

## **M4130-20041012**

IN ADDITION TO THE MILL MARKING REQUIRED BY THE APPLICABLE MATERIAL SPECIFICATION, METALLIC RAW MATERIALS WITH “STD” IN THE MATERIAL GROUP IN THE PART DESCRIPTION IN THE PURCHASE ORDER SHALL HAVE EACH HEAT BUNDLED SEPERATELY, WITH EACH BUNDLE SUBSTANTIALLY TAGGED OR PERMANENTLY MARKED ON BOTH ENDS AS FOLLOWS:

1. PURCHASE ORDER AND ITEM NUMBERS.
2. NEWPORT NEWS PART NUMBER (IF PROVIDED ON PURCHASE ORDER)
3. HEAT OR ANALYSIS NUMBER (WHEN REPORTS OF CHEMICAL/ MECHANICAL TESTS ARE REQUIRED HEREIN)

IN ADDITION TO THE MILL MARKING REQUIRED BY THE APPLICABLE MATERIAL SPECIFICATION, METALLIC RAW MATERIALS WITH “MC-I” OR “Q-1” IN THE MATERIAL GROUP IN THE PART DESCRIPTION IN THE PURCHASE ORDER SHALL BE INDIVIDUALLY PERMANENTLY MARKED ON BOTH ENDS AS FOLLOWS:

1. PURCHASE ORDER AND ITEM NUMBERS.
2. NEWPORT NEWS PART NUMBER (IF PROVIDED ON PURCHASE ORDER)
3. HEAT OR ANALYSIS NUMBER (WHEN REPORTS OF CHEMICAL/MECHANICAL TESTS ARE REQUIRED HEREIN)
4. MANUFACTURER’S TRADEMARK

MARKING MAY BE ACCOMPLISHED BY THE FOLLOWING METHODS:

1. FOR ALUMINUM OR COPPER TAG OR STAMP WITH INK OR PAINTS.
2. FOR CARBON STEEL PLATE ORDERED TO WEIGHT 7.35 LB. AND HEAVIER OR THICKNESS 0.180 AND THICKER WITH A WIDTH OF 48.000 AND WIDER SHALL BE MARKED AS FOLLOWS:

- A. DIE STAMPING - SUPPLIER HEAT AND SERIAL NUMBERS SHALL BE LOW IMPACT (ROUND BOTTOM) DIE STAMPED WITHIN A 12.000 SQUARE OF THE LOWER RIGHT CORNER IN

THE LONGITUDINAL DIRECTION REGARDLESS OF THICKNESS. IF THE SUPPLIER UTILIZES AN AUTOMATIC DOT MATRIX DIE STAMPING MACHINE, THE DIE STAMPING MUST BE WITHIN A 36.000 SQUARE OF THAT CORNER. IN EITHER CASE, THE STAMPINGS ARE TO BE CIRCLED WITH PAINT STICK TO IDENTIFY LOCATION.

- B. PAINT STICK - THE SUPPLIER SHALL MARK LEGIBLY IN A LEAST 4.000 HIGH LETTERS WITH PAINT STICK ALONG EITHER EDGE OF THE PLATE NEXT TO THE DIE STAMPING OR DOT MATRIX AS FOLLOWS:
- (1) NNS PURCHASE ORDER AND ITEM NUMBER (E.G. P646D-1350-H99 IT#15)
  - (2) NEWPORT NEWS PART NUMBER (NNPN)
  - (3) MATERIAL CODE DESIGNATOR (E.G. "MV" AS PROVIDED BY NNS). IN THE EVENT THAT THE MATERIAL CODE DESIGNATOR IS NOT KNOWN, THE SUPPLIER SHALL CONTACT NNS FOR CLARIFICATION.

3. FOR STAINLESS STEEL PLATES AND ALL OTHER MATERIAL TAG OR IMPACT DIE STAMP WITH LOW-STRESS ROUND BOTTOM DIES (NOT TO BE USED IN HIGH-STRESS AREAS) OR AIR OR ELECTRIC POWERED VIBRA-TOOL.

NOTE: SIZE MAY BE IN THE USUAL SIZE LETTERS BUT PURCHASE ORDER AND ITEM NUMBER, NEWPORT NEWS PART NUMBER, AND HEAT NUMBER SHALL BE IN LETTERS AT LEAST 4.000 INCHES HIGH WHEN MARKING SHEET OR PLATE.

NOTE: ON BARS TOO SMALL TO BE MARKED ON THE END, THE MARKINGS SHALL BE MADE ON THE SIDE OF THE BAR NEAR THE END.

THE USE OF YELLOW WRAPPING MATERIAL IS STRICTLY PROHIBITED. FAILURE TO COMPLY WITH THE REQUIREMENTS OF THIS PARAGRAPH SHALL BE CAUSE FOR REJECTION.