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(Cancelling B.S. Specification L. 38.)

NOTE.—The Institution desires to call attention to the fact that this Specification is intended to include the technical provisions necessary for the supply of the material herein referred to, but does not purport to comprise all the necessary provisions of a contract.

British Standards Institution.

Incorporated by Royal Charter.

FORMED IN 1901 AS THE ENGINEERING STANDARDS COMMITTEE.

INCORPORATED IN 1918 AS THE BRITISH ENGINEERING STANDARDS ASSOCIATION.

BRITISH STANDARD SPECIFICATION

FOR

ALUMINIUM COATED ALUMINIUM ALLOY

SHEETS AND COILS

FOR AIRCRAFT PURPOSES.

(Specific Gravity not greater than 2.85.)

1. **Quality of Material.** (a) The sheets and coils shall consist of a core of the alloy specified in Clause 2 (a), coated uniformly on both sides with aluminium of the quality specified in Clause 2 (b).

(b) The sheets and coils shall be made by an approved process.*

(c) The aluminium used for making the core shall be in accordance with the latest issue of British Standard L. 31.

(d) The copper used for making this core shall assay not less than 99.8 per cent.

(e) No scrap shall be used other than that derived from the Manufacturer's own manufacture.

2. **Chemical Composition.** (a) The chemical composition of the alloy shall be:—

Copper	-	-	not less than 3.5 nor more than 4.5 per cent.
Manganese	-	" " "	0.4 " " " 0.7 per cent.
Magnesium	-	" " "	0.4 " " " 0.8 per cent.
Silicon	-	-	not more than 0.7 per cent.
Iron	-	-	" " " 0.7 per cent.
Titanium	-	-	" " " 0.3 per cent.
Aluminium	-	-	the remainder.

(b) The composition of the coating shall be:

Aluminium - not less than 99.7 per cent.

(c) The Manufacturer shall supply, when required, the complete analysis of the material from which the core of the sheets and coils has been prepared to the Inspector.

(d) A cast shall be defined as:—

- (i) The product of one furnace melt.
- (ii) The product of one crucible melt.
- (iii) The product of a number of crucible or furnace melts where such are aggregated and mixed prior to casting.
- (iv) Where a continuous melting process is employed, a cast shall be taken as the amount of metal tapped from the furnace without any further additions of alloying constituents having been made.
- (v) Or as otherwise defined from time to time.

3. **Heat Treatment.** (a) Unless otherwise specified on the order, sheets and coils shall be delivered in the finally heat-treated and aged condition, and in this condition before straightening must comply with the mechanical tests specified in Clause 7.

*Attention is called to the fact that certain processes of manufacture are the subject of claims in certain British Patent Specifications.

(b) The sheets and coils shall be finally heat-treated by being heated uniformly to a temperature of 495° C. plus or minus 10° C. and quenched in water or oil; they shall then be aged at room temperature for five days.

All material to be used for aeronautical purposes must give the required mechanical properties after heat-treatment at the temperature specified above. Material for other purposes may be heat-treated at different temperatures from those specified, provided that these temperatures are stated by the Manufacturer on the test certificate. On no account in workshop practice should the temperature be greater than 505° C. owing to the danger of overheating the material and rendering it brittle in consequence.

4. **Freedom from Defects.** (a) The sheets and coils shall be free from defects.

(b) Any sheet or coil may be rejected for faults in manufacture, notwithstanding that it has been passed previously on chemical composition and mechanical tests.

5. **Margins of Manufacture.** (a) The margins of manufacture on the nominal thickness of the sheets and coils shall not exceed those given in Tables 1 and 2, respectively.

(b) The margins of manufacture on the nominal width of the sheared coils shall not exceed those given in Tables 3 and 4. The class of tolerance required shall be stated on the order.

(c) Unless otherwise agreed between the Purchaser and the Manufacturer, the coil, unless ordered in short lengths, shall be so free from lateral curvature that when laid out flat no part of its edge shall be distant from a 10 foot chord by more than the following amount:—

Class A		¼ inch.
„ B		1 inch.

The class of tolerance required shall be stated on the order.

