

**RAW MATERIAL SPECIFICATIONS - ALUMINUM COIL PRODUCTS**

**SCOPE: This raw material specification is to apply to all aluminum coil orders.**

- 1) Material must conform to the current revision of the following specifications:

2024-O Bare	AMS 4035	7055-O Bare	BMS 7-387
2024-O Clad	AMS 4461	7075-O Bare	AMS 4044
2024-T3 Bare	AMS 4037	7075-O Clad	AMS-4048
2024-T3 Clad	AMS 4041	7075-T6 Clad	AMS-4049
6013-T4	AMS 4347	7075-O Bare & Clad Hi Form	BMS 7-302
6061-O Bare	AMS 4025		
6061-T4 Bare	AMS 4026		
6061-T6 Bare	AMS 4027		

- 2) Test reports attesting to compliance with this specification must accompany material.
- 3) Tolerance to slit width is to be +/- .005"  
Material shall be uniform in quality and condition; clean, sound, smooth, commercially flat, and free from camber, buckles, blisters, and other injurious defects within the limits consistent with the best commercial practices. Slit edge of coil shall be burr-free. A light coat of oil that is approved for aerospace use shall be applied to the material prior to packaging.
- 4) Packaging shall prevent damage during shipment and shall include the following:  
-1/4" minimum cardboard or equivalent between skid and first coil  
**- 1 x 2 or equivalent separators between each coil**  
-1/2" minimum wafer board on top of package  
-Wrapped with waterproof and airtight protection  
-Banded with two 3/4" x .032" minimum metal or equivalent bands  
-.063" thick and thicker must be paper interleaved.
- 5) Quantity tolerance shall be +/-10% unless otherwise stated on the Purchase Order.
- 6) Each individual coil must be identified with material source and lot number.  
Absence of identification on individual coils will be cause for rejection.
- 7) This material is procured for aerospace applications.
- 8) Thickness tolerances, unless otherwise specified, shall be per ANSI H35.2, Table 7.7b.
- 9) Physical limitations shall be as follows:  
- Coil outside diameter 48" maximum  
- Coil inside diameter to be 16-20"  
- Minimum coil weight 50# per inch of width  
- 1,000# maximum coil weight  
- 3,000# maximum skid weight
- 10) Perform necessary activities to eliminate counterfeit materials.

