

**RAW MATERIAL SPECIFICATIONS**  
**17-7 PH ANNEALED STAINLESS STEEL COIL**

**SCOPE: This specification applies to 17-7 PH annealed stainless steel coil orders.**

- 1) Test reports testing to compliance with this specification must accompany material. Material must conform to the following Federal Specifications: **AMS 5528 Latest Rev.**
- 2) Thickness tolerances, unless otherwise specified, shall be per AMS2242, Table I.
- 3) Tolerance on slit width to be  $\pm .005$ ".
- 4) 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.
- 5) 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
  - Wrapped with waterproof and airtight protection
  - Banded with two 3/4" x .032" minimum metal or equivalent bands
- 6) Quantity tolerance shall be  $\pm 10\%$  unless otherwise stated on the purchase order.
- 7) Each individual coil must be identified with material source and lot number. Absence of identification on individual coils will be cause for rejection.
- 8) This material is procured for aerospace applications.
- 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
  - 1,000# maximum coil weight
  - 3,000# maximum skid weight

