AIPS
Airbus Process Specification

Marking process of identification for electrical harness (with sleeves NSA937201 and labels ASNE0248)

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Contents

1 Scope

This Airbus Process Specification defines the Engineering requirements for the marking process of identification for electrical harness with sleeves NSA937201 and labels ASNE0248.

This specification does not give detailed instructions; these are given in the Process Instructions (PI) / Airbus Process Instruction (AIPI) and the Work Instructions.

This specification shall not be used as an inspection document.

It shall be applied when mentioned in the relevant standard, material specification or Definition Dossier.

2 Normative references

Only normative references cited in the text are listed hereafter.

The latest issue of the publication referenced shall be used.

A1091	Airbus requirements for the management of hazardous substances.
ASNE0248	Marking, 4 or 6 holes label.
EN2424	Aerospace series - Marking of aerospace products. [1]
MIL-STD-202	Test methods for electronic and electrical component parts. [2]
NSA0021	Markings - Letters, figures, signs.
NSA937201	Sleeve – Identification, for electric cable.
SAE AS81531	Marking of electrical insulating materials.

3 Definition, applicability and limitations

3.1 Definition

Not applicable.

3.2 Applicability and limitations

This document is applicable for the marking process of identification for electrical harness with sleeve NSA937201 and label ASNE0248.

This Airbus specification is applicable when invoked by the drawing directly or through another document for the purpose given in the scope. When processing to AIPS07-06-004 is required, it shall be invoked on the drawing by the words “AIPS07-06-004 - Marking process of identification for electrical harness”.

Only the practice defined in this document is authorized.

4 Engineering requirements

Engineering requirements are minimum requirements specified by Responsible Engineering to ensure optimal performance of the manufacturing process.

All Engineering requirements have to be met and controlled in production.

[1] Published as ASD Standard at the date of publication of this standard
[2] Published by: Department of Defense (DOD), the Pentagon, Washington, D.C. 20307, USA

4.1 Performance requirements

All markings shall be permanent and shall not prejudice the requirements or performance of the product.

Identification carriers shall always be printed in black color letters.

The marking shall be legible without magnification after a possible surface treatment.

The character size (height) shall not be less than 0,8 mm. The preferred character size is 1,5 mm (see EN2424). For information on font types refer to NSA0021.

The marking must be centred, abrasion-proofed and resistant to aircraft fluids as specified in SAE AS81531.

4.2 Other requirements

The further processing of identification carriers after printing shall only be performed after a drying time of at least 30 minutes.

Note: The drying time is not necessary for thermo transfer printers.

5 Technical qualification

The Technical Qualification shall be performed, according to the relevant Airbus procedure.

For technical workshop process qualification, process control, regularly inspection purposes, the inspection tests of SAE AS81531, listed in table 1 shall be applied at minimum:

Table 1: Qualification tests

Designation of test	Requirement	Test method	Number of markings tested
Indentation	SAE AS81531 (as per subclause 3.4.1)	SAE AS81531 (as per subclause 4.6.1)	4
Adherence	SAE AS81531 (as per subclause 3.4.2)	SAE AS81531 (as per subclause 4.6.2)	4
Solvent resistance	SAE AS81531 (as per subclause 3.4.3)	MIL-STD-202 (as per test method 215)	4

6 First part qualification

Not applicable.

7 Series production inspection

The shop shall perform the following series production inspections under serial conditions.

7.1 Pre-operation

For the printer handling instructions see the manufacturer's operating manuals.

7.2 Inter-operation:

Assurance that the labels are manufactured in accordance with the manufacturing documents.

The tools used have undergone periodic checks.

7.3 Final check

Check the identification for:

- Background color.
- Character size, content and completeness of the text.
- Text centred and clearly legible.
- Labels with indistinct or smugged identification or defect shall not be used.

8 Rework

Not applicable.

9 Environment, health and safety

The manufacturing process shall be in line with Airbus Health and Safety and ecoefficiency policies.

Compliance with A1091 shall be ensured for all materials, substances and/or articles implemented during process.

In particular, targeted substances according to A1091 shall not be used, if a safer alternative is available.

Uses made of all substances involved in the process shall be documented in Safety Data Sheet as required by REACh regulation (Registration Evaluation and Authorization of Chemicals).

RECORD OF REVISIONS

Issue	Clause modified	Description of modification
1 08/06		New standard.
2 09/10		Global change of AIPS.