6. **Selection and Preparation of Mechanical Test Samples.** (a) *Before straightening.* All sheets or coils of the same nominal thickness made from the same cast and heat-treated together shall be grouped in parcels of not more than 50 sheets or 20 coils. Test samples shall be cut from three sheets or coils selected by the Inspector from each parcel, and one of these samples shall be submitted to the tensile test specified in Clause 7 (a). If this sample complies with the tensile test specified in Clause 7 (a) the parcel shall be accepted. The two remaining samples are to be retained for re-testing in the event of the first sample failing to meet requirements (see Clause 8 (a)).

(b) *After straightening.* All sheets or coils of the same nominal thickness from the same cast and heat-treated together shall be retained in the parcels of not more than 50 sheets or 20 coils specified in paragraph (a) above.

For sheets or coils 12 S.W.G. (0.104 in.) or thinner, one test sample shall be selected from each parcel for the single bend test specified in Clause 7 (b); for sheets or coils thicker than 12 S.W.G. (0.104 in.) one tensile test sample shall be selected from each parcel for the elongation test specified in Clause 7 (a). If these test samples comply with the tests specified in Clause 7 (b) or (a) the parcel shall be accepted.

(c) *Annealed Sheets and Coils.* If sheets or coils are ordered to be supplied in the annealed condition, all the sheets or coils of the same nominal thickness made from the same cast and annealed together shall be grouped in parcels. From each parcel the Inspector shall select one test sample to represent the parcel. The test sample shall be heat-treated as specified in Clause 3 (b) and the test pieces prepared therefrom shall comply with the mechanical tests specified in Clause 7 (a) and (b).

(d) All test samples shall be marked as directed by the Inspector before they are cut from the sheets or coils and, unless the sheets or coils are ordered to be supplied in the annealed condition, they shall not be further heat-treated. The test samples shall not be mechanically worked before testing.

(e) The tensile test samples from all material over 12 inches wide shall be cut so that the longitudinal axis of the test piece is at right angles to the direction of final rolling. The tensile test samples from material 12 inches wide and under shall be cut so that the longitudinal axis of the test piece is parallel to the direction of rolling.

The width of the tensile test piece, where possible, shall be not less than $\frac{1}{2}$ inch and the elongation shall be measured on a gauge length of 2 inches.*

(f) All single bend test pieces shall be $\frac{1}{2}$ inch wide and shall be cut from each selected sheet or coil so that the longitudinal axis of the test piece is in a direction at right angles to the direction of final rolling. Where the width of the coil does not permit of this procedure the test piece shall be cut and bent in such a manner that the axis of the bend is in a direction at right angles to the direction of rolling. The longer edges shall be carefully rounded and smoothed so that the cross section has approximately semi-circular ends.

7. Mechanical Tests. The mechanical properties of the test pieces machined from the samples selected and prepared as specified in Clause 6 must comply with the following tests to the satisfaction of the Inspector:—

(a) *Tensile Test*:—0.1 per cent Proof Stress (For sheets and coils thicker than 25 S.W.G. (0.020 in.) only) - Not less than 13.5 tons per sq. in.

Ultimate Tensile Stress (All thicknesses) - Not less than 24 tons per sq. in.

For sheets and coils thicker than 12 S.W.G. (0.104 in.):—

Elongation (on 2 inches) - - Not less than 15 per cent.

The load shall be applied axially. Should a tensile test piece break outside the middle half of its gauge length the test may be discarded and another test made.

(b) *Single Bend Test*. (Applicable only to sheets and coils 12 S.W.G. (0.104 in.) and thinner). Each test piece must withstand without cracking, being bent by steadily applied pressure through 180° over a former having a radius equal to three times the nominal thickness of the sheet or coil, care being taken to ensure continued contact between the test piece and the former.

8. Re-Tests. (a) If any test piece fails to comply with the tensile test specified in Clause 7 (a), the sheet or coil from which the test piece was taken shall be rejected and the two further samples selected as specified in Clause 6 (a) shall be submitted to the tensile test specified in Clause 7 (a). If either of these further samples fails to pass the tensile test specified in Clause 7 (a) the parcel may be rejected or re-heat-treated in accordance with Clause 3 (b) and re-tested in accordance with Clauses 6 and 7.

(b) If any single bend or elongation test piece selected as specified in Clause 6 (b) fails to comply with the single bend or elongation tests specified in Clause 7 (b) or (a) respectively the Inspector may reject the parcel represented by that test

* A suitable test piece is shown in B.S. Specification No. 485—Tests on Thin Metal Sheet and Strip.