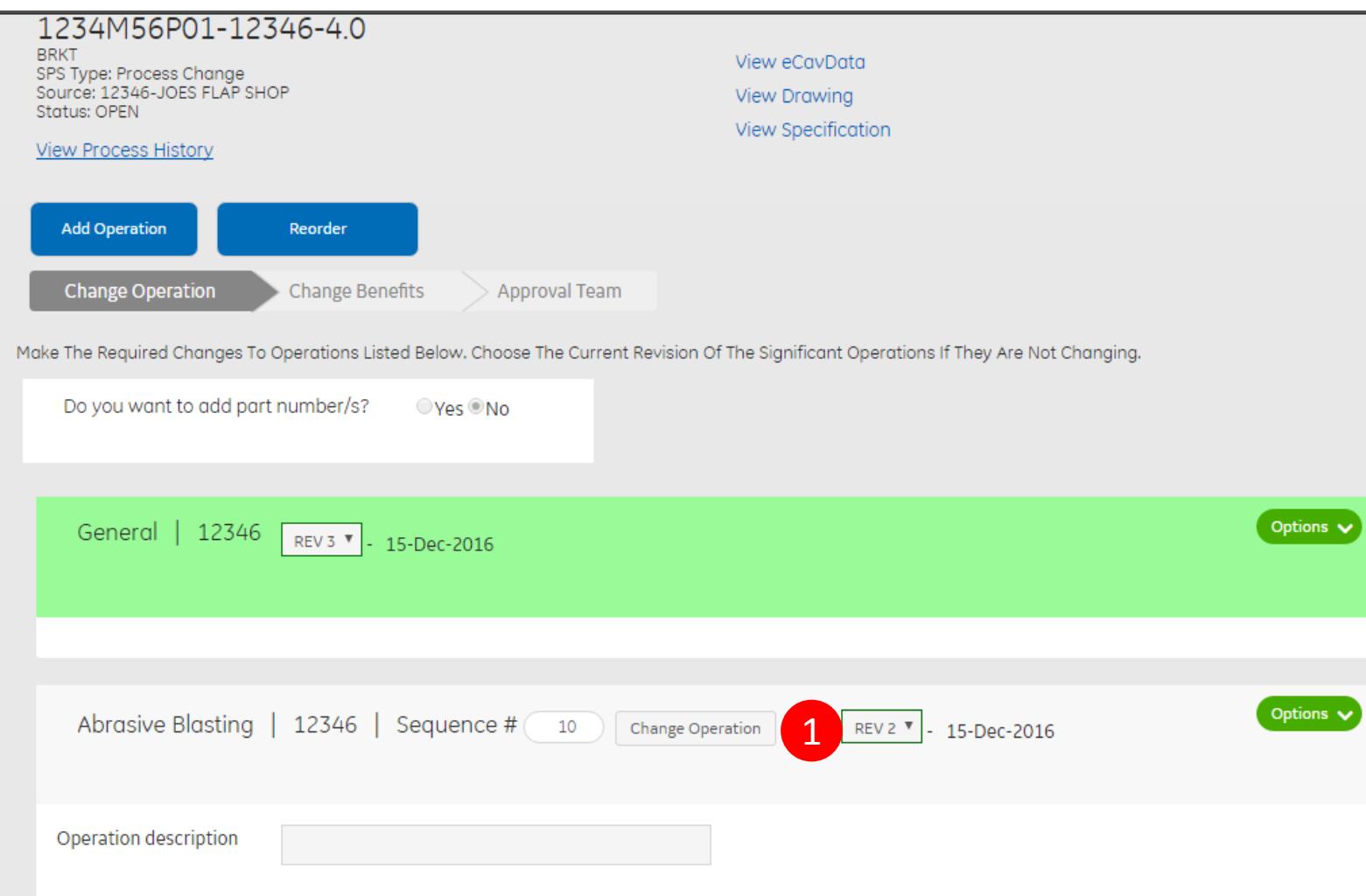
Make The Required Changes To Operations Listed Below. Choose The Current Revision Of The Significant Operations If They Are Not Changing.

Do you want to add part number/s?  Yes  No

General | 12346 REV 3 ▾ - 15-Dec-2016 Options ▾

Abrasive Blasting | 12346 | Sequence # 10 Change Operation REV 2 ▾ - 15-Dec-2016 Options ▾

Operation description



1. Select the operation that will be added as rework. Click "change operation"



# Rework | Set an operation as rework

Process Change Description ×

What is the current process or parameter?

What is the proposed process or parameter?

Why is the Process changing?

Will this be a rework operation? \*

Yes  No

1

2

OK

1. Fill up the Process change description and select “yes” in Will this be a rework operation question
2. Click OK



# Rework | Set an operation as rework

1

Abrasive Blasting | 12346 | Sequence # 10 Change Operation REV 2 - 15-Dec-2016

2

Options ▾

Unmark as Rework

Operation description



1. The operation set as rework will display this icon
2. To remove the rework operation select Options menu and Unmark as rework
3. Continue with the process change modal steps



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# Inadvertent / Process Excursion

Note:

- Can only be initiated after a PC has been initiated and after the New part has been acknowledged
- Can be closed by SN Release only
- Requirement Review not required
- Screened by Quality Engineer before notifying Design Engineering and MAE
- A drawing characteristic must not be violated to use an inadvertent SPS – use MRB if this is the case



# Inadvertent | Initiation

What would you like to do?

New Part SPS

Process Change

1 Inadvertent Change

Part Number Conversion SPS

View Draft Requirements

View/Edit Standard Requirements

Manage Reviewers

2

Search By Part Number

2357M35P02

Search By Source

OR

Search By Package Id

3 Search

Select the SPS Below

4

▼ Part Number	Description	Source
<a href="#">2357M35P02</a>	BLISK, COMPRESSOR ROTOR- STAGE 5	BRO

1. Select INADVERTENT CHANGE from the SPS dashboard
2. Search for part number and source where you'd like to create a process change
3. SEARCH
4. Select Part Number and Source from search results – this takes you to the process history page



# Inadvertent | Initiation

SPS Dashboard

Initiate SPS

Process History 1

Hide Voided SPSs

Initiate Process Change

L50308G01-DEA-2.0 2

Process Change 2.0 : OPEN  
Initiated On : 03-May-2017  
SN : 0

L50308G01-DEA-0.0

Significant Operation List 0.0 : CLOSED  
Initiated On : 03-May-2017  
Closed On : 03-May-2017  
SN : 0

DEA-VSE-11-04738-L50308G01

New Part : LEGACY  
Initiated On : 20-May-2016  
Closed On : 20-Mar-2016  
SN : 0

L50308G01-DEA-2.0 2

Process Change  
DEA  
[Details Page](#)

▼Expand All

Show Operation Flow

Generate Rebaseline Sig Op List 3

Inadvertent Change

General | DEA - DURHAM ENGINE ASSEMBLY REV 1 - 03-May-2017

10 | Compression Molding | DEA - DURHAM ENGINE ASSEMBLY REV 0 - 03-May-2017  
Operation description : Compression molding of Part 1

15 | Hole Drilling | 12346 - JOES FLAP SHOP REV 0 - 03-May-2017  
Operation description : Part 3

1. Go to Process History page
2. Select the appropriate Process change or New part workflow to create the Inadvertent from
3. Select INADVERTENT CHANGE



# Inadvertent | Initiation

SPS Dashboard

Initiate SPS

Process History

Hide Voided SPSs

[Initiate Process Change](#)

L50308G01-DEA-2.1  
Inadvertent Change :  
On Process : 03-May-2017  
SN :

L50308G01-DEA-2.0  
Process Change 2.0 : OPEN  
Initiated On : 03-May-2017  
SN : 0

L50308G01-DEA-0.0  
Significant Operation List 0.0 : CLOSED  
Initiated On : 03-May-2017  
Closed On : 03-May-2017  
SN : 0

DEA-VSE-11-04738-L50308G01  
New Part : LEGACY  
Initiated On : 20-May-2016  
Closed On : 20-Mar-2016

[Help](#)

**L50308G01-DEA-2.1**  
L50308G01  
SPS Type: Process Change  
Source: DEA-DURHAM ENGINE ASSEMBLY  
Status: OPEN

[View eCAV Data](#)  
[View Drawing](#)  
[View Specification](#)

[View Process History](#)

