



YOUR MISSION.
OUR HONOR

RELIANCE CHANGE MANAGEMENT (RCM)

04/11/2023





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WHAT IS AN RCM?

Definition

Reliance Change Management

- Used to communicate to Oshkosh when there is change request from the supplier
- Can be used to help root cause any field issues/questions
- Formal process to approve change request
 - Goes through Purchasing, Engineering and Quality
 - Risk mitigation for supplier
 - Eliminates the response, “we’ve always done it that way”
- Needs to be done before change is implemented
- If you don’t have access to Reliance, reach out to your Buyer or AQE

TWO DIFFERENT TYPES OF RCM'S

Process Change

This applies to either tier 1 or tier 2 supplier changes. Reasons for selecting this are, but not limited to, the below examples:

- Change tier 2 supplier
- Change/modify/repair/add tooling
- Change physical location
- Applies to buy-level and sub-components

Product Change

This applies to either tier 1 or tier 2 supplier changes. Reasons for selecting this are, but not limited to, the below examples:

- Request/notify alternate material
- Request dimensional/tolerance change
- Part finish change
- Applies to buy-level and sub-components

TEMPORARY OR PERMANENT CHANGE

Temporary Change

There is a select number of parts or orders that are requesting the deviation. Not requesting the print to be updated.

- Tier 2 supplier change due to supply chain
- Raw material change due to supply chain
- Applies to buy-level and sub-components
- Performance tests
- Material specifications

Permanent Change

The change being requested is permanent and will require a drawing change.

- Request alternate material due to obsolete
- Request dimensional/tolerance change
- Facility move
- Change tier 2 supplier
- Tooling modification/repair
- Print interpretation

IMPLICATIONS OF RCMS

Material/Performance Testing

Additional material/performance testing may be required based on disposition

- Radiography/NDT
- Continuity test
- Plating/painting cert
- Dimensional report

CFAT Requirements

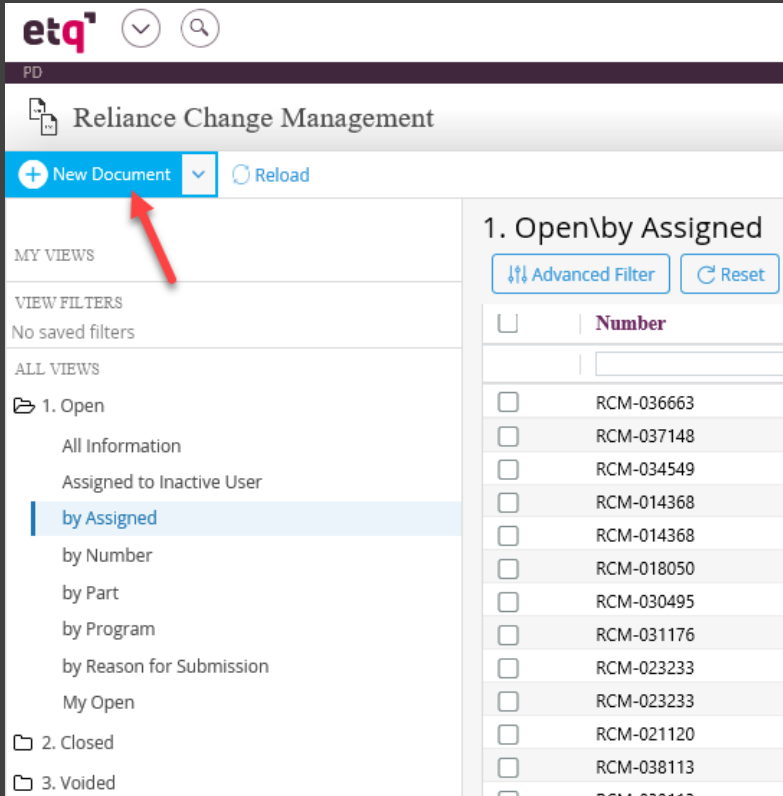
RCM may affect elements of CFAT for a specific part and require additional testing

- Full CFAT retest
- Partial CFAT retest
- Customer has ultimate decision

Updated PPAP Required

All approved RCMs will require an updated PPAP. The entire PPAP does not necessarily need to be updated. Only elements of the change need to be updated.

- PPAP reflects latest process and product
- Document temporary deviations



CREATING AN RCM

- Log into Reliance
 - Reach out to Buyer or AQE if you don't have access
- Select the RCM module
- Select "New Document" in the upper left corner

CREATING AN RCM (CONT.)

