



TME 2019

PRODUCT STANDARD

TME DIVISION, BHOPAL

TM 12548

Rev. No. 01

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Specification for Identification Marking of Traction Machines Components

1.0 Scope: This specification governs the requirements for identification marking of all components of traction machines (except electrical items, hardwares & bearings) either manufactured in-house or outsourced in raw material, semi-finished or fully finished condition.

2.0 Identification marking of components: The component manufacturer shall provide the identification marking depending upon the type of component (raw material/semi-finished castings, raw material/semi-finished forgings & fabricated components, fully finished components or sheet metal components) manufactured by it as per guidelines given below:-

A) CASTED COMPONENTS:

Sl. No.	Condition of supply	Identification marking requirement
1.	Castings/ semi-finished castings	<p>a) Method of marking in castings: Each casting shall be embossed & punched on un-machined surface/ etched on machined surface legibly and indelibly with following details:-</p> <p>i) Supplier's name initial , Heat no. ← To be embossed. (Example: SAIL/341)</p> <p>ii) xxxxx , MM-YY ← To be embossed/punched on cast surface or etched on machined surface.</p> <p>4 digits of date of manufacturing in MM-YY format</p> <p>Manufacturer's unique job serial no.</p> <p>(Example: 00345/0319)</p> <p>b) Method of marking in semi-finished castings: Each casting shall be embossed & punched on un-machined surface/ etched on machined surface legibly and indelibly with following details:-</p> <p>i) Supplier's name initial , Heat no. ← To be embossed. (Example: SAIL/341)</p> <p>ii) xxxxx , MM-YY ← To be embossed/punched on cast surface or etched on machined surface.</p> <p>4 digits of date of manufacturing in MM-YY format</p> <p>Manufacturer's unique job serial no.</p> <p>(Example: 00345/0319)</p> <p>c) Size & location: For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.</p>

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2.

Machined
castings on
labour basis

a) Method of marking after finish machining:

i) **When embossed marking is not removed:** In case the embossed marking is not removed during finish machining of the component, the component shall be punched with following details below the already existing embossed marking:-

Supplier's name intial , xxxxx , MM-YY

4 digits of date of manufacturing in MM-YY format

Manufacturer's unique job serial no.

(Example: SAIL/341)

← Already embossed.

ABCD/00345/0319

← To be punched.

ii) **When embossed marking is removed:** In case the component is machined all over & the embossed marking is removed, the same shall be re-punched on fully finished component. Date of finish machining in MM-YY format & manufacturer's details shall be punched below the above punched marking as per details given below:-

Supplier's name intial , xxxxx , MM-YY

4 digits of date of manufacturing in MM-YY format

Manufacturer's unique job serial no.

(Example: SAIL/341)

← To be punched.

ABCD/00345/0319

← To be punched.

b) **Size & location:** For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.

3.

Fully finished
casted
components

a) Method of marking in finished components:

i) **When embossed marking is not removed during machining:** Each component shall be **embossed & punched** on un-machined surface/ **etched** on machined surface legibly and indelibly with following details:-

Supplier's name initial , Heat no. ← To be embossed/already embossed.

(Example: SAIL/341)

xxxxxx , MM-YY

← To be embossed/punched.

4 digits of date of manufacturing in MM-YY format

Manufacturer's unique job serial no.

(Example: 00345/0319)

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ii) When embossed marking is removed during machining: In case the component is machined all over & the embossed marking is removed, the same shall be re-punched on fully finished component. Date of finish machining in MM-YY format & manufacturer's details shall be punched below the above punched marking as per details given below:-

Supplier's name initial , xxxxx , MM-YY

4 digits of date of manufacturing in MM-YY format

Manufacturer's unique job serial no.

(Example: SAIL/341)

← To be punched.

ABCD/00345/0319

← To be punched.

b) Size & location: For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.

B) FORGING / FABRICATED COMPONENTS:

1. Raw material/ semi-finished forgings and fabricated components

a) Method of marking in forgings & fabrications: Each component shall be punched legibly and indelibly with following details:-

Supplier's name initial , xxxxx , MM-YY , xxx

Heat no.

4 digits of date of manufacturing (forging/fabrication) in MM-YY format

Manufacturer's unique job serial no.

(Example: SAIL/00345/0319/341)

b) Size & location: For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.

2. Machined forgings/ fabrications on labour basis

a) Method of marking after finish machining:

i) When punched marking is not removed: In case the punched marking is not removed during finish machining of the component, the component shall be punched with following details below the already existing punched marking:-

Supplier's name initial , xxxxx , MM-YY

4 digits of date of manufacturing in MM-YY format

Manufacturer's unique job serial no.

(Example: SAIL/00345/0319/341)

← Already punched.

ABCD/00345/0319

← To be punched.



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		<p>ii) When punched marking is removed: In case the component is machined all over & the punched marking is removed, the same shall be re-punched on fully finished component. Date of finish machining in MM-YY format & manufacturer's details shall be punched below the above punched marking as per details given below:-</p> <p>Supplier's name initial , xxxxx , MM-YY</p> <div style="margin-left: 400px;"> <p>4 digits of date of manufacturing in MM-YY format</p> <p>Manufacturer's unique job serial no.</p> </div> <p>(Example: SAIL/00345/0319/341) ← To be punched.</p> <p>ABCD/00345/0319 ← To be punched.</p> <p>b) Size & location: For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.</p>
3.	Fully finished forged/fabricated components	<p>a) Method of marking in finished components: Each component shall be punched on un-machined surface/ etched on machined surface legibly and indelibly with following details:-</p> <p>Supplier's name initial / xxxxx / MM-YY / xxx</p> <div style="margin-left: 400px;"> <p>Heat no.</p> <p>4 digits of date of manufacturing in MM-YY format</p> <p>Manufacturer's unique job serial no.</p> </div> <p>(Example: SAIL/00345/0319/341)</p> <p>b) Size & location: For size and location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.</p>
C) SHEET METAL COMPONENTS:		
1.	Sheet metal components	<p>a) Method of marking: Each component shall be etched or punched as the case may be legibly with following details:-</p> <p>Supplier's name initial , xxxxx , MM-YY</p> <div style="margin-left: 400px;"> <p>4 digits of date of manufacturing in MM-YY format</p> <p>Manufacturer's unique job serial no.</p> </div> <p>(Example: SAIL/00345/0319)</p> <p>b) Size & location: For etching/painting and size & location of identification marks, supplier to take prior approval from BHEL unless otherwise specified in the drawing.</p>