Affected Operations > Issues & Actions > SN Upload > Approval Team

## Inadvertent SPS

**Info** You will be able to add source data to the affected operations once the Inadvertent change is saved as a draft

### Affected Operations

Select The Affected Operations Below

General | DEA

Compression Molding | DEA | Sequence # 10  Select Operation 1

Operation description: Compression molding of Part 1

1. Scroll through and select affected operation(s), they can be unselected
2. Click NEXT

Next > 2



# Inadvertent | Initiation

Affected Operations > Issues & Actions > SN Upload > Approval Team

## Inadvertent SPS

**Info** You will be able to add source data to the affected operations once the Inadvertent change is saved as a draft

### Issues & Actions

What deviations occurred in the selected operations? \*

What is the root cause to the non-compliance? \*

1

What corrective actions have been taken? \*

2

Back Cancel Record Next >

1. Describe the deviation in detail, document the root cause and corrective action
2. Click NEXT



# Inadvertent | Initiation

Affected Operations > Issues & Actions > SN Upload > Approval Team

## Inadvertent SPS

### Serial Number Upload

Upload Excel for bulk data entrance

SPS SN Upload Template.xlsx

Drop file here or  
Browse

Type Serial Number or Lot Number with quantity of parts  
Serial Numbers meet requirements but additional data may be needed to meet all requirement quantities

1 Serial number      2 Lot number      Qty parts      Add Row

Clear Grid

Back      Cancel Record      4 Next >

1. Add the affected serial numbers or the affected lot number and quantity of parts
2. Add Row
3. Or add a set of SN's by uploading a template
4. Select Next



# Inadvertent | Initiation

Affected Operations > Issues & Actions > SN Upload > Approval Team

Please Complete Or Verify The Following Approval Team Is Correct:

Quality Engineer \* 1      Carlota Vazquez  
Source Contact \* 2      Patrick Steiger

Email:  
carlota.vazquez@ge.com,  
Phone:null

Email:  
Patrick.Steiger@ge.com,  
Phone:null

Back      Cancel Record      3 Submit to Quality >

1. Add the GE quality engineer
2. Add the source contact (usually the initiator)
3. Click "Submit to Quality"



# Inadvertent | Quality Screening

1

Hello Patrick

An inadvertent process change has been requested for part number 1234M56P01 by 12346 at 12346 .Please review the change details to understand the non-compliances and attached data.

Here are the links to the SPS to copy into your browser:

Internal: <https://qa-digitalthread.aviation.ge.com/sps/5928332/icdetails>

External: <https://qa-digitalthread.geaviation.com/sps/5928332/icdetails>

2

/\*\* This is a system generated email, please do not reply. \*\*\*/

1. Quality Engineer is notified of inadvertent change from source by email
2. Select a link to view the SPS



# Inadvertent | Initiation

SPS Dashboard

Initiate SPS

Process History

Hide Voided SPSs

Initiate Process Change

L50308G01-DEA-2.1  
Inadvertent Change 2.1 : OPEN  
Initiated On : 03-May-2017  
SN:0

L50308G01-DEA-2.0  
Process Change 2.0 : OPEN  
Initiated On : 03-May-2017  
SN:0

L50308G01-DEA-0.0  
Significant Operation List 0.0 : CLOSED  
Initiated On : 03-May-2017  
Closed On : 03-May-2017

L50308G01-DEA-2.1

L50308G01  
Inadvertent Change  
DEA  
[Details Page](#) 1

▼Expand All

Show Operation Flow

Generate Rebaseline Sig Op List

General | DEA - DURHAM ENGINE ASSEMBLY

10 | Compression Molding | DEA - DURHAM ENGINE ASSEMBLY  
Operation description: Compression molding of Part 1

15 | Hole Drilling | 12346 - JOES FLAP SHOP  
Operation description: Part 3

- Once the SPS has been created, the workflow will send you to the Process history page. Select Details page to access the workflow



# Inadvertent | Quality Screening

The screenshot shows a software interface for quality screening. On the left, a dark sidebar lists navigation options: SPS Dashboard, Initiate SPS, L50308G01-DEA-2.1 (selected), Details, Export Tagging, and Process History. A red circle labeled '1' highlights the 'Process History' item. The main content area displays part information for L50308G01-DEA-2.1, including its type (INADVERTENT), source (DEA-DURHAM ENGINE ASSEMBLY), and status (OPEN). It also includes links to View Drawing and View Specification, and a 'View Process History' button. A red circle labeled '2' is placed over the 'Inadvertent Process Description' expandable section. Another red circle labeled '3' is placed over the 'Submit' button at the top right. The bottom of the screen features a yellow footer bar with the text 'General | DURHAM ENGINE ASSEMBLY' on the left and 'REV 0 - 03-May-2017' on the right.

1. Review deviation details by clicking the “Inadvertent Process Description” expand button
2. Review Operation(s) affected
3. For the GE Quality Engineer select Submit once the information have been reviewed



# Inadvertent | Quality Screening

**Submit Inadvertent Change For Review**

Please Verify That The Following Is Accurate

Is A Drawing Characteristic Violated? 

Yes  No 1

Is This The Proper Use Of An Inadvertent Process Change? 

Yes  No 2

Is The Description Clear And Detailed?

Yes  No 3

Cancel 4 Next

1. Confirm that a drawing characteristic has not been violated; if that is not the case, the IC needs to be Voided and an MRBR should be created (you can do it by clicking yes)
2. An inadvertent SPS should not be used for permanent process changes or in anticipation of process deviations
3. The details must be clear and detailed before submitting to engineering. If this is not the case, complete the radio buttons properly and send back the SPS for clarification or void the SPS
4. Click NEXT, assign the SPS approval team, and submit



# Inadvertent | Quality Screening

Submit Inadvertent Change For Review

1 Design Engineer \*

2 Materials Application Engineer \*

3 Export Tagging Focal \*

4

Email:  
carlota.vazquez@ge.com,  
Phone:null

Email:  
carlota.vazquez@ge.com,  
Phone:null

Email:  
Patrick.Steiger@ge.com,  
Phone:null

1. Select Design Engineer
2. Select Materials Application Engineer
3. Select Export Tagging Focal
4. Click OK



# Inadvertent | Requirements

The screenshot shows the SPS Dashboard interface. On the left, a sidebar lists navigation options: SPS Dashboard, Initiate SPS, L50308G01-DEA-2.1 (expanded), Details, Requirements (selected), Acknowledgement, Export Tagging, Process History, and Help.

The main content area displays the details for SPS L50308G01-DEA-2.1. It includes the SPS ID, Type (INADVERTENT), Source (DEA-DURHAM ENGINE), Status (OPEN), and links to View Drawing and View Specification. Below this is a link to View Process History.

The Requirements section is currently active. It shows three process steps:

- General | DEA**: Sequence # 75. Operation description: Part 1, 2, and 3. Includes an "Add a sub-tier supplier" button with Yes/No options.
- Heat Treating | DEA | Sequence # 75**: Includes an "Add a sub-tier supplier" button with Yes/No options.
- Brazing | DEA | Sequence # 80**: Operation description: Parts 1, 2, and 3. Includes an "Add a sub-tier supplier" button with Yes/No options.

Proceed with the SPS like a **Process Change** but note the following:

- Requirement review is not necessary after requirement editing**
- The SPS can only be SN Closed after all the data required has been met



# Administrative Change

Note:

- Administrative Changes can only be done in **closed packages**
- Use for non-technical, clerical changes only to **documents** and **text fields** in SPS
- Admin changes are made within the SPS where the change is needed
- Hover over the file or text field where you need to make an Admin change  
– then click EDIT



# Text fields change

Note:

- Text changes should not contain any proprietary information
- This kind of change can be done in Details, Requirements and acknowledgement tabs



# Admin | Initiation

What would you like to do?

- |                                |   |
|--------------------------------|---|
| New Part SPS                   | <a href="#">View Draft Requirements</a>         |
| Process Change                 | <a href="#">View/Edit Standard Requirements</a> |
| Inadvertent Change             | <a href="#">Manage Reviewers</a>                |
| Part Number Conversion SPS     | <a href="#">View all my SPS packages</a>        |
| Concurrent Process Development | <a href="#">Need Help?</a>                      |

Search Significant Process Substantiation [Advanced Search](#)

Search By Part Number

Search By Source

Search By Package Id

1

[Search](#)

1708M21P01-BRO-3.0	<i>Process Change 3.0 : OPEN</i>
	<i>Initiated On : 25-Jul-2017</i>
	<a href="#">SN : 1</a>
1708M21P01-BRO-2.0	<i>Process Change 2.0 : CLOSED</i>
	<i>Initiated On : 25-Jul-2017</i>
	<i>Closed On : 25-Jul-2017</i>
	<a href="#">SN : 0</a>
1708M21P01-BRO-1.0	<i>Process Change 1.0 : OPEN</i>
	<i>Initiated On : 25-Jul-2017</i>
	<a href="#">SN : 1</a>
1708M21P01-BRO-0.0	<i>New Part : OPEN</i>
	<i>Initiated On : 26-Apr-2017</i>
	<a href="#">SN : 1</a>

1. Search for the SPS package
2. Select the SPS that requires an administrative change
3. Click details page



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# Admin – Text change - Details Page

Once on the details page you should be able to edit the text fields

1. Hover over the box to see the “edit text button” and click

▼ Sequence# 4 | Anodizing | BROMONT

What is the current process or parameter?

test

1

Edit Text

What is the proposed process or parameter?

test

Why is the process changing?

test



# Admin – Text change -Requirements tab

Once on the Requirements page you should be able to edit the text fields

1. Hover over the box to see the “edit text button” and click

▼ Anodizing | BRO Sequence # [View](#)

Operation description  STANDARD REQUIREMENTS

**Requirements**

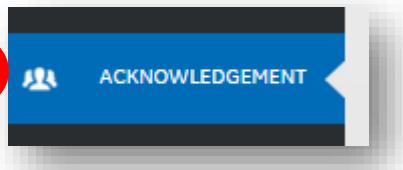
Req_Test1	3 Part families selected	Qty Required:
<b>Generic Template:</b>	<b>Source Data Template:</b>	
<b>Acceptance Criteria:</b>	<b>Part Specific Template:</b>	

Sps is approved and no more changes are permitted in this module.



