



TITLE:

PROCEDURE FOR IDENTIFICATION MARKING OF NAMMO TALLEY PRODUCTS

PREPARED BY:

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DATE:

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REVISION: K

ECO # 104826

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1.0 INTRODUCTION**1.1 Purpose**

This document establishes requirements for identifying deliverable products with standard human readable labels and machine readable (Unique Identification, UID) labels to assure proper identification of parts with applicable information in accordance with the Defense Federal Regulation Supplement (DFARS): Unique Item Identification and Valuation, (DFARS Case 2003-D081).

1.2 Scope

This procedure establishes the physical identification requirements for standard part marking labels and of the UID labels of parent parts, shipped subassemblies, assemblies, and/or sets IAW DFARS CLAUSE 252.211-7003 and MIL-STD-130 (UID) unless otherwise specified in the applicable contract.

Items will require a DoD compliant unique item identifier (UII) for all personal property items delivered to the Government under contract or in inventory or use if one or more of the following applies:

- (1) All items for which the Government's unit acquisition cost is \$5,000 or more;
- (2) Items for which the Government's unit acquisition cost is less than \$5,000, when *identified by the requiring activity as* serially managed, mission essential or controlled inventory;
- (3) When the Government's unit acquisition cost is less than \$5,000 and the requiring activity determines that permanent identification is required;
- (4) Regardless of value, (i) any DoD serially managed subassembly, component, or part embedded within an item and, (ii) the parent item that contains the embedded subassembly, component or part.

1.3 Definitions

Cage Code (Commercial and Government Entity): The code number identifies the activity that controls the design or produces the item.

Document: Applicable specification, standard, drawing, or other item used for procurement definition.

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Product: A term used to denote a parent part, assembly, subassembly, unit, or set that is shipped.
Enterprise Identifier: CAGE Code ([NAMMO TALLEY] 12116)

Construct #2: The enterprise, (NAMMO TALLEY), is responsible for items that are serialized within the part, lot, or batch number within the enterprise identifier, the UII data set includes the data elements of enterprise identifier, the original part, lot, or batch number, and the serial number.

Serially Managed: A distinction must be made between “serialized items” and “DoD serially managed” items. While DoD may use an item that has been serialized by the manufacturer, DoD may not manage the item by means of its serial number. When DoD elects to serially manage an item it becomes "DoD serially managed".

Mission Essential: A measure of an item's military worth in terms of how its failure (if a replacement is not immediately available) would affect the ability of a weapon system, end item, or organization to perform its intended functions.

Controlled Inventory: Those items that are designated as having characteristics that require that they be identified, accounted for, segregated, or handled in a special manner to ensure their safeguard and integrity.

1.4 Acronyms

DFAR	Defense Federal Acquisition Regulation
DFARS	Defense Federal Acquisition Regulation Supplement
UID	Unique Identification
IUID	Item Unique Identification
UII	Unique Item Identifier
MRI	Machine Readable Information
HRI	Human Readable Information
WAWF	Wide Area Work Flow

2.0 APPLICABLE DOCUMENTS

MIL-STD-130	Identification Marking of U.S. Military Property
DFARS 211.274-2	Policy for Unique Item Identification
DFARS Clause 252.211-7003	Item Identification and Valuation

3.0 PROCEDURE

3.1 Identification

Products will be identified by one of the following methods: (Parts within an assembly or a subassembly that are not normally subject to removal, replacement, or repair, need not be barcode marked unless contractually specified for IUID).

- 3.1.1 Identification Plate, Tag, or Label: Generally used on final assembly and will be securely fastened to the product. Metal and stiff plastic identification tags, along with their provisions for being attached, shall have all burrs and sharp edges removed.
- 3.1.2 Metal stamping, vibro peening, acid, electric or electro chemical etching, embossing, forging, blasting, casting, molding, or laser etching.
- 3.1.3 Decalcomania transfer, metal tag, stencil, silk screen or rubber stamp with ink.
- 3.1.4 Products that cannot be physically marked or tagged due to insufficient space, item configuration, damage of parts due to marking, or manufacturing processes, will be placed in properly marked containers as defined in MIL-STD-130, General Requirements.

3.2 Location of Identification and Method

Location of UID information labels and method of application shall be established by the Project Engineer, Quality Engineer and Manufacturing Engineer. Whenever practicable, the identification will be visible during item use (final assembly only). Subassemblies and parts will be marked in locations that will be hidden after assembly and will not interfere with the final assembly's identification number. On the final assembly, only one UID label shall be visible.

3.3 Re-Identification

Re-identification of items, such as altered items, selected items, or forgings and castings, requires removal or obliteration of the old identification number before marking with the new identification number.

3.4 Lettering

Lettering will be vertical capitals, Arial, Gothic, Futura, or other sans-serifs font, numbers will be Arabic, and other characters will be similar. Letters, numbers, and other characters will be clearly legible.

