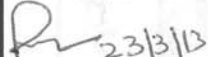
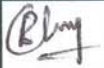
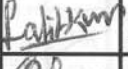


दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान मानक (हीप - हरिद्वार) PLANT STANDARD (HEEP - HARDWAR)	HW 0400397 पृष्ठ 6 का 1 Page 1 of 6
समग्री सूची संख्या को SUPERSEDES INVENT	Based upon KUN 107.01		
<u>IDENTIFICATION OF WORK PIECES</u>			
1.0 PURPOSE OF STANDARD :			
1.1 This standard shall be followed at HEEP for identification of work pieces. 1.2 To avoid mix-ups of parts of materials. To avoid placing identification marking where they might cause functional interference, for example notch effect. 1.4 To minimize re-stampings during manufacture. 1.5 To place the identification marking in identical location on identical parts. 1.6 To place the identification marking in such a manner as to leave them legible when the parts are assembled. 1.7 To place the identification marking in such a manner that corrosion and erosion cannot destroy the marking.			
2.0 IDENTIFICATION:			
2.1 Extent of identification Work order No. Drawing No. Q No. IR No. Heat No. in case of castings/ forgings			
स्वत्वाधिकार एवं गोपनीय इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।	हस्ताक्षर एवं दिनांक SIGN & DATE 		
समग्री सूची संख्या INVENTORY NO P-1709	सहमत विभाग AGREED DEPTT. PED	नाम NAME R. PANJA	दिनांक एवं हस्ताक्षर DATE & SIGNATURE 
		अनुवादक TRANSLATED BY	नाम NAME Lalit Kumar
		निर्माणकर्ता WORKED BY	दिनांक एवं हस्ताक्षर SIGNATURE & DATE 
		जांचकर्ता CHECKED BY	नाम NAME B. Choudhary
		पर्यवेक्षणकर्ता SUPERVISED BY	दिनांक एवं हस्ताक्षर SIGNATURE & DATE 
(Supersedes)		स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE	
Rev.No. 03 Dt. 18.03.2013		निर्माण : PREPARED : TSX	
		जारी : मानक विभाग ISSUED : TSX	
		दिनांक : DATE : 03.08.1984	
		GR.No. 1.10	

दिनांक एवं हस्ताक्षर SIGN & DATE			संस्थान मानक (हीप - हरिद्वार) PLANT STANDARD (HEEP - HARDWAR)		HW 0400397 पृष्ठ 6 का 2 Page 2 of 6	
सामग्री सूची संख्या को INVENTORY	SUPERSEDES INVENTORY	Material colour codes for ferrous materials as per corporate standard number AA0400305. Material colour codes or its abbreviation for aluminium & aluminium alloys as per corporate standard no. AA0400310. Material colour codes or its abbreviation for copper and copper alloys as per corporate standard no. AA0400310.				
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		Material test stamp as per quality assurance system no. SMI 301 (Material procurement control system) Supplier's number/ manufacture's symbol (if specified in order documents). Acceptance stamp of customer's representative (if agreed upon with customer). "All rough machined casting and forgings received at our works must be identified by the casting/ forging nos. stamped by the supplier based on numbers giving by BHEL on the indent. These identification number must be retransferred suitably at works on the casting/ forging in case they are removed due to further machining"				
स्वत्वाधिकार एवं गोपनीय इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।		2.2 Means of identification The identification is stamped on the part with a marking punch, except for the following: Sheet metal parts of $\leq 3\text{mm}$ thickness should be marked by electric engraver. Also wherever punching is not possible, admissible electric engraver can be used (see figure – 3) Not yet machined castings and forgings are to be marked with oil paint on the surface which will remain unmachined even after final machining as far as possible. After machining this identification must be replaced by punch marking. For identification marking example see pages 5. Smaller items such as fasteners M16 and below, machined parts of nipple connectors/ nut nipple set where punching/ engraving of identification details is not possible, the following procedure to be adopted:				
हस्ताक्षर एवं दिनांक SIGN & DATE 						
सामग्री सूची संख्या INVENTORY P-1709		Rev.No.03		निर्माणकर्ता WORKED BY	Lalit Kumar	 18.3.13
				जांचकर्ता CHECKED BY	B. Choudhary	 18.3.13