# Admin | Acknowledgement Page Change

1



Milestone Name	Date▲	Comments	Operation
Closure Required Before ⓘ	03-07-2019 <input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Acknowledgment Required Before ⓘ	04-21-2017 <input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Kickoff Discussion ⓘ	<input type="text"/> <input type="button" value="Calendar"/>	<input checked="" type="button" value="Edit Text"/> 2	<input type="button" value="Delete"/>
Hardware Need Date	<input type="text"/> <input type="button" value="Calendar"/>		<input type="button" value="Delete"/>
Add milestone	<input type="text"/> <input type="button" value="Calendar"/>		<input type="button" value="Add"/>

1. Go to the Acknowledgement section
2. Hover over the text field with the cursor and click EDIT TEXT



# Admin | Text Change

Administrative Change To Details

Original Text:

1

Make Changes To The Text Field Below:

2

Why Are The Changes Being Made?

3

Cancel

Next

1. Original text is shown
2. Change the text
3. Justify the change – click NEXT



# Admin | Text Change

ADMININSTRATIVE CHANGE TO DETAILS

VERIFY THAT THE QUALITY ENGINEERS LISTED BELOW IS CORRECT:

1 **QUALITY ENGINEER \*** Select a Quality Engineer in the list or search his na...

CANCEL **2 SUBMIT TO QUALITY**

1. Add GE Quality engineer for evaluation and approval
2. Submit to Quality



# Admin | Text Change

## Administrative Change To Details

Change Request Saved Successfully

1

Verify That The Quality Engineers Listed Below Is Correct:

Quality Engineer \*

Jerin Chacko

Email: Jerin.Chacko@ge.com,  
Phone:null

2

**Close**

1. Confirmation on changes
2. Select close



# Admin | Acknowledgement Change

Hello Carlota,

An administrative change is requested for C50TF12 manufactured at TEST1 by Vazquez,Carlota.  
Here are the links to the SPS to copy into your browser:

Internal: <https://digitalthread.aviation.ge.com/spa/20071341/sourcedata?adminchangeflag=true&adminchangeid=21069037&adminchangeapprovalrole=Quality%20Engineer>

External: <https://digitalthread.geaviation.com/spa/20071341/sourcedata?adminchangeflag=true&adminchangeid=21069037&adminchangeapprovalrole=Quality%20Engineer>

to understand the From-To fields and reasons for the change.

/\* This is a system generated email, please do not reply. \*/

1. The quality engineer will receive an email notification and a link for approval.



# Documents change

Note:

- This kind of change can be done in Source Data tab only



# Admin | Document Change

1

Sps is approved and no more changes are permitted in this module.

▼ Anodizing (2) | BRO | Sequence # 4

Operation description

## Requirements

Req\_Test1      3 Part families selected

Source Data  
 Edit Attachment  
 guest\_list\_template.csv  
Jul 25, 2017

1. Go to the Source Data section
2. Hover over the document



# Admin | Document Change

ADMINISTRATIVE CHANGE TO SOURCE DATA

ADMINISTRATIVE CHANGES CAN ONLY BE MADE TO SOURCE DATA THAT ARE CLERICAL OR CLARIFYING IN NATURE AND DO NOT AFFECT THE PHYSICAL PROCESS.

PLEASE UPLOAD THE REVISED DOCUMENT FOR BELOW.

1

2

Drop file here or  
[Browse](#)

CANCEL

NEXT

1. Download and view the existing file (should be visible here)
2. Upload updated file with corrections – Click NEXT



# Admin | Document Change

## Administrative Change To Source Data

What Changes Were Made To The Document? \*

1

Why are the changes being made? \*

2

Cancel

Next

1. Describe the changes made to the document – be as specific as possible
2. Explain why the changes were made and why they are administrative – Click NEXT



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# Admin | Document Change

ADMININSTRATIVE CHANGE TO DETAILS

VERIFY THAT THE QUALITY ENGINEERS LISTED BELOW IS CORRECT:

1 QUALITY ENGINEER \*

Select a Quality Engineer in the list or search his na...

CANCEL

2

SUBMIT TO QUALITY

1. Add GE Quality engineer for evaluation and approval
2. Submit to Quality



# Admin | Quality Review

Hello Patrick,

An administrative change is requested for 2462M75G02 manufactured at GRN by Steiger,Patrick. Here are the links to the SPS to copy into your browser:

1

Internal: <https://qa-digitalthread.aviation.ge.com/spa/30662/sourcedata?adminchangeflag=true&adminchangeid=84333&adminchangeapprovalrole=Quality%20Engineer>

External: <https://qa-digitalthread.aviation.ge.com/spa/30662/sourcedata?adminchangeflag=true&adminchangeid=84333&adminchangeapprovalrole=Quality%20Engineer>

to understand the From-To fields and reasons for the change.

/\*\* This is a system generated email, please do not reply. \*\*\*/

Quality engineer will receive an email notification with the proposed administrative change information

1. Review proposed Admin change by clicking link



# Approving an Admin change

Note:

- Only applicable to Quality engineer and in some cases to the Design



# Admin – Approving an Admin change

- When approving or looking for an admin change look for the icon  and click on it

Sps is approved and no more changes are permitted in this module. 

► Anodizing | BRO | Sequence # 4 

▼ Airflow Measurement | BRO | Sequence # 32

Operation description 

Requirements

Null - NDE - Sequence Only

The sequence of when a non-destructive inspect consult with the Special Process owner to deter this change in sequence. Please edit or delete th

**Source Data:**

-  [21 day fix tally.jpg](#) 
- [Aug 9, 2017](#)
-  [5.xls](#)
- [Jul 27, 2017](#)
-  [6.docx](#)
- [Jul 27, 2017](#)



# Admin – Approving an Admin change

1. Click on “Approve” to view the change and approve or reject

Administrative Change To Sequence#4

Changed To	Justification	Edited By	Approval	
Current Process	info is changing	Vazquez,Carlota	Quality Engineer	<b>Approve</b>

CANCEL



# Admin | Quality Review

Administrative Change

1708M21P01 - 1708M21P01  
BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
BRO - BROMONT  
PROCESS CHANGE - 4 - CURRENT PROCESS

TEXT

The Following Administrative Changes Are Requested.

Original Text:  
test

Revised Text:  
for user guide purposes

1

Why are the changes being made?  
info is changing

Does the Design Engineer need to review and approve the data? \*

YES  NO

2

Void Approve

3

Administrative Change

1708M21P01 - 1708M21P01  
BLADE, HIGH PRESSURE TURBINE ROTOR- STAGE 2  
BRO - BROMONT  
SOURCE DATA - ATTACHMENT - PROCESS CHANGE SCENARIOS.PPTX

FILE

The Following Administrative Changes Are Requested.

Original:  
 guest\_list\_template.csv  
07-25-2017

Revised:  
 Process  
Change  
Scenarios.pptx  
08-08-2017

1

What changes were made to the document?  
tes

Why are the changes being made?  
test

Does the Design Engineer need to review and approve the data? \*

YES  NO

2

Void Approve

3

Quality engineer:

1. Review change details and verify the change is administrative
2. Send to design engineer if needed (default is no)
3. APPROVE (and send to Design Engineer if selected) or REJECT (VOID)

Admin Change is approved.



