

AERONAUTICAL MATERIAL SPECIFICATION

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IDENTIFICATION Forgings

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. **MARKING METHODS:** All markings shall be visually clear.
 - 2.1 **Raised Marks:** Characters shall be formed in the forging dies and shall appear raised on the surface of the forging in the location indicated on the drawing by the symbol:

 - 2.2 **Stamping:** Characters shall be impressed in the surface of the forging, either while the forging is hot or after cooling.
 - 2.2.1 **Hot Impressed Marks:** Shall not exceed 0.060 in. in depth and shall be impressed on a surface that is to be machined or on a pad 1/16 in. high specifically provided on a surface which is not subsequently machined.
 - 2.2.2 **Cold Impressed Marks:** Shall not exceed 0.015 in. in depth and shall, unless otherwise specified, be impressed on a surface that is to be machined, as indicated on the drawing. When a location for stamping is not shown on the drawing, impressions shall be located where the effect of marking will be completely removed during subsequent machining. When cold impressed marks are applied to surfaces which are not to be machined, the impressions shall have fillets of not less than 0.006 in. radius at all intersecting surfaces.
 - 2.3 **Inking:** Characters shall be applied by a rubber stamp and a colored ink. The ink shall have a light etching effect on the metal. Inked markings shall be applied only when the conditions for stamping cannot be fulfilled or when specifically permitted by purchaser, to suitably prepared surfaces of forgings.
3. **RAISED MARKS:**
 - 3.1 The following information shall appear as raised characters on the forging except as specified in 4.1.1, 4.1.2 and Section 5.
 - 3.1.1 **Vendor Identification:** This shall consist of the vendor's trademark or letters, or symbol assigned by the purchaser to denote the vendor.
 - 3.1.2 **Forging Number:** This shall include the forging number and the change designation. The applicable change designation shall be the latest designation signifying a change to the drawing which has been incorporated in the forging.
 - 3.1.3 **Die Equipment Number:** This is required only when more than one set of finish dies is used by a vendor for making forgings of the same number and forgings are not partly machined by the forging vendor.
 - 3.2 When the area for raised marks is too small to permit marking with the information of 3.1.1, 3.1.2 and 3.1.3, the markings to appear shall, unless otherwise specified on the drawing, be in the following order of preference: Vendor's identification, forging number, and die equipment number.

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