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1. Scope of application and purpose

Part markings must be carried out on all light alloy parts produced by introducing into a mold liquid or plastic for shaping, and on plastic injection molded parts as well as on steel forgings.

Not included are parts where marking is not or only partially possible for technical reasons (function, quality, surface) and/or lack of space.

2. General points

Only those labels must be put on parts which are indicated on the drawing and have the labels' position specified on the drawing. Generally, the position can be described by indicating a certain area or exact dimensions.

If nothing is else is specified on the drawing, the manufacturer can choose to put the labels raised by max. 0.5 mm or sunk by max. 0.5 mm.

The labels must be placed in accordance with the respective design of the forming tool.

3. Composition

The complete marking consists of :

Rotax symbol (not on steel forgings)

Manufacturing date (not on steel forgings)

Material number

Mold label (die number on steel forgings)

Material specification

2004687	3.1. Up-dating of the Rotax-symbol				RON116_en_2004687
2001115	manufacturer' label removed				RON116_2001115
2000475	Up-dating and revision				RON116_2000475
2002080602	Correction of font-type: BOLD instead BOND				RON116_2002080602
2000101305	Up-dating of the Rotax logo				RON116_2000101305
Edition	Description of change				Document
prepared on 2000 11 17	revised on 2007 12 03	Checked on 2007 12 10	checked on 2007 12 12	released on 2007 12 13	document no RON 116_en_2004687.doc
by AK/Ai	by AK/Ai	by MP/Br	by QP/BUN	by AK/Ai	replaces RON116_en_2001115.doc



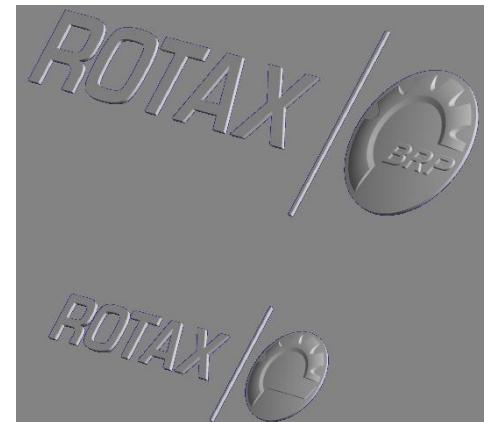
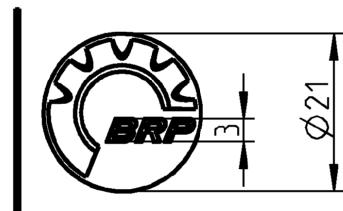
3.1. Rotax symbol

Size and position are specified on the drawing.

For light alloy cast parts:

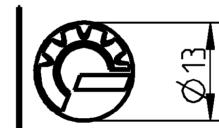
Size 1

ROTAX



Size 2

ROTAX



For plastic injection molded parts:

Size 1 is identical as light alloy cast parts

Size 2

ROTAX

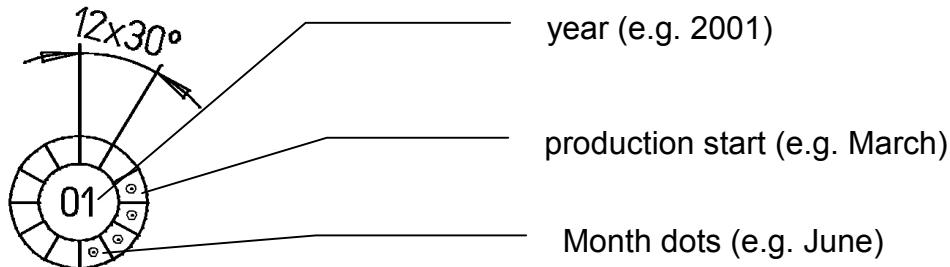


As a general rule, the symbol will be molded in the CAD-model. If this is not possible, in any exceptional case, than a model of the symbol will be allocated in ProE or various data format.

As a rule, the Rotax symbol is not put on steel forgings.

3.2. Manufacturing date

The symbol shown below should be treated merely as a recommendation. Any symbol whereby the year and the month of the parts can be identified is permissible.



The position of the manufacturing date is specified on the drawing, Rotax and the manufacturer must agree on the size and format.

As a rule, the manufacturing date is not put on steel forgings.

3.3. Manufacturer label

Attention:

**Application of manufacturer label on parts which toolings are ordered,
manufactured or renewed after 2006.07.01 is not permitted!**

3.4. Material number

The raw part number is put on castings and injection molded parts by metal-cutting.

As a rule, only the last three digits of the material number are put on steel forgings.

Position and size are specified on the drawing.

3.5. Mold marking

Cavity labelling must be placed on the component (on steel forgings the die number) for parts manufactured by multiple machine tools.

The position is specified on the drawing. If not indicated on the drawing, the size must be selected by the manufacturer in accordance with the available area in order to guarantee flawless legibility.

If not explicitly specified on the drawing, the way of marking is at the manufacturer's option. The parts must be unmistakably assignable to the respective tools.

3.6. Material specification

The material specification must be indicated on plastic injection molded parts on the component and is composed of the identification letters and codes according to ISO 1043-1 and ISO 1629.

Example: PA6.6 GF30

On steel forgings, the material number must be composed by leaving out the identification number 1 for steel.

Example: 5919 for 15CrNi6

Size and position are required according to each drawing.

4. Indications for application

On parts on which complete marking is not possible due to lack of space, the labels must be put in the following order

4.1. Injection molded parts of light alloy

1. Manufacturing date
2. Part number
3. Mold label
4. Rotax symbol
- 5.

4.2. Injection molded parts of polymere plastics

1. Material specification
2. Material number
3. Manufacturing date
4. Mold number
5. Rotax symbol

4.3. Steel forgings

1. Die number
2. Material number
3. Material specification

Standards cited herein:

ISO 1043-1
ISO 14629

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