



AEROSPACE MATERIAL SPECIFICATION

AMS6387™**REV. C**

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Superseding AMS6387B

Steel, Carbon, Laminated Sheet, Surface Bonded

RATIONALE

AMS6387C has been declared "STABILIZED" by SAE AMS Committee E Carbon and Low Alloy Steels as no longer state of the art and other sources are available in the open literature.

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AMS6387C has been declared "STABILIZED" by SAE AMS Committee E Carbon and Low Alloy Steels. This document will no longer be updated and may no longer represent standard industry practice. This document was stabilized as this document contains mature technology that is not expected to change and thus no further revisions are anticipated. The last technical update of this document occurred in February 2013. Users of this document should refer to the cognizant engineering organization for disposition of any issues with reports/certifications to this specification; including exceptions listed on the certification.

NOTE: In many cases, the purchaser may represent a sub tier supplier and not the cognizant engineering organization.

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Documents
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1. SCOPE

1.1 Form

This specification covers steel in the form of laminated sheet.

1.2 Application

This material has been used typically for shims in which thickness is adjusted by removal of laminations as required, but usage is not limited to such applications.

1.3 Classification

Materials are classified as follows:

1.3.1 Type

Type I - All laminations

Type II - One half laminations

Type III - Three quarters laminations

1.3.2 Class

Class 1 - 0.002 inch (0.05 mm) thick laminations

Class 2 - 0.003 inch (0.075 mm) thick laminations

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS5040 Steel, Sheet and Strip, 0.15 Carbon, Maximum, Deep Forming Grade

AMS5042 Steel, Sheet and Strip, 0.15 Carbon, Maximum Grade

AMS5044 Steel, Sheet and Strip, 0.15 Carbon, Maximum, Half Hard Temper

AMS5047 Steel, Sheet and Strip, 0.08 - 0.13C, Aluminum Killed (SAE 1010), Deep Forming Grade

2.2 American Society for Quality Publications

Available from American Society for Quality, 600 North Plankinton Avenue, Milwaukee, WI 53203, Tel: 800-248-1946 (United States or Canada) or +1-414-272-8575 (International), www.asq.org.

ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes

3. TECHNICAL REQUIREMENTS

3.1 Composition

3.1.1 Laminations

Shall conform to AMS5040, AMS5042, AMS5044 or AMS5047.

3.1.2 Adhesive

Shall be of a composition that will meet the fabrication and quality requirements of this specification.

3.2 Fabrication

The laminated shim stock shall consist completely of laminations each 0.002 inch $\pm$ 0.0002 (0.05 mm $\pm$ 0.005) thick or 0.003 inch $\pm$ 0.0003 (0.08 mm $\pm$ 0.008) thick, or partly of such laminations combined with a single thicker lamination, as ordered, bonded together by an adhesive such that individual laminations may be peeled for adjustment of shim thickness. The thickness of each layer of adhesive shall not exceed 0.0003 inch (0.008 mm).

3.2.1 Sheet shall be of the thicknesses and combinations of laminations and solid base shown in Table 1.