



**SUPPLY SPECIFICATION
MARKING TECHNIQUES FOR TRANSPORT CONTAINERS**

**Design
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1.0 PURPOSE AND SCOPE

This document specifies the requirements for the permanent marking (engraving, stamping, laser etching, vibro-engraving and paint marking) of components for transport containers for radioactive materials. It is not necessarily restricted to this application.

2.0 REFERENCES

SS 028: current issue: Quality assurance requirements for controlled materials.

3.0 DEFINITIONS

- Purchaser : REVISS Services (UK) Ltd.
- Supplier : Organisation named in the purchase order

4.0 QUALITY ASSURANCE

- See SS 028 for general quality assurance and documentation requirements.
- See purchase order and any specifications referenced therein for any supplementary requirements.

5.0 GENERAL

- The purchase order takes precedence over the manufacturing drawing.
- The manufacturing drawing takes precedence over this specification.
- The manufacturing drawing and/or associated supply specification will specify the content, size, position and marking technique.
- All text shall be in an upright, non-ornate (sans-serif) typeface. The capital letter height will be specified on the drawing or associated specification.
- All text and symbols must be faithfully reproduced. It is not permissible to change the case, omit, add or otherwise modify what is shown on the drawing or associated specification.
- Care should be observed in reading the drawing notes or associated specification. Variable text is usually shown as dashes or crosses with an instruction where to find the actual text (for instance "See purchase order for serial number").

6.0 MARKING TECHNIQUES

6.1 ENGRAVING

- Engraving is the machining of a U-shaped groove in the surface of a component.
- The groove width shall be 12-20% of the specified text height unless otherwise specified on the manufacturing drawing or specification.
- The groove depth shall be 0.10 - 0.30 mm.
- If "back-fill in black" is specified the Supplier shall use a waterproof paint or paint system recommended by the paint manufacturer for the base metal to ensure adequate adhesion.
- If a trefoil (the standard radiation warning symbol) is required and the drawing gives only the outer diameter the proportions defined in Figure 1 shall be used.
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6.2 LASER ETCHING

- Laser etching is the computer controlled oxidation of a stainless steel surface with a scanning laser.

- Line width shall be 12-20% of the specified text height unless otherwise specified on the manufacturing drawing or specification.
- If a trefoil (the standard radiation warning symbol) is required and the drawing gives only the outer diameter the proportions defined in Figure 1 shall be used.

6.3 STAMPING

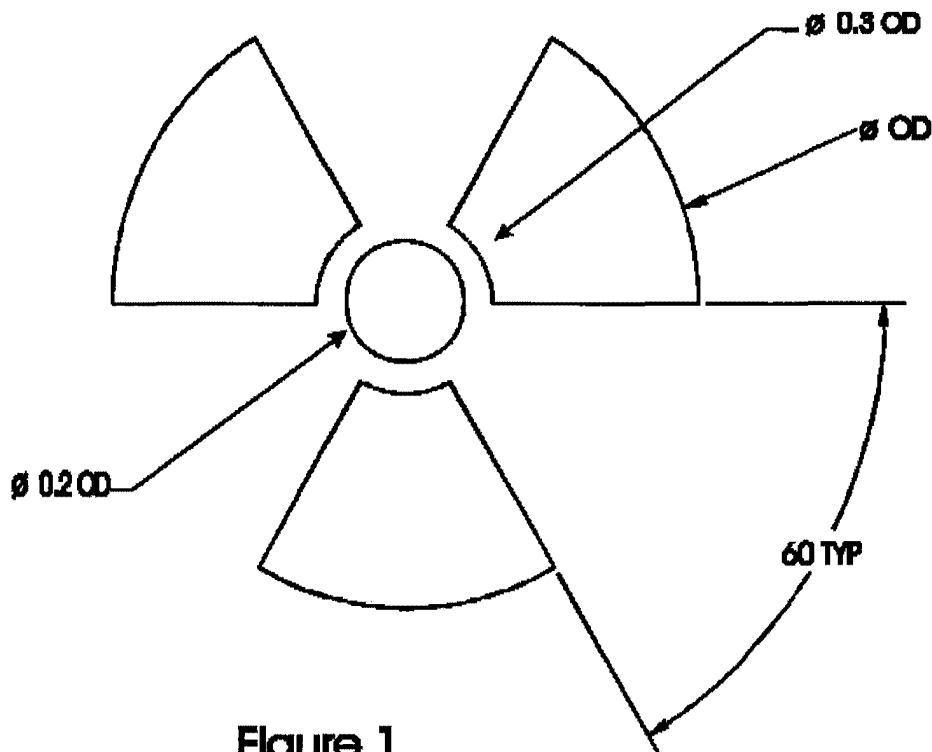
- Stamping is the indentation of a surface, one character at a time, by the impact of a shaped punch tool.
- The minimum depth shall be determined by legibility. The maximum depth shall be 0.5mm.
- Engraving is an acceptable alternative technique.

6.4 VIBRO-ENGRAVING

- Vibro-engraving is the indentation of a surface using a hand tool with a vibrating hardened tip.
- Text shall be non-ornate and clearly legible to the naked eye.
- Engraving or stamping is an acceptable alternative technique..

6.5 MARKING

- Marking is the application of text using paint and a stencil.
- It may be applied to metallic or organic base materials.
- The Supplier shall use a waterproof paint or paint system recommended by the paint manufacturer for the base material to ensure adequate adhesion.



**Figure 1
Trefoil Proportions**