

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 Bare	AMS-QQA-250/4
2024 Clad	AMS-QQA-250/5
6061-O Bare	AMS 4025
6061-T4 Bare	AMS 4026
6061-T6 Bare	AMS 4027
7055-O Bare	BMS 7-387
7075 Bare	AMS-QQA-250/12
7075 O Clad	AMS-4048
7075 T6 Clad	AMS-4049
  
- 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