# Admin | Engineering Review

1

Does the Design Engineer need to review and approve the data? \*

YES  NO

## ADMINISTRATIVE CHANGE

2462M75G02 - 2462M75G02  
BLADE, HIGH PRESSURE TURBINE ROTOR

GRN - GREENVILLE

SOURCE DATA - ATTACHMENT - INITIATION.DOCX

VERIFY THAT THE DESIGN ENGINEER LISTED BELOW IS CORRECT:

2

DESIGN ENGINEER \*

Patrick Steiger

Email:  
Patrick.Steiger@ge.com,  
Phone:null

3

GO BACK SUBMIT TO DESIGN

Quality engineer:

1. Elect to send the change details to the Design Engineer (approves for quality)
2. Add the appropriate Design Engineer contact (Design Engineer on last SPS will load by default)
3. Submit to Design

Request for approval mail is sent to Design Engineer



## Administrative Change To Sequence#4

Changed To	Justification	Edited By	Approval	
Current Process	info is changing	Vazquez,Carlota	Quality Engineer Design Engineer	<button>Approve</button>

CANCEL



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# Part Number conversion

## Note:

- Parts must be done at the same Source
- Part must have similar processes
- The part from where you are approving processes by similarity should have a fully approved New part workflow or an approved Significant Operations List
- PNC banner does NOT mean the operation(s) is approved, to approve the source or operation you still need to approve in the “package closure tab”



# Part Number Conversion | Initiation from dashboard

What would you like to do?

[New Part SPS](#)

[View Draft Requirements](#)

[Process Change](#)

[View/Edit Standard Requirements](#)

[Inadvertent Change](#)

[Manage Reviewers](#)

[Part Number Conversion SPS](#)

1

[View all my SPS packages](#)

[Need Help?](#)

1. From the Dashboard “What would you like to do?” card, click “Part Number conversion”



# Part Number Conversion | Initiation from process history page

Home Intelligence Design Quality Test

SPS Dashboard

Initiate SPS

New Part

Process Change

Inadvertent Change

Part Number Conversion

1

## Part Number Conversion

What part are you creating this record for?

Part Number

Part Description

What part is it being converted from?

Search By Part Number

Search By Source

Search

Cancel

Next

1. From the Initiate SPS menu, click “Part Number conversion”



# Part Number Conversion | Initiation

## Part Number Conversion

What part are you creating this record for?

Part Number

1

1234M56P02

Part Description

BRKT

What part is it being converted from?

Search By Part Number

2

1234M56P01

Search By Source

3

Search

Select the part number and source below (click row to select):<sup>1</sup>

4

	Part Number	Description	Source
<input type="checkbox"/>	1234M56P01	BRKT	12346

Cancel



5

Next

GE Aviation

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# Part Number Conversion | Initiation

## Part Number Conversion

Step 1: Select which process was used to manufacture 1234M56P01:

1

Select a revision

New Part - 1234M56P01-12346-0

Back      Cancel      Next

1. Select the process from where you are substantiating operations by similarity



# Part Number Conversion | Initiation

## Part Number Conversion

Step 1: Select which process was used to manufacture 1234M56P01:

New Part - 1234M56P01-12346-0

Step 2: Select the unchanging significant operations from 1234M56P01:<sup>i</sup>

Reorder

Sequence # 10 | Abrasive Blasting | 12346 - JOES FLAP SHOP

1

REV 0 - November 22, 2016

Sequence # 20 | Creep Feed Grinding (CFG) | 12346 - JOES FLAP SHOP

 SELECT OPERATION

REV 0 - November 22, 2016

Back

Cancel

Next

1. Select the significant processes that are being substantiated by similarity. This operations will not require any more source data or requirement editing.



# Part Number Conversion | Initiation

## Part Number Conversion

Step 3: Verify if the List of Operations is correct. Significant Operations from 1234M56P01 highlighted in green will be substantiated by similarity:

Sequence # | General | 12346 - JOES FLAP SHOP

REV -

Sequence # 10 | Abrasive Blasting | 12346 - JOES FLAP SHOP

1

REV 0 - November 22, 2016

Sequence # 20 | Creep Feed Grinding (CFG) | 12346 - JOES FLAP SHOP

REV 0 - November 22, 2016

+ Add Operation

2

Back

Cancel

Next

1. Verify the significant processes that are being substantiated by similarity.
2. If necessary add any operations that are not listed and that will be part of the new process by clicking the “+ Add Operation” button



# Part Number Conversion | Initiation | Add operations

## Part Number Conversion

Search for Standard Operations :

Operation

Specification Number

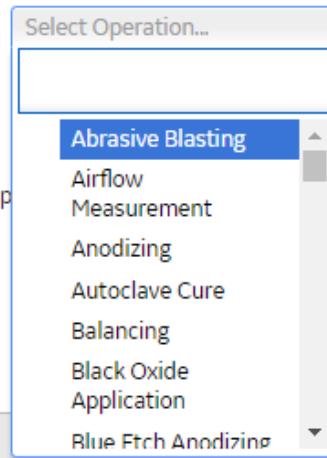
Do you need to add a new operation to the list above? Define the p

Yes  No

Back

Cancel

Add



1. Type the name of the standard operation or scroll down to find the name of the operation



# Part Number Conversion | Initiation

## Part Number Conversion

Search for Standard Operations :

1. Select the applicable spec
2. Click "add"

Operation

Chemical E...



Specification Number



	Spec	Operation
<input type="radio"/>	C50TF50, P3-TE5	Chemical Etching
<input type="radio"/>	C50TF50,P3-TE5	Chemical Etching
<input type="radio"/>	P4TF2	Chemical Etching
<input type="radio"/>	P4TF3	Chemical Etching
<input type="radio"/>	P4TF4	Chemical Etching
<input type="radio"/>	P4TF8	Chemical Etching
<input type="radio"/>	P4TF9	Chemical Etching

1

Do you need to add a new operation to the list above? Define the proposed operation name below:

Yes  No

Back

Cancel

2

Add



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# Part Number Conversion | Initiation

## Part Number Conversion

Step 3: Verify if the List of Operations is correct. Significant Operations from 1234M56P01 highlighted in green will be substantiated by similarity:

Sequence #	General	12346 - JOES FLAP SHOP	REV -
Sequence # 10	Abrasive Blasting	12346 - JOES FLAP SHOP	REV 0 - November 22, 2016
Sequence # 20	Creep Feed Grinding (CFG)	12346 - JOES FLAP SHOP	REV 0 - November 22, 2016
1	Sequence # <input type="text"/>	Chemical Etching   -	<a href="#">Delete Operation</a> REV 0 - February 2, 2017
<a href="#">+ Add Operation</a>			

[Back](#) [Cancel](#) [Next](#)

1. Add a sequence number
2. Repeat adding operations as necessary
3. Click next



# Part Number Conversion | Initiation

## Part Number Conversion

Provide a description of what is changing. \*

1

Why is this change being performed? \*

Back

Cancel

2

Next

1. Provide information in the boxes
2. Click Next



# Part Number Conversion | Initiation

## Part Number Conversion

Buyer

1

Not Applicable

Quality Engineer \*

Carlota Vazquez

Email: carlota.vazquez@ge.com, Phone:null

Design Engineer

Robert Epperson

Email: robert.epperson@ge.com, Phone:null

Materials Engineer

Jerin Chacko

Email: Jerin.Chacko@ge.com, Phone:null

Source Contact

Dalonda Morris

Email: dalonda.morris@ge.com, Phone:513-555-5555

Export Tagging Focal

Patrick Steiger

Email: Patrick.Steiger@ge.com, Phone:null

Back

Cancel

2

Review & Submit to Quality

1. Select the approval team
2. Click “Review and Submit to Quality”



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# Part Number Conversion | Initiation | Quality

Home Intelligence Design Quality Test



SPS Dashboard

Initiate SPS

1234M56P02-12346-0.0

Details

Export Tagging

Process History

**Caution** - Use or disclosure of the data on this page is subject to the restrictions defined in the export control section of this document.

1234M56P02-12346-0.0

BRKT  
SPS Type: Part Number Conversion  
Source: 12346-JOES FLAP SHOP  
Status: OPEN

[View Process History](#)

[View eCAV Data](#)

[View Drawing](#)

[View Specification](#)

[Download Attachments](#)

1

Submit

## Part Information

Part Number \*

1234M56P02

Part Description

BRKT

Commodity \*

Configurations Hardware

Part Family \*

Configurations - Harness - Engine

1. Verify the information is correct. The Part number conversion workflow will have the same Part family and commodity than the original part number. After the information has been reviewed; the GE Quality Engineer can “submit” the workflow. This will create a record.



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# Part Number Conversion | Initiation

Home Intelligence Design Quality Test



SPS Dashboard

Initiate SPS

1234M56P02-12346-0.0

Details

Requirements

Acknowledgement

Export Tagging

Process History

Help

1234M56P02-12346-0.0

BRKT

SPS Type: Part Number Conversion

Source: 12346-JOES FLAP SHOP

Status: OPEN

[View Process History](#)

[View eCAV Data](#)

[View Drawing](#)

[View Specification](#)

[Download Attachments](#)

[Show Operation Flow](#)

[Add Operation](#)

[Reorder](#)

This operation is substantiated by similarity to SPS ID 1234M56P01-12346-0

1

Abrasive Blasting | 12346 | Sequence # 10

▶ General | 12346

Options ▾

▶ Creep Feed Grinding (CFG) | 12346 | Sequence # 20

Options ▾

Operation description

- Operations approved by similarity will have a banner that will send you to the original record. Operations approved by similarity are accepted as is and will not allow you to add data or change requirements in it.



