

**RAW MATERIAL SPECIFICATIONS**  
**CUSTOM SHEARING REQUIREMENTS**

**SCOPE: This raw material specification is to apply to all custom shear orders**

- 1) 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.
- 2) Sheared edge of strips shall be burr-free.
- 3) Sheets are to be skidded and paper interleaved for protection during shipment.
- 4) Skids shall be banded with 2 x 4's on top.
- 5) This material is procured for aerospace applications.
- 6) For sheared strips, the following additional requirements apply:
  - Strips shall be packaged on skids 24" wide x 168" long.
  - Tolerance on sheared widths to be +/- .016" (1/64").
  - Maximum of .016" variation within each aluminum strip.
  - Maximum skid weight to be 800#.
  - Orders shall be packaged individually subject to maximum skid weight.
  - Maximum 5 set-up (scrap) pieces per order.
  - Individual lot numbers to be separated with cardboard and marked
  - Protection required on all exposed edges.
- 7) Perform necessary activities to eliminate counterfeit materials.