- Select Production or Aftermarket
- Indicate reason for submission
 - Permanent or temporary
 - Can include SCRIP (Supplier Cost Reduction Idea Program)
 - If temporary, indicate duration date and qty
- Is drawing change required?
 - For permanent changes
- When you plan on implementing the change
 - Used to determine when PPAP will be needed

Change Summary

Change Number * Segment **1**

Please Save Defense Production

Temporary or Permanent submissions must be approved by Oshkosh before any changes are made to the product

-Permanent Process Change Request: You / Your sub-tier supplier are moving your processing facility to a different s
-Permanent Product Change Request: You / your sub-tier supplier have a product Improvement proposal or determ
-Temporary Process Change Request: You / Your sub-tier supplier wants to temporarily use different equipment to p
-Temporary Product Change Request: You / Your sub-tier supplier want to use an alternate material due to a supply

* Reason for Submission - **2**

Temporary Process Change
 Temporary Product Change
 Permanent Process Change
 Permanent Product Change
 SCRIP (Supplier Cost Reduction Idea Program)
 Obsolete Part

Submission by

Internal Submission
 Supplier Submission

2a

* Drawing Change Required **3**

Yes
 No

* Temporary Deviation Durati...

* Temporary Change Quantity

* Requested Implementation Date **4**

CREATING AN RCM (CONT.)

- Select your reason for submission
 - Manufacturing Request
 - Drawing Error
 - Print Obsolescence
 - Supplier Change Request
 - Print Interpretation
 - Logistics
 - Indirect

Program

* PO # PO Due Date Buyer

* Description of the Proposed Change (Change To)

Manufacturing Request

Drawing Error

Print Obsolescence

* Ra Supplier Change Request

Print Interpretation

* Wt Logistics

Indirect :

Indirect

Attach a red-line drawing, marked up image, or any other supporting information to assist in communication of the

Attachment(s)

No Files

REASONS FOR SUBMISSION

Manufacturing Request

- notification of permanent process change
- temporary deviation
- economical production methods have changed
- facility move

Drawing error

- finish requirement not included on print
- tolerance error
- drawing with conflicting requirements
- inadequate or incorrect detail



REASONS FOR SUBMISSION (CONT.)

Print Obsolescence

- specification is obsolete
- part is obsolete



Supplier Change Request

- Source control
- Suggested source of supply
- Supplier request for change in configuration
- Legislative requirement

REASONS FOR SUBMISSION (CONT.)

Print Interpretation

- Visual question
- Dimensional question
- Notes question
- Color request
- Outdated prints attached



CREATING AN RCM (CONTINUED)

- Enter PO and due date
- Description of proposed change
 - Be specific with your request
- Rationale for change/deviation
 - The more information/data you enter, the better
- Benefit to Oshkosh?
- Attachments
 - Redline prints
 - Data collected
 - Pictures
 - Etc.

Program * Supplier Reason

* PO # **1** PO Due Date **2** Buyer

* Description of the Proposed Change (Change To) **3**

* Rationale for the Change **4**

* What is the benefit to Oshkosh Corporation? **5**

Attach a red-line drawing, marked up image, or any other supporting information to assist in communication of the

Attachment(s) **6**
 No Files

CREATING AN RCM (CONTINUED)

- Supplier information
 - Who to contact with questions

Supplier Information

[↑ Oldest to newest](#)

Supplier Lookup

Supplier Name Jaggaer Supplier Number ERP Supplier Number

Supplier lookup informat

Supplier Manufacturing Address

Please enter the location in which the part was manufactured

Supplier Contact(s) Telephone Number Email Address

Submitter Technical (Engineering) Contact Information

* Submitter Technical Contact * Submitter Technical Contact Phone # * Submitter Technical Contact Email

CREATING AN RCM (CONTINUED)

- Oshkosh part number, rev level and description
 - Lookup with fill PN and name
 - Can include multiple PNs
- Production, Aftermarket, Prototype part
 - Can be multiple
- Has component at rev level been approved?
 - Part looking for deviation

Product Information ▲ Collapse All

↑ Oldest to newest

Product Lookup **1** * Oshkosh Purchase Level Part # * Engineering Revision Level * Part Name

Product lookup informa Please enter the part number Please enter the part name

Oshkosh Lower Level Part # Lower Level Part Revision Lower Level Part Name Supplier Part #

* Production Part **2** * Aftermarket Part * Prototype Part Design Responsibility Safety/Government Regulation

Yes No Yes No Yes No Oshkosh Supplier Other Yes No N/A

* Has Component Been PPAP Approved? **3**

Yes No

Attachment

No Files

CREATING AN RCM (CONTINUED)

