

**RAW MATERIAL SPECIFICATIONS**  
**ALUMINUM SHEET PRODUCTS**

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

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

2014-T3 Clad	AMS-QQA-250/3
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
7075 Bare	AMS-QQA-250/12
- 2) Test reports attesting to compliance with this specification must accompany material.
- 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 sheet 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) Sheets are to be skidded and paper interleaved for protection during shipment.
- 5) Skids shall be banded with 2 x 4's on top.
- 6) Quantity tolerance shall be +/-10% unless otherwise stated on the Purchase Order.
- 7) This material is procured for aerospace applications.
- 8) Thickness tolerances, unless otherwise specified, shall be per ANSI H35.2, table 7.7b.
- 9) Each order must be identified with material source and lot number. Multiple lot numbers skidded together must be physically separated. Absence of identification or separation will be cause for rejection.
- 10) Sheets shall be packaged as follows:
  - 48" wide sheets shall be packaged on wooden skids
  - Tolerance on 48" sheets on width and length to be +/-0.063"
  - Maximum skid weight to be 800#.
  - Orders shall be packaged individually subject to maximum skid weight.
  - Individual lot numbers to be separated with cardboard.
  - Protection required on all exposed edges.
  - All sheets must be paper interleaved.