दिनांक एवं हस्ताक्षर SIGN & DATE			संस्थान मानक (हीप - हर्द्वार) PLANT STANDARD (HEEP - HARDWAR)	HW 0400397 पृष्ठ 6 का 3 Page 3 of 6	
सामग्री सूची संख्या को	SUPERSEDES INVENTORY	(i) For smaller items total weight less than 2Kg., these items may be put in plastic/ gunny bag suitably tied and bags may be tagged giving full details per clause 2.1. (ii) If the number of parts is large i.e. weighting more than 2 kg., these are to be packed in a wooden box and identification detail to be clearly written on the box by paint. (The requirements listed above to be mentioned in purchase order) (iii) After the receipt of the boxes in store, the items are to be verified , steeloscope testing for chemistry of the components is to be done by quality control. The boxes are to be closed and sealed after satisfactory verification by quality control. (iv) Shop planning/ shop store must be keep such boxes separately to avoid mixing with other similar items. (v) Production to maintain and keep the records of these items plant order wise and Q. No. also to be mentioned in the records.			
COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company					
स्वत्वाधिकार एवं गोपनीय इस प्रदेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो सकता है।		2.3 Process of identification Ferrous material and its alloys should be marked with the material colour code as per corporate standard no. AA0400305. Aluminium and copper material and its alloys should be marked with the material colour code as per corporate standard AA0400310. If the colour code during manufacturing is removed than the work piece must be marked with abbreviation equivalent to colour code of the material as per AA0400310. It must be shown on the accompanying documents and compared with the work piece prior to the start of the first operation. Remaining identification should be affixed after the part is checked.			
हस्ताक्षर एवं दिनांक SIGN & DATE 		2.4 Identification of sub-contracted material The identification of sub-contracted material/ semifinished parts, issued from stores shall be as per SMI- 623 (A) subcontracting			
सामग्री सूची संख्या INVENTORY P-1709	Rev.No. 03		निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY	Lalit Kumar B. Choudhary	 18.3.13  18.03.13



संस्थान मानक (हीप-हरिद्वार)

PLANT STANDARD (HEEP-HARDWAR)

HW 0400397

पृष्ठ 6 का 4

PAGE 4 OF 6

SYSTEMS WHICH READS AS UNDER:-

- 2.4.1 In case of issue of materials direct from stores, sub-contracting store will ensure that 'Q' mark and inspection seal are punched/ painted on total lengths/areas of plates by QCX before despatch of material to such contractor and these will be recorded on all the copies of SMIV by sub contracting store. (Ref. clause 9.6 of SMI 623-A)
- 2.4.2 In case of partly process materials shop planning will ensure that semifinished items are inspected and clear identification marks are punched/ painted by shop QCX before handing over to sub contracting store. (Ref. clause 10.5 of SMI 623 -A)

3 Drawing Notation:

The following shall be written in the vicinity of the title block of the blank drawing sheet:

Identification according to HW0400397

At the place indicated with IN →

The place of identification has to be indicated by an arrow and the letters in (IN) →

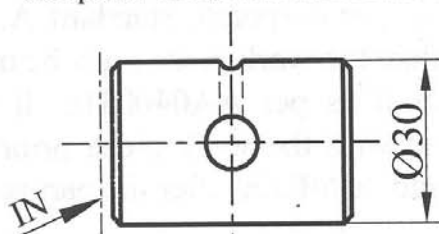


FIG.1

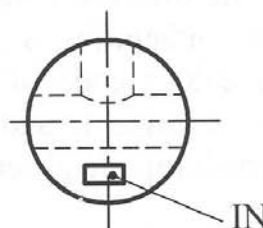
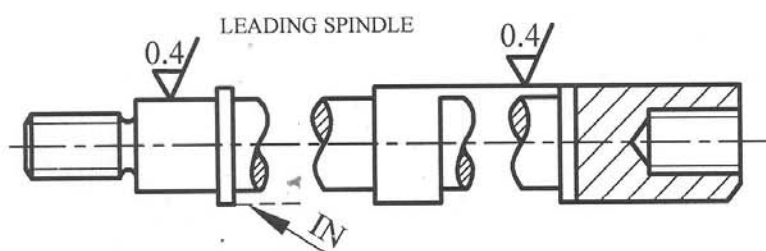


FIG.2

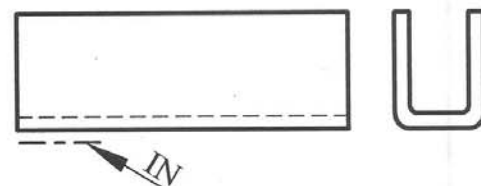
If it is not possible to allow to stamp the identification mark with a marking punch, one of the following remarks should be entered on the drawing.



WITH ELECTRIC ENGRAVER

FIG.3

INSULATING CAP
(MADE OF FORM-MIKANITE)



WITH FELT PEN/ SKETCH PEN

FIG.4

Rev.No. 03

निर्माणकर्ता
WORKED BY

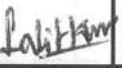
Lalit Kumar

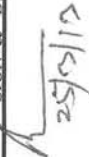
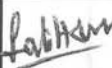
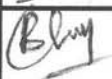
जांचकर्ता
CHECKED BY