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# Define Alternate Path

## Enablers:

- Available to Source, Design Engineer, MAE, and Quality Engineer role
- An alternate path can be used for processes that are similar or that go to multiple suppliers
- Alternate paths can be set up in the requirements tab for Process changes, New Part, Part number conversion and Sig ops Lists.

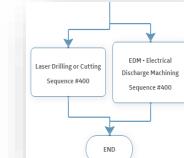


# Set 1 Alternate path



# Set alternate paths

To define an alternate path



1. Verify that the operations that will be set up as alternate are in the list
2. On the operation that will have an alternate path select options and “Define alternate path option”

L47253P02-12346-0  
NOZZLE,HIGH PRESSURE TURBINE-STAGE 1 (HOLE DRILL)  
SPS Type: New Part  
Source: 12346-JOES FLAP SHOP  
Status: OPEN

[View eCovData](#) [View Drawing](#) [View Specification](#) [Download Attachments](#)

[View Process History](#)

Show Operation Flow Add Operation Add Subcomponent Reorder

General | 12346 Options

**1**

Laser Joining - Secondary Weld | 12346 | Sequence # 2 Options

Operation description

**2**

**1** To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

**1** To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process? Yes No

EDM - Electrical Discharge Machining | 12346 | Sequence # 4 Options

Operation description

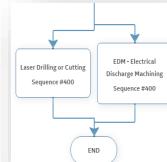
**1** To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

**1** Add a sub-tier supplier for this process? Yes No

Copy Operation Delete Operation Edit Requirements Mark as Rework Define Alternate Path Assign Subcomponent



# Set alternate paths



Add Alternate Path

Select one or more operations that define the alternate path;

Alternate Path Name : \* hole drilling 1

Sequence#	Operation Name	Operation Description	Source Code
4	EDM - Electrical Discharge ...		
5	Laser Drilling or Cutting		
10	Creep Feed Grinding (CFG)		

2 3

4 5

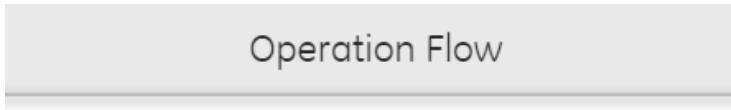
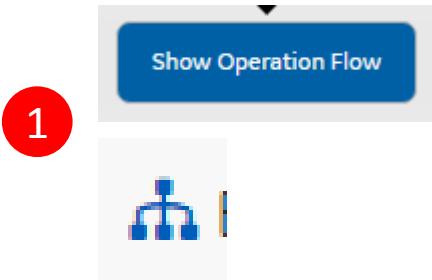
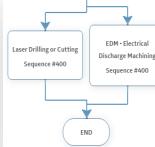
Cancel Submit

Alternate path is defined with selected operations.

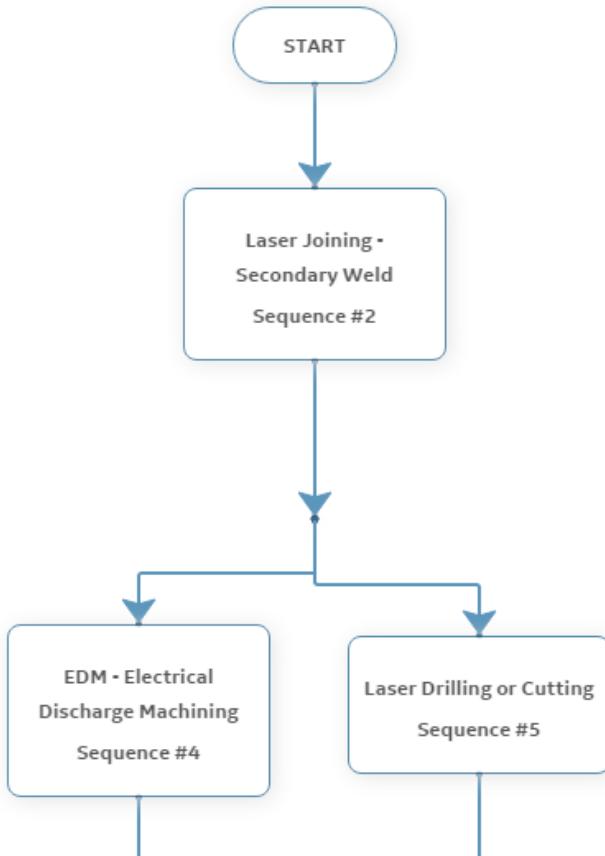
1. Name the alternate path
2. Select the operation(s) that will become the alternate
3. Click submit
4. Once completed a green banner will be display
5. Operations that are part of alternate paths will display this logo



# Set alternate paths



1. To view the alternate path, click on the “show operation flow” or in the alternate operation icon
2. Alternate paths are displayed for those operations that have a sequence number. You can have more than one alternate process along the workflow and multiple ones for an existing alt. path



Add multiple operations or  
remove operations in an  
Alternate path



# Add or remove more ops to alternate paths

To Edit an alternate path and add more operations:

1. Select Options and Define alternate path
2. Select the path that you want to edit or delete
3. To add more operations, select the operations
4. To remove operations unselect them
5. Click submit

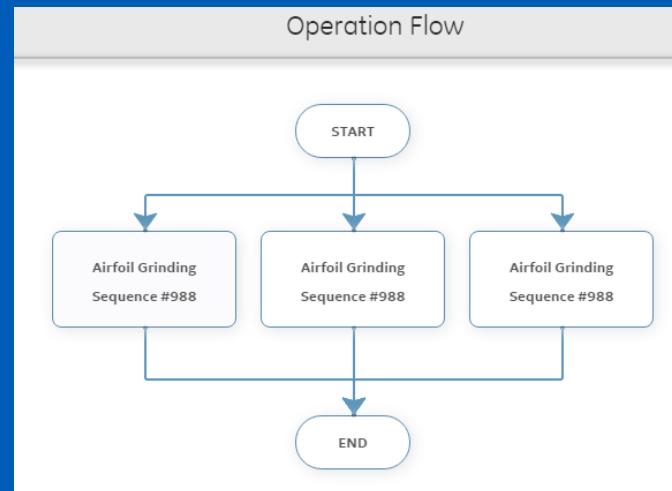
The screenshot shows a software interface for managing operations. At the top right, there is a green 'Options' button with a dropdown menu. A red circle with the number '1' is placed over the 'Options' button. The dropdown menu contains several items: 'Copy Operation', 'Delete Operation', 'Edit Requirements', 'Define Alternate Path' (which is highlighted in blue), and 'Assign Subcomponent'. A red circle with the number '2' is placed over the 'Define Alternate Path' item. Below the menu, there is a list of paths: 'alt. drilling' and 'Default Path\_5'. Each path has edit and delete icons next to it. A red circle with the number '3' is placed over the 'Default Path\_5' entry. In the center, a modal window titled 'Edit Alternate Path' is open. It contains a sub-instruction: 'Select one or more operations that define the alternate path;'. Below this, there is a table with the following data:

Sequence#	Operation Name	Operation Description	Source Code
2	Laser Joining - Secondary ...		
4	EDM - Electrical Discharge ...		
10	Creep Feed Grinding (CFG)		

A red circle with the number '4' is placed over the 'Submit' button at the bottom right of the modal.



# More than 1 Alternate path



# Sig Ops List | Edit – 3-Way Alternate path

If you have already set up an alternate path you can skip this page!

1

Add Operation

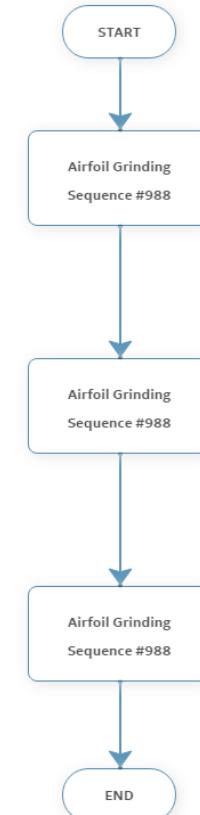
1. Add all 3 operations to your Sig Ops List.
2. Give them unique operation descriptions to help distinguish one from the other.
3. Include the Sequence # for each operation.

Airfoil Grinding | 91060 | Sequence # 988

Operation description: Grind 1

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Operation Flow



4. Your operation flow will look like this:



# Edit – 3-Way Alternate path

If you have already set up an alternate path you can skip this page!

5. Click Options in the primary operation – Select Define Alternate Path.

A screenshot of the GE Aviation software interface. At the top, it shows 'Airfoil Grinding | 91060 | Sequence # 988'. Below that, 'Operation description' is listed as 'Grind 1'. A message bar says, 'To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.' Another message bar asks, 'Add a sub-tier supplier for this process? Yes No'. On the right, a context menu is open under 'Options': 'Copy Operation', 'Delete Operation', 'Edit Requirements', 'Mark as Rework', 'Define Alternate Path' (which is highlighted with a red box and a red number 5), and 'Assign Subcomponent'.