3.5 Marking

- 3.5.1 Items will be physically identified with the following minimum requirements:

Cage Number = 12116

Drawing Number = xxxxx

Appropriate Dash Number = -x

Marking Example = 12116-xxxxx-x

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3.5.2 Products that will require the additional UID Label will have the 2D label encrypted with the following minimum information:

- Cage Number = 12116
- Lot Number = XXXXXXXX-XXX
- Serial Number = XXXXX
- Part Number = XXXX-X
- Date of Manufacture (DOM) = X/X/XXXX

Additional information, Lot Numbers, Mix Numbers, etc., may be added as required by the contract.

NOTE: Requirements for physical part marking may be waived by Talley during the manufacturing or procurement processes at Nammo Talley, Inc. These parts must be clearly identified but do not have to be physically marked. Individual parts shipped as spares will have their own UII if they are valued \$5000 or more, Serially Managed, Mission Essential, Controlled Inventory or Require Permanent Identification. Parts shipped to government or customer bonded stores will be identified by the drawing or contract requirements.

3.5.3 Commercial Contracts

Items may be identified with an encoded bar code label and/or physical marking.

3.5.4 Government Contracts: UID Item

Items under contracts that require Unique Identification (UID) will have the following.

1. MRI - Lot Number. "NTI xxx-xxxxxx"
 2. *MRI - Cage Code. "12116"
 3. *MRI - Part Number "xxxxx"
 4. *MRI - Serial Number. "xxxxx"
 5. *MRI Date of Manufacture (DOM)
- *Minimum UID Requirements

This information shall be on both barcode (MRI) and standard (HRI) labels. Scanned verification of the UID information will be confirmed to match the standard label and the scanned data will be saved for input to the Wide Area Work Flow (WAWF) Electronic Submission and Processing of Payment Requests.

NOTE: For purposes of illustration, linear bar coding is used as an example of MRI marking. A 2D Data matrix is all that is required. (CONSTRUCT II, See paragraph 3.5.3)

4560



CAGE: 12116
 LOT No.: NT110E002-002
 SERIAL No.: 4560
 PART No.: 50656-1
 DOM: 6/29/2010

EXAMPLE

270-SJ rPnnUID

3.6 Marking Methods

Unique Identification labels shall be pressure sensitive, coated polyester with acrylic adhesive, with the information dimensions being approximately .5" x .5" exclusive of the 'quiet zone'. The label printer shall be a thermal transfer unit which will produce labels that best suit the application and durability requirements of MIL-STD-130.

In addition, Table 1 lists the human readable or visual marking methods at Nammo Talley. The applicable Project Engineer will use Table 1 to determine an acceptable marking method.

3.7 Drawing Callouts for Marking

The human readable information on the current drawing configuration will remain and a 2D data matrix UID label will be added as the required electronic identification.

Table 1 is a guideline for HRI, Visual Marking Methods on drawings. (Example): "Identify IAW Nammo Talley Procedure 12883, Method III B."

[NOTE: DFARS Case 2003-D081, Final Rule...

Comment 30: Will drawings have to be changed prior to adding the physical UID marking?
 DoD Response: ...(4) When the necessary marking information and criteria do not change the form, fit, or function of the part, the change does not require an immediate drawing update but rather can be accomplished by a coversheet with the marking instructions....]

Specific label material, configuration and application location of the label on the product will be incorporated onto the drawing only as additional product changes are required and the drawing is revised.

Per DFARS Case 2003-D081, Final Rule, the Standard Operating Procedure 12883 shall be precedence and serve as the necessary cover letter to include the UID label until such time that the product drawing requires revision.

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Label orientation: **Top and Right sides have no border**



Bottom and Left sides have a black border

TABLE 1. VISUAL MARKING METHODS, (HRI)

METHOD	DESCRIPTION	DEPTH (inch)
I	Rubber stamp/stencil ink per A-A-208**	
A	Black	Legible
B	White or other specified color	Legible
II	Tag	
A	Rubber stamp/stencil ink per A-A-208**	Legible
B	Metal Tag impression stamp	Legible – 0.006
III	Identify container by rubber stamp or stencil ink per A-A-208**	
A	Container (individuals)	Legible
B	Container (two or more parts)	Legible
IV	Casting, forging or molded	
A	Raised	Legible - 0.070*
B	Depressed	Legible - 0.070
V	Electrochemical	Legible - 0.001
VI	Scribe	
A	Engraving	Legible - 0.006
B	Electrical Arc	Legible - 0.005
C	Vibrating Tool	Legible - 0.005*
D	Pencil grinder	Legible - 0.005
VII	Mechanical	
A	Stamp	Legible 0.010
B	Roll	Legible 0.010
VIII	Identification plate	
A	Rubber stamp/stencil ink per A-A-208**	Legible
B	Metal Stamp	Legible
IX	Label identification	
A	Decalcomania	Legible
B	Pressure sensitive label	Legible
C	Pressure sensitive label (Effectivity, 5/15/2003)	Legible
X	Laser	Legible – 0.005

* Existing molds, casts or dies are acceptable

** A-A-208 Ink on metal surfaces requires lacquer overspray for permanency. Standard paint pen can be used for in-process marking methods. In-process marking methods for internal tracking can also be generated by the use of mechanical Inkjet marking and industrial coding systems. Marking and coding system inks shall require a chemical rub resistance to bleach, alkali, detergent, oils and water.