B.Chodhary

18.3.13

18.3.13

दिनांक एवं हस्ताक्षर SIGN & DATE			संस्थान मानक (हीप - हरिद्वार) PLANT STANDARD (HEEP - HARDWAR)		HW 0400397 पृष्ठ 6 का 5 Page 5 of 6																	
SUPERSEDES INVENTORY सामग्री सूची संख्या को		In case of the mass produced parts eg. cores, spacers, conductors (hollow conductors and solid strands) and cooling pipes (generator construction) respectively condenser cooling pipes, the identification spot does not need to be indicated on the drawing, identification according to HW0400397 is sufficient.																				
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		Guidelines for the selection of the place of identification is contained in plant standard no. HW0400398. 4.0 SPACE REQUIREMENT: The size of the letter used for marking of casting and forgings with oil paint, as well as other parts with a marking punch is left to the individual operator. It should be chosen according to the space available for marking purposes as well as size of the part. The standardized letter and number of punch sizes at corporate level are 3, 5, 8 & 10 millimeter. See section 2.2 for means of identification if sufficient space is not available for stamping all the required information on the part.																				
स्वत्वाधिकार एवं गोपनीय इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।		5.0 EXAMPLES OF IDENTIFICATION MARKINGS: <table border="1" data-bbox="252 1281 1161 1563"> <thead> <tr> <th>TURBINE L.P. SHAFT</th><th>IDENTIFICATION</th></tr> </thead> <tbody> <tr> <td>WORK ORDER NUMBER</td><td>10049-A-107-01</td></tr> <tr> <td>DRAWING NUMBER</td><td>9 103 01 01000</td></tr> <tr> <td>IDENTIFICATION NUMBER FOR ATTESTED/ CONTROLLED MATERIAL</td><td>XX-X-X-XXXXXX-XX (As per AA4915)</td></tr> </tbody> </table> <table border="1" data-bbox="252 1630 1273 1899"> <thead> <tr> <th>MOVING BLADE</th><th>IDENTIFICATION</th></tr> </thead> <tbody> <tr> <td>WORK ORDER NUMBER</td><td>10049-A-107-01</td></tr> <tr> <td>DRAWING NUMBER</td><td>21 0 1 02010 01</td></tr> <tr> <td>MATERIAL CODE COLOUR</td><td>ORANGE-VOILET-ORANGE</td></tr> </tbody> </table>					TURBINE L.P. SHAFT	IDENTIFICATION	WORK ORDER NUMBER	10049-A-107-01	DRAWING NUMBER	9 103 01 01000	IDENTIFICATION NUMBER FOR ATTESTED/ CONTROLLED MATERIAL	XX-X-X-XXXXXX-XX (As per AA4915)	MOVING BLADE	IDENTIFICATION	WORK ORDER NUMBER	10049-A-107-01	DRAWING NUMBER	21 0 1 02010 01	MATERIAL CODE COLOUR	ORANGE-VOILET-ORANGE
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हस्ताक्षर एवं दिनांक SIGN & DATE 		Rev.No 03		निर्माणकर्ता WORKED BY	Lalit Kumar	 18.3.13																
सामग्री सूची संख्या INVENTORY P-1709				जांचकर्ता CHECKED BY	B. Choudhary	 18.3.13																

दिनांक एवं हस्ताक्षर SIGN & DATE			संस्थान मानक (हीप - हर्द्वार) PLANT STANDARD (HEEP - HARDWAR)		HW 0400397 पृष्ठ 6 का 6 Page 6 of 6																
सामग्री सूची संख्या को	SUPERSEDES INVENTORY	6.0 IDENTIFICATION NUMBER FOR ATTESTED/ CONTROLLED MATERIALS: The identification scheme for system for attested/ controlled material is as follows:																			
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		<table border="0"> <tr> <td>1</td> <td>2</td> <td>3</td> <td>4</td> <td>5</td> </tr> <tr> <td>XX</td> <td>X</td> <td>X</td> <td>XXXXX</td> <td>XX</td> </tr> <tr> <td colspan="3">SRV No.</td> <td colspan="2">SL. No.</td> </tr> </table> Barrel 1 will be two digits code representing the receipt cell concerned. Barrel 2 will be a single digit indicating whether the material required is imported or indigenous. '0' will be used for imported and '1' for indigenous materials. Barrel 3 will be a single digit representing the last digit of the financial year. (for example '4' will be written for 1984-85) Barrel 4 will be a five digit running serial numbers within Barrel 1 & 3. Barrel 5 will be serial number of the entry on store receipt voucher.					1	2	3	4	5	XX	X	X	XXXXX	XX	SRV No.			SL. No.	
1	2	3	4	5																	
XX	X	X	XXXXX	XX																	
SRV No.			SL. No.																		
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हस्ताक्षर एवं दिनांक SIGN & DATE	 25/3/13																				
सामग्री सूची संख्या INVENTORY	P1709	Rev.No.03		निर्माणकर्ता WORKED BY	Lalit Kumar	 18.3.13															
				जांचकर्ता CHECKED BY	B. Choudhary	 18.3.13															