

Coded Note Number: **M4130**  
Revision Level: **C002**  
Date: **October 21, 2014**  
Title: **METALLIC RAW MATERIAL MARKING**

**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**

**Change from Revision C001.**

**Bolded font indicates changed/added content.**

**[Text deleted] inserted in the document indicates the removal of content.**

In addition to the Mill marking required by the applicable material specification, metallic raw materials with "STD" in the material control level identified in the **purchase order** part description shall have each heat bundled separately, with each bundle 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, Lot, or Analysis number

In addition to the Mill marking required by the applicable material specification, metallic raw materials with "MC-I" or "Q-1" in the material control level identified in the **purchase order** part description shall be individually and 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, Lot, or Analysis number
4. Manufacturer's trademark

Marking shall be accomplished by the following methods, provided that it does not violate Appendix P for MC-I control level materials:

1. Aluminum or copper that is identified with Material Control Level "STD" in the part description shall be tagged, or stamped with ink or paints.
2. 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 by:
  - 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 shall be within a 36.000" square of that corner. The stampings shall be circled with paint stick to identify location.

- Paint stick - marked with paint stick legibly in a least 4.000" high letters along either edge of the plate next to the die stamping or dot matrix with:

(1) NNS Purchase Order and Item Number (e.g. 4300237351#5)

(2) Newport News Part Number (NNPN)

(3) Material Code designator (e.g. "MV", provided by NNS in the Item information on the Purchase Order). In the event that the Material Code designator is not provided the supplier shall contact NNS for clarification.

3. Stainless steel plates and all other material shall be marked as follows:

- Material identified with "STD" in the material control level shall be die stamped, vibra-tool marked, or tagged.
- Material identified with "MC-1" or "Q-1" in the material control level shall be die stamped, or vibra-tool marked.

Note: Impact die stamp with low-stress round bottom dies (not to be used in high-stress areas), or mark with vibra-tool.

- In addition, for sheet and plate, the supplier shall mark legibly in at least 4.000" high letters with paint stick as follows:

(1) NNS Purchase order and Item Numbers

(2) Newport News Part Number (NNPN)

(3) Heat, Lot, or Analysis number

3. Markings must be legible, for bar too small to mark (i. e. less than 0.375" nominal size) marking shall be applied to a durable tag, and the tag shall be securely affixed to the material.
4. The use of yellow wrapping material is strictly prohibited. Failure to comply with the requirements of this paragraph shall be cause for rejection.