## 6. Add Alternate Path

- Provide a unique Alternate Path Name.
- Select the first alternate operation.
- Click Submit.

A screenshot of the 'Add Alternate Path' dialog box. At the top, it says 'Add Alternate Path' and has a note: 'Select one or more operations that define the alternate path;'. A red box labeled 'a' highlights the 'Alternate Path Name' input field, which contains 'Alt 1'. A red box labeled 'b' highlights the checkbox next to the first row in the table below. The table has columns: Sequence#, Operation Name, Operation Description, and Source Code. The first row is checked and shows: Sequence# 988, Operation Name Airfoil Grinding, Operation Description Grind 2, and Source Code. The second row is not checked and shows: Sequence# 988, Operation Name Airfoil Grinding, Operation Description Grind 3, and Source Code. At the bottom are 'Cancel' and 'Submit' buttons, with a red box labeled 'c' highlighting the 'Submit' button.

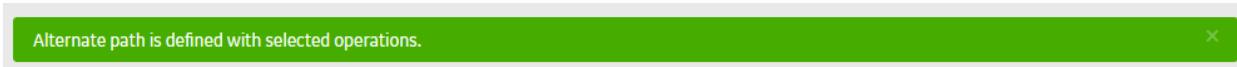
Sequence#	Operation Name	Operation Description	Source Code
988	Airfoil Grinding	Grind 2	
988	Airfoil Grinding	Grind 3	



# Sig Ops List | Edit – 3-Way Alternate path

If you have already set up an alternate path you can skip this page!

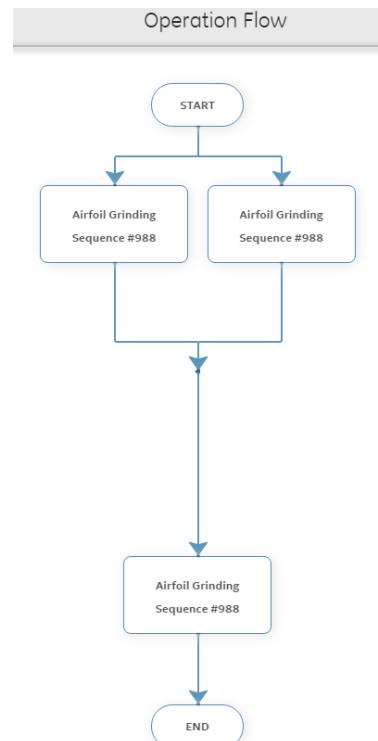
7. You will receive a notification like this:



And the alternate path icon will appear next to the operation title:

► Airfoil Grinding |

8. Your Operation Flow will now look like this:



# Sig Ops List | Edit – 3-Way Alternate path

9. Click Options in the first operation used.

- Select Define Alternate Path.
- Do not select one of the other already defined alternate paths.

Airfoil Grinding | 91060 | Sequence # 988

Operation description: Grind 1

To remove operations, you must now delete them using the Options menu at the top right corner of each row.

Add a sub-tier supplier for this process? Yes No

Options menu (highlighted):

- Copy Operation
- Delete Operation
- Edit Requirements
- Alt 1
- Default Path\_988
- Define Alternate Path (highlighted)
- Assign Subcomponent

10. Add Alternate Path

- Provide a unique Alternate Path Name.
- Select the next alternate operation.
- Click Submit.

Add Alternate Path 10

Select one or more operations that define the alternate path;

Alternate Path Name : \* Alt 2

Sequence#	Operation Name	Operation Description	Source Code
988	Airfoil Grinding	Grind 3	

Cancel Submit



# Sig Ops List | Edit – 3-Way Alternate path

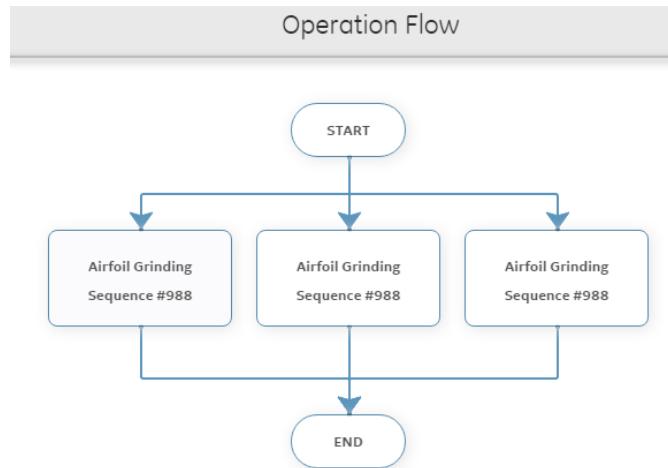
11. You will receive a notification like this:

Alternate path is defined with selected operations.

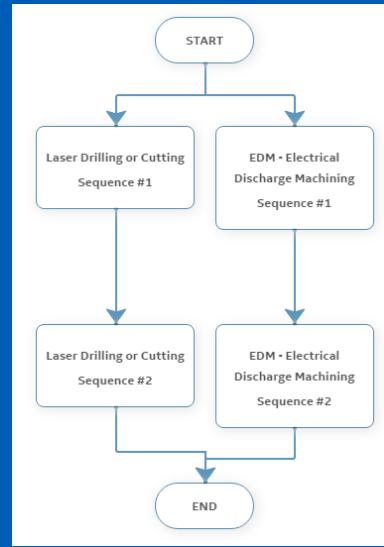
And the alternate path icon will appear next to the operation title:

▶  Airfoil Grinding |

12. Your operation flow will now look like this:



# More than 1 operation for each alternate path



# Sig Ops List | Edit – Multi-Op Alt Path

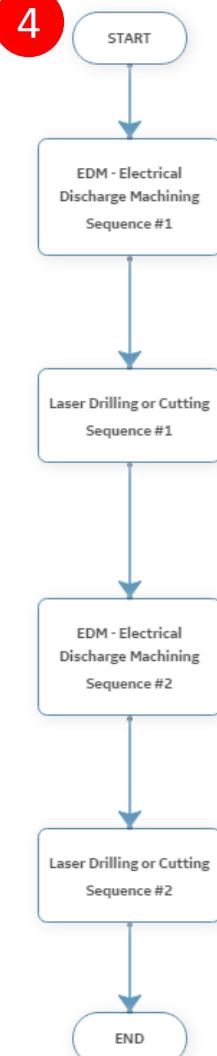
1

Add Operation

1. Add all operations to your Sig Ops List for your primary manufacturing path.
2. Give each operation unique Operation Descriptions to help distinguish one from the other.
3. Include the Sequence # for each operation.

The screenshot shows a software interface for managing manufacturing operations. At the top, there is a blue button labeled "Add Operation". Below it, a list of operations is shown, with the first item being "EDM - Electrical Discharge Machining | 91060". To the right of this item is a "Sequence #" input field containing the value "1", which is highlighted with a red box and circled with a red number "3". Below the list, there is a section for "Operation description" containing the text "EDM 1", which is also highlighted with a red box and circled with a red number "2". At the bottom of the interface, there is a question "Add a sub-tier supplier for this process?" with "Yes" and "No" buttons, and the "No" button is highlighted with a red box.

4



4. Your operation flow will look like this:



# Sig Ops List | Edit – Multi-Op Alt Path

6

1. Click Options in the first operation of your primary manufacturing path. Then, select Define Alternate Path.

EDM - Electrical Discharge Machining | 91060 | Sequence # 1

Operation description: EDM 1

Add a sub-tier supplier for this process? Yes No

Options ▾

- Copy Operation
- Delete Operation
- Edit Requirements
- Mark as Rework
- Define Alternate Path**
- Assign Subcomponent

Add Alternate Path

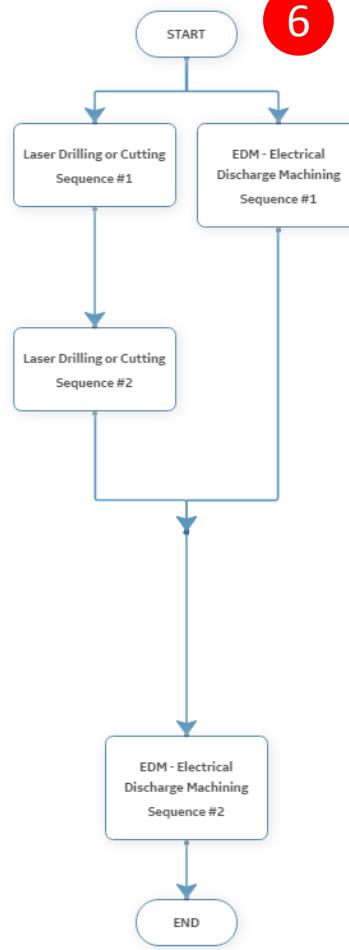
Select one or more operations that define the alternate path;

Alternate Path Name: \* Alt 1

Sequence#	Operation Name	Operation Description	Source Code
2	EDM - Electrical Discharge ...	EDM 2	
1	Laser Drilling or Cutting	Laser 1	
2	Laser Drilling or Cutting	Laser 2	

Cancel **Submit**

2. Provide unique alternate path name.
3. Select all operations in the alternate path.
4. Click Submit.
5. A notification like this will appear.
6. Your operation flow will look like this.