- Cost implications for change
- Reason for increase or decrease

Cost Information - Impact Per Part

All fields are required if Cost Effect is 'Increase' or 'Decrease'.
Explain cost change per unit of measure (i.e. \$20 per part)

* Cost Effect **1**

Increase
 Decrease
 No Impact

* Annual Purchase Volume

* Cost per Part USD

* Total Cost Impact USD

* Reason for Estimated Increase/Decrease **2**

Additional Cost Information
Press Refresh to calculate total

Materials USD

Transportation USD

Labor USD

Equipment USD

New Tooling USD

Other Cost USD

Other Cost Description

Total
0.00 USD

AFTER RCM CREATION

RCM Workflow

- Purchasing
- Quality
- Engineering
- Final Review

RCM Disposition

- Approved
- Partial Approval
- Rejected
- Request Acknowledged
- Temporary

RCM DISPOSITION

Rejected

- Scrap
- Rework

Approved

- Implement change per RCM
- Update process documents if necessary
- Gather documents to update PPAP



UPDATING PPAP WITH APPROVED RCM

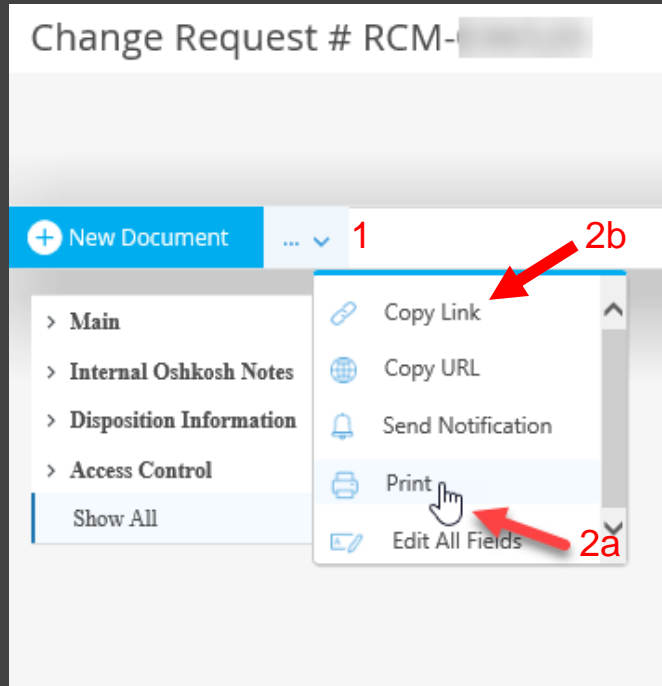
A new PPAP will be required after every RCM is approved/partially approved/temporarily approved for every part number in RCM.

- All applicable elements of PPAP need to be submitted
 - Only elements effected by RCM need to be updated (PSW, material certs, plating certs, PFD, etc.)
- RCM needs to be submitted with PPAP
- Utilizes the implementation date of change for PPAP submission date
- Have 60 days to submit PPAP after change is effective
 - After 60 days, parts will be non-salable



ATTACHING AN RCM TO PPAP

- RCM must be completed, approved and closed
- Open completed RCM
- Click on ellipsis or carrot key
- Select “Print” option or “Copy Link”
- If “Print”, you can then Open the PDF, or Save/Save As
- If “Copy Link”, see next slide



ATTACHING AN RCM TO PPAP (CONT.)

- Open PPAP task
- Select “Yes” for approved RCM
- If “Copy Link” was selected, you can paste in the “Linked Documents” section
- If saved as a PDF, you can submit it with the PPAP document

General Information

* PO Number

Segment*

* Buyer

Priority

Is there an approved RCM(Reliance Change Management)?

Yes **1**

No

Linked Documents **2** 0 link(s)

No Links

[Paste Link](#)

ATTACHING AN RCM TO PPAP (CONT.)

- Use the declaration line on PSW to indicate approved RCM is submitted with PPAP

Declaration: 1

I have noted on this part submission warrant any deviation from the associated des
Yes, Explain SEE RCM - [REDACTED]

Organization Authorized Signature _____

Print Name _____ Phone No. _____

Title _____ E-mail _____

FOR CUS
(Level 4 PPAP's

PPAP Warrant Disposition: Approved Rejected

Customer Signature _____

Print Name _____ Cu

DISTRIBUTION STATEMENT

KEY TAKEAWAYS

- Official process for deviation requests
- All supplier changes must be approved by Oshkosh
- RCM must be approved before implementing change
- Information in RCM is important
- All changes need to be verified
- Updated PPAP with RCM required
 - All PNs in RCM





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THANK YOU!





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Questions?





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