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Superseding AMS 2808C	

Identification
Forgings

1. SCOPE:

This specification covers the requirements for identification of forgings, including die forgings, hand forgings, and rolled rings.

2. APPLICABLE DOCUMENTS:

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been canceled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AS478 Identification Marking Methods

3. TECHNICAL REQUIREMENTS:

3.1 Marking Method:

Shall be in accordance with any method permitted in AS478, unless a specific method is listed on the forging drawing or purchase order. Marking materials and procedures shall have no deleterious effect on the forgings or their performance.

3.1.1 When the forging configuration does not permit identification marking or when specified by purchaser, required identification shall be accomplished by tagging the forgings or by marking the package containing the forgings.

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3.2 Location:

Shall be as specified on the forging drawing or purchase order.

3.2.1 When a location has not been specified and a permanent marking method is to be applied, the supplier shall select a location that does not encroach on any edge, corner, fillet, or designated high stress area.

3.2.2 When a location has not been specified and a non-permanent marking method is to be applied, the supplier shall select a prominent location on the surface of the forging.

3.3 Required Information:

Shall be as specified on the forging drawing or purchase order. When required information is not specified, forgings shall be identified with the following information:

Forging/Part Number

Manufacturer's Identification

Die Equipment/Cavity Identification, when more than one set of dies is used.

Number(s) and/or letter(s) traceable to the chemical composition test data, as required by the forging material specification.

Number(s) and/or letter(s) traceable to the mechanical property test data, as required by the forging material specification.

Nondestructive testing acceptance marking, as required by the forging drawing and nondestructive testing specification.

3.3.1 Hand Forgings: Shall also be marked with an arrow indicating the direction of longitudinal grain flow. The marking on square or rectangular hand forgings shall be on a face parallel to the long-transverse grain direction. The marking location for other hand forgings, such as rounds, biscuits, or contoured shapes, shall be at the option of the forging vendor.

3.3.2 Forged or Rolled Rings: Shall also be marked with an arrow indicating the direction of predominant grain flow, when this direction is other than circumferential.

3.3.3 Test Specimens: When test specimens are not attached to the forgings, they shall be identified in accordance with the requirements of this specification to provide traceability to the forgings they represent.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of forgings shall be responsible for inspection to ensure that the identification markings are legible and have been accomplished in accordance with the specified requirements.