Alternate path is defined with selected operations.

5

# Sig Ops List | Edit – Multi-Op Alt Path

1. Click Options in the first operation of your primary manufacturing path. Hover over the Define Alternate Path option. Select the pencil icon of the Default Path option.

1

2

3

2. Select the missing operation.

3. Click Submit

4. A notification like this will appear.

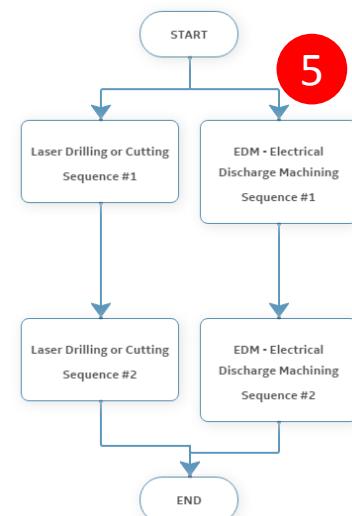


Selected alternate path is updated.

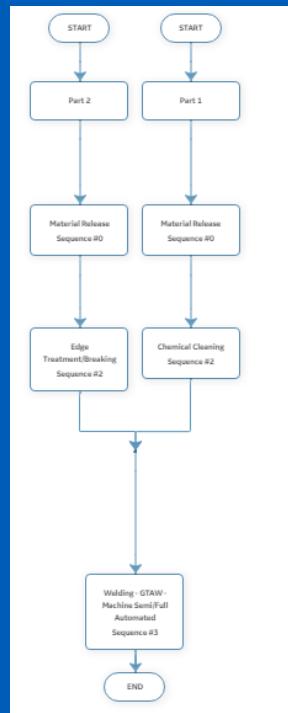
170

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5. Your op flow now looks like this.



# Defining Subcomponents



# Edit – Subcomponents

Many manufacturing processes involve bringing multiple subcomponent parts together. The following instructions will show you how to add these subcomponents to your Sig Ops List and bring them together to properly associate them to the appropriate significant operations.

1. Add each operation up to the first joining process for the first part.

Add Operation

1

2. Give them unique operation descriptions to help distinguish one from the other.
3. Include the Sequence # for each operation.

Material Release | 91060 | Sequence # 0

Operation description Part 1

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

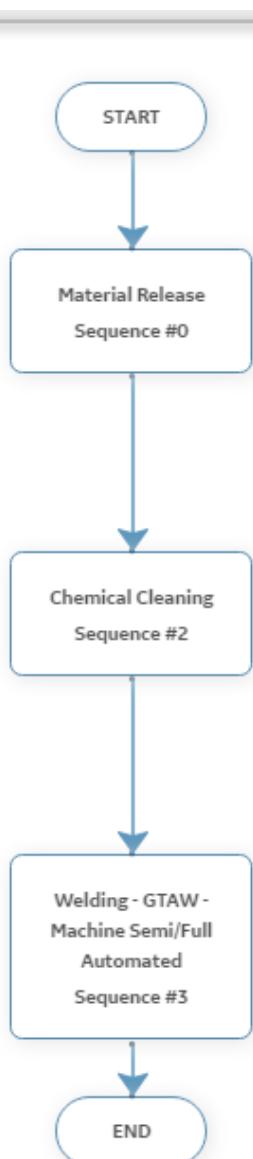
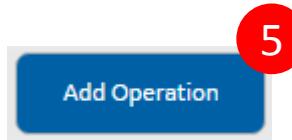
1. Add a sub-tier supplier for this process?



# Edit – Subcomponents

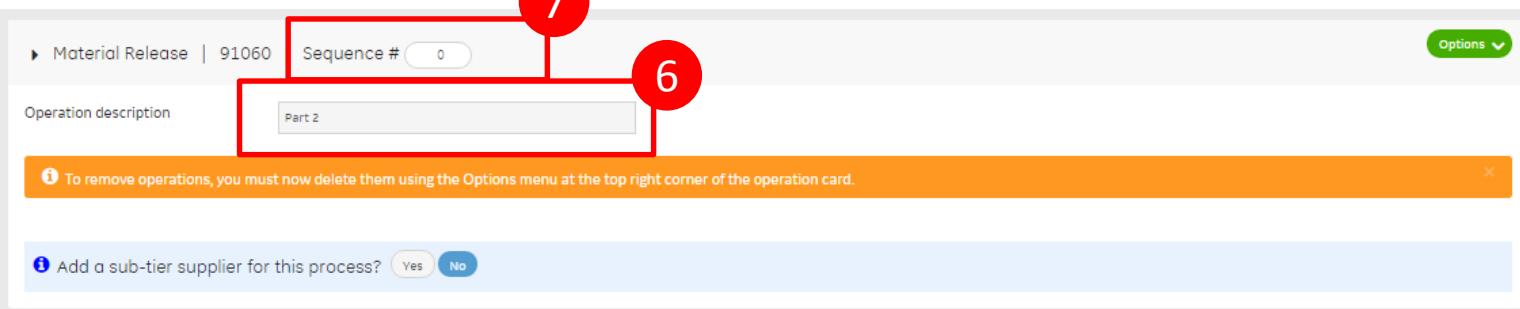
4. Your operation flow will look like this:

5. Add each operation up to the first joining process for the second part.



6. Give them unique operation descriptions to help distinguish one from the other.

7. Include the Sequence # for each operation.



Material Release | 91060 Sequence # 0 Options ▾

Operation description Part 2

To remove operations, you must now delete them using the Options menu at the top right corner of the operation card.

Add a sub-tier supplier for this process? Yes No



# Edit – Subcomponents

8. Your operation flow will look like this:

9. Click Add Subcomponent



10. Add Subcomponents

a. Provide a unique Subcomponent Name

b. Select all operations that apply to this subcomponent. You can select multiple operations by holding down the SHIFT key.

c. Click Add

Add Subcomponents

Create one or more subcomponents that define the assembly to be substantiated  
Operations can also be associated to components from the options menu on the requirements page.

Subcomponent Name: Part 1

Associated Operation (Optional):

- Material Release
- Material Release
- Welding - GTAW - Machine S
- Chemical Cleaning

**a** **b**

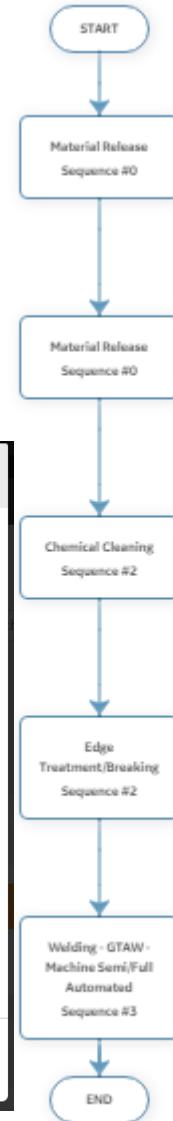
Add

Manage Subcomponents

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
-------------------	-----------	----------------	-----------------------	--------

**c**

Cancel      OK



# Edit – Subcomponents

- d. You will now see a notification like this.
- e. And summary of the subcomponents & their operations will appear here.

Add Subcomponents

Create one or more subcomponents that define the assembly to be substantiated  
Operations can also be associated to components from the options menu on the requirements page.

**d** Subcomponent is defined.

Subcomponent Name

Associated Operation (Optional)

**e** Add

Manage Subcomponents

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
Part 1	0	Material Release	Part 2	
Part 1	2	Chemical Cleaning	Part 1	

Cancel **Ok**



# Edit – Subcomponents

Note that the incorrect Material Release operation was chosen.

f. This can be removed by clicking the trash can icon.

g. You will see a notification like this if you do and the operation will disappear.



Selected subcomponent is removed. X

Add Subcomponents X

Create one or more subcomponents that define the assembly to be substantiated  
Operations can also be associated to components from the options menu on the requirements page.

Subcomponent is defined. X

Subcomponent Name

Associated Operation (Optional)

**Add**

Manage Subcomponents

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
Part 1	0	Material Release	Part 2	<span style="color: red; border: 2px solid red; padding: 2px;">f</span>
Part 1	2	Chemical Cleaning	Part 1	

**Cancel** **Ok**



# Edit – Subcomponents

h. You can also edit the subcomponent name to reassign it by clicking the pencil icon.

