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REF.: PA4201-03-02		08-12

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CONTROL SHEET

PROCEDURE ISSUING:

Issuing INDUSTRIAL MANAGEMENT
depart
ment:

MODIFICATION CONTROL:

<u>Edition</u>	<u>Date</u>	<u>Modified section</u>	<u>Description of the modification</u>
0	02 / 05		It invalidates and replaces the one with reference pag7502-01
1	08 / 12	4	It includes the sheets and cut or folded profiles.
1	08 / 12	5	Change of Quality Control and Environment Head by Quality Management Department.
1	08 / 12	6.3	It will include minimum identification of normalized sheets which are used as raw material of the bodyshell and rolling parts. It includes the minimum identification on sheets and cut and folded profiles which is included in the drawing.
1	08 / 12	6.5	It includes minimum identification for machined or welded parts. The title is modified "Marking method" instead of "Placement". It will include the normalized sheet marking used as raw material. It includes the marking on sheets and profiles which is included in the drawing. It includes the equipment marking method.

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1.- PURPOSE.

This procedure defines the criteria for the marking of the products which may require it.

2.- SCOPE.

This procedure is applicable to all the equipment in order to allow the Quality Control department to establish which are required to be marked.

If the drafts specify the marking method, it will prevail over the indications included in this procedure.

3.- REFERENCES.

- Quality Plan Issuing Procedure, ref.: PA4201-03

4.- DEFINITIONS.

Cut and folded sheets and profiles

Sheets and profiles manufactured according to the drawing.

5.- RESPONSIBILITIES.

Quality department

- Ensure that for the items/products which must be marked, the Quality Assurance Sheets will include the contents according to the instructions provided in this procedure.

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6.- DEVELOPMENT.

6.1.- SUPPLIER IDENTIFICATION

For all the products which are required to be marked in the Quality Assurance Sheet, the supplier will indicate so in the Quality Assurance Sheet, according to the general criteria provided in this procedure or according to the general criteria which is specified in section 7.3. in the "Purchasing General Conditions" ref. CGC/001/2003.

6.2.- PRODUCTS WHICH MUST BE MARKED BY THE SUPPLIER.

- a) Metal
- b) Plastic and polyester.
- c) Elastomers.
- d) Chemical Products.
- e) Equipment.

Standard products and those which lack marking space, due to their size, will be excluded.

6.3.- IDENTIFICATION CODE.

The materials/equipment, will be identified in Spanish on the same product, at least including the following data:

- 1) Chemical products will be labeled according to the standard in force.
- 2) For standard sheets which are used as raw material of the bodysheet and rolling parts: (without Talgo drawings). According to the standard.
- 3) For forged and casted parts.

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- Name or symbol of the supplier.
- Manufacturing date (month and year)
- Talgo drawing number, with revision state.
- Casting no.

4) Cut and folded sheets and profiles according to the drawing:

- Name or symbol of the supplier.
- Talgo drawing number, with revision state.
- Manufacturing date and Casting number (if its is required in the drawing).

5) For mechanized and welded parts:

- Name or symbol of the supplier.
- Manufacturing date (month and year)
- Talgo drawing number, with revision state.

6) For equipment:

- Name or symbol of the supplier.
- Manufacturing date (month and year)
- Talgo drawing number, with revision state.
- Reference and serial number.
- In the case of the electronic equipment, hardware and software revision level.

This code will be only applicable to the marking and therefore it does not modify the references which are used in the documentation used hitherto.

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6.4.- PLACEMENT

The criterion to be applied is that of respecting the area which is indicated in the corresponding drawing. If its lacks indications, it will meet those indicated below:

- a) Whenever possible, an area where the code can be visible without removing the part will be chosen.
- b) Areas under functional work will be marked.

6.5.- MARKING METHOD.

It will depend on the nature of the product.

a) Metal

- Casted: the marking will be high lettering and must be included in the mold.
- Forged: if they are not mechanized, they will have low lettering. In the case of machining, it will be performed with permanent ink on the blank, transferring these marks to the mechanized part by means of embossing.
- Machining: the marking will be performed using punches which will not have sharp edges or, failing this, electric pencil or acid emulsion.
- Normalized sheets used as raw material: applicable to the applicable standard.
- Cut and folded sheets and profiles according to the drawing: the marking will be performed using punches which will not have sharp edges or, failing this, electric pencil or acid emulsion or laser.

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b) Plastic and polyester.

- Plastic: the marking is incorporated in the mold and it can be either high or low lettering.
- Polyester: the marking will be performed by means of a permanent ink stamp on the unseen sides or by labeling.

c) Elastomers: The marking will be high and low lettering which must be included in the mold.

d) Chemical Products: The labeling, in addition to the manufacturer identification and reference, it will also include a warning indicating pictogram, expiry date and recontrol.

e) Equipment: The equipment marking will be done using an identification sheet or an adhesive sticker with permanent ink.

6.6.- DIMENSIONS

The height, thickness and space between letters and numbers will depend on the parts size and be given at the manufacturer's discretion. Nonetheless, for small parts, its height will be 3 mm, and for big parts it will not be greater than 20 mm.

The relationship between height, thickness and separations will be for guidance only.

Thickness = 1/10 height

Separation = 1/6 height

Those products which can have more than a supplier involved in the manufacturing process must include the identification code of each.