

**RAW MATERIAL SPECIFICATIONS**  
**INCONEL COIL PRODUCTS**

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

- 1) Material must conform to Federal Specifications as follows:  
Inconel 625 to AMS5599  
Inconel 718 to AMS5596  
Test reports confirming compliance with this specification must accompany material.
- 2) Tolerance on slit width shall be +/- .005".
- 3) 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.
- 4) Packaging shall prevent damage during shipment and shall include the following:
  - 1/4" minimum cardboard or equivalent between skid and first coil
  - Separators between each coil
  - 1/2" minimum wafer board on top of package
  - Skidded and wrapped with waterproof and airtight protection during shipment
  - Banded with two 3/4" x .032" minimum metal or equivalent bands
- 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 AMS2262, Table I.
- 9) Charles Engineering reserves the right to negotiate any changes to this purchase order due to changes in our schedule.
- 10) Physical limitations are as follows:
  - Coil inside diameter must be 16-20"
  - Coil outside diameter 48" maximum
  - Coil diameter not to exceed 50X width
  - Minimum coil weight 50# per inch of width unless otherwise approved
  - 1,000# maximum coil weight
  - 3,000# maximum skid weight
- 11) Perform necessary activities to eliminate counterfeit materials.

