

NONDESTRUCTIVE TEST MARKINGS

AFTER EACH CASTING OR ITEM HAS SATISFACTORILY MET THE REQUIRED STANDARDS, IT IS TO BE PERMANENTLY MARKED AS FOLLOWS:

- A. RT FOR RADIOGRAPHIC INSPECTION, AND THE SERIAL NUMBER FOR IDENTIFICATION OF THE CASTING TO THE RADIOGRAPHS.
- B. MT FOR MAGNETIC PARTICLE INSPECTION.
- C. PT FOR LIQUID PENETRANT INSPECTION.
- D. UT FOR ULTRASONIC INSPECTION.

MARKING MUST NOT REDUCE THE WALL THICKNESS OF THE ITEM BELOW THE SPECIFIED MINIMUM. THE DEPTH OF IMPRESSION MUST BE AT LEAST .003" BUT NOT GREATER THAN .010". MARKING SHALL BE APPLIED BY ANY OF THE FOLLOWING METHODS:

- A. (CASTINGS ONLY) STAMPING WITH A ROUND BOTTOM STAMP ON A RAISED PAD SPECIFICALLY DESIGNED FOR STAMPING OR AS OTHERWISE SPECIFIED BY PLAN AND/OR PURCHASE ORDER;
OR
- B. A VIBRATING PENCIL (VIBRO TOOL) WITH ROUNDED OR BLUNT POINT; OR
- C. OTHER APPROVED METHODS.

WHEN MARKING IS PERFORMED BY USE OF THE VIBRO TOOL METHOD ON MATERIAL ON WHICH MARKING LEGIBILITY MAY DEGRADE, THE AREA BEING MARKED MUST BE COATED WITH A BLUE DYKEM TYPE SOLUTION PRIOR TO ETCHING.

EXEMPTION:

(FASTENERS) FASTENERS WHICH HAVE BEEN MANUFACTURED TO A SPECIFIC FASTENER SPECIFICATION SUCH AS (MIL-S-1222, MIL-N-25027) ARE NOT REQUIRED TO BE MARKED IN ACCORDANCE TO STANDARD CLAUSE 45-50.