## Manage Subcomponents

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
Part 2	0	Material Release	Part 2	
Part 1	2	Chemical Cleaning	Part 1	

11. Now correctly assign the operations to both subcomponents.

## Manage Subcomponents

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
Part 2	2	Edge Treatment/Breaking	Part 2	
Part 2	0	Material Release	Part 2	
Part 1	0	Material Release	Part 1	
Part 1	2	Chemical Cleaning	Part 1	



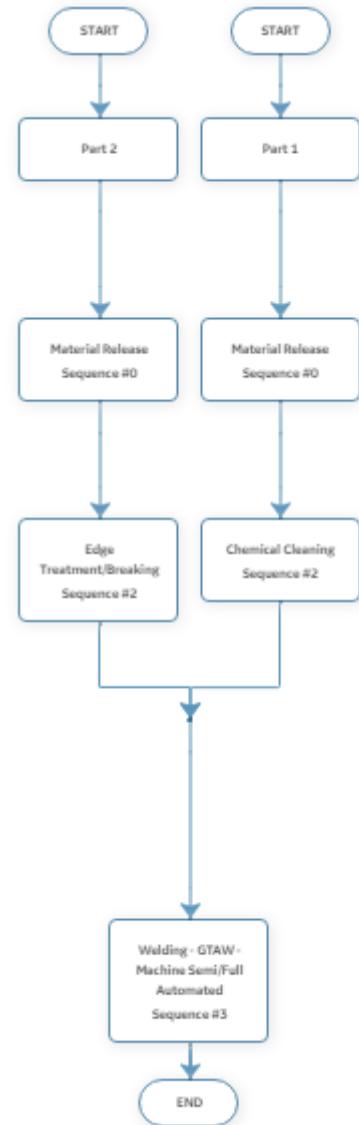
# Edit – Subcomponents

13. Your operation flow will now look like this:

Note how the operations are clearly split now.

Any operations not assigned to a subcomponent will automatically be assigned to apply to all subcomponents.

This will prompt a notification on the Package Closure page to state this operation is not assigned to any subcomponents.



# Edit – Subcomponents

To remove this notification and as a best practice these operations should be formally assigned to all applicable subcomponents.

Do this by adding the operation to each subcomponent.

Subcomponent Name	Sequence#	Operation Name	Operation Description	Action
Part 2	0	Material Release	Part 2	 
Part 2	3	Welding - GTAW - Machine Semi/Full Automated	Join Parts 1 & 2	 
Part 2	2	Edge Treatment/Breaking	Part 2	 
Part 1	0	Material Release	Part 1	 
Part 1	3	Welding - GTAW - Machine Semi/Full Automated	Join Parts 1 & 2	 
Part 1	2	Chemical Cleaning	Part 1	 



# Edit new part reason in draft state

Notes:

- New part reason can be modified before the New part workflow has been initiated.



# Appendix

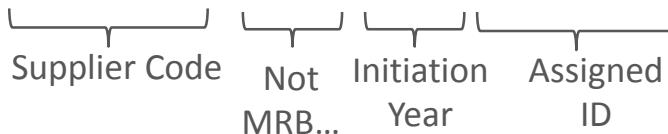
Notes:



# Key Things to Know

## VSE/SPS identification number change

From: XXXXX-VSE-YY-ZZZZZ



To: 1234M56P01-XXXXX-1.0



# Key Things to Know

## eVSE data migration

All eVSE data can be searched, accessed, and viewed through the new SPS application.

New Process Changes, Inadvertent Changes, Administrative, or other SPSs for documents in eVSE must first complete a **Significant Operations List** before full application functionality is available.



# Data Protection

Notes:



# Data Protection | LR Data

Digital Thread SPS is a GE owned application and is authorized to store **License Required Technology**.

All data is automatically assigned a “UNK” export status, which restricts the content to be viewed by US-based employees only.

Authorized export taggers can change the export classification of data and assign licenses if necessary.



# Export Control

Notes:





Export control is governed by International Trade Compliance (ITC) and [GE Policy 110.65](#).

Authorized export taggers are managed in the Trade Compliance Tool (TCT).  
Follow the following steps to obtain export tagging authorization:

1. Review [GE Policy 110.65](#)
2. Complete “Aviation Global Export Control Training” via [GE Learning](#)
3. Consult [ITC Portal](#) or [Commercial Compliance Portal](#) for additional resources.



# Data Protection | Export Control

Similar to VSE, an SPS document contains a general, overarching classification for the document itself, and separate classifications for each of the uploaded attachments

Tag the SPS:

SPS Data

**TAG SPS:**

Part Commodity: **Turbine Airfoils**

Part Family: **Turbine Blade, Cooled**

Engine Program: **ADVENGRIIG, GENX**

SPS Export Status: **UNK**

SPS Export License: **NA**

DAN Code: **[Empty]**

**1** **2** **3** **4** **5**

**Apply Drawing Tag**

**Tag In Single Tagging Wizard**

Drawing Export Status:	UNK
Drawing Classification:	[Empty]
Drawing Licenses:	NA
Justification:	[Empty]

1. Select “Export Tagging” tab
2. View **SPS Export Status**
3. View **Drawing Export Status**
4. Select “**Apply Drawing Tag**” to quick-tag the SPS with the drawing tag
5. Or select “**Tag in Single Tagging Wizard**” for other



# Data Protection | Export Control

Pro- tip!

Tag the SPS:

The screenshot shows a software interface for managing SPS (Supplier Part Specification) data. On the left, a sidebar lists 'Details', 'Requirements', 'Acknowledgement', and 'Export Tagging' (which is selected). The main area is titled 'SPS Data'. It features a 'TAG SPS:' section with two buttons: 'Apply Drawing Tag' (gray) and 'Tag In Single Tagging Wizard' (blue). Below this are several data fields:

- Part Commodity: Turbine Airfoils
- Part Family: Turbine Blade, Cooled
- Engine Program: ADVENGRIG, GENX
- SPS Export Status: UNK (highlighted by a red circle)
- SPS Export License: NA
- DAN Code: (empty input field)
- Drawing Export Status: UNK
- Drawing Classification: (empty input field)
- Drawing Licenses: NA
- Justification: (empty input field)

1. Use part commodity, part family, and engine program data to quickly find the appropriate DAN number for this document
2. Use this field to keep track of the DAN number for quick future reference
3. View the justification/rationale for the drawing export tag here instead of using EC Extract



# Data Protection | Export Control

Tag the attachments:

The screenshot shows the 'EXPORT TAGGING' tab selected (1). A list of attachments is displayed, with the second attachment (Demo 3.pptx) checked (2). The 'TAG ATTACHMENTS' section includes buttons for 'Download Attachments' (3), 'Apply Drawing Tag' (4), and 'Tag In Single Tagging Wizard' (5).

REF	ATTACHMENTS	EXPORT STATUS	CLASSIFICATION	EC LICENSE
NO	Demo 1.pptx	UNK	NA	
1528	Demo 3.pptx	UNK	NA	
1530	Demo 2.pptx	UNK	NA	
1532	Demo 4.docx	UNK	NA	

1. Select “Export Tagging” tab
2. Select documents
3. Download selected attachment(s)
4. Select “Apply Drawing Tag” to quick-tag the document with the drawing tag
5. Select “Tag in Single Tagging Wizard” for other classification options



# Data Protection | Export Control

Pro- tip!

Tag the attachments:

REF	ATTACHMENTS	EXPORT STATUS	CLASSIFICATION	EC LICENSE
NO	Demo 3.pptx	UNK	NA	
<input checked="" type="checkbox"/>	Demo 3.pptx	UNK	NA	
1526	Demo 2.pptx	UNK	NA	
1530	Demo 4.docx	UNK	NA	

1. Use the selection box in the header to select all displayed attachments after filtering
2. Download any individual attachment by clicking on the name
3. Use the sort and filter functionality to quickly isolate the documents you need
4. Use reference number (REF NO) to differentiate files with the same name



# Proprietary Information

Notes:



# Data Protection | Proprietary Information

Digital Thread SPS incorporates robust data protection capability. Data for a particular source can only be viewed by that source and by GE personnel who are trained and authorized to be in the system.

When required, further capability allows source data to be restricted to US based GE personnel only, regardless of export classification. This is used when special proprietary information agreements are signed between GE Aviation and suppliers.

When required, sub-tier SPS, or farmout SPS, offer a layer of protection between the sub-tier and the prime source. This enables the sub-tier to share proprietary data with GE Aviation while withholding it from the prime source.



# Data Protection | Proprietary Information

Throughout the SPS process, it is also important to protect GE proprietary data. For proprietary information requirements, refer to GE Policy 110.50.

Complete the latest version of “Proprietary Information” via GE Learning

Refer to the [Commercial Compliance Portal](#) for more info

\*Not applicable for external users

