



AEROSPACE MATERIAL SPECIFICATION

AMS-T-5066™**REV. B**

Issued	1999-06
Noncurrent	2005-11
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Stabilized	2020-07

Superseding AMS-T-5066A

Tubing, Carbon Steel (1025) (Aircraft Quality)

RATIONALE

AMS-T-5066B has been declared stabilized based on the results of a survey of aerospace users and producers.

STABILIZED NOTICE

AMS-T-5066B has been declared "STABILIZED" by AMS Committee E. This document will no longer be updated and may no longer represent standard industry practice. This document was stabilized because this document is no longer state of the art and other documents contain similar, but not necessarily equivalent, requirements. Previously, this document was reaffirmed non-current. The last technical update of this document occurred in June 1999. 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.

AMS Committee E recommends that the following similar, but not identical, specifications may be considered for future procurement. This listing does not constitute authority to substitute these specifications for the "STABILIZED" specification.

ASTM A513/A513M Standard Specification for Electric-Resistance-Welded Carbon and Alloy Steel Mechanical Tubing (SAE 1025)

ASTM A519/A519M Standard Specification for Seamless Carbon and Alloy Steel Mechanical Tubing (SAE 1025)

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NOTICE

This document has been taken directly from U.S. Military Specification MIL-T-5066B, Amendment 1, Notice 2 and contains only minor editorial and format changes required to bring it into conformance with the publishing requirements of SAE technical standards. The initial release of this document is intended to replace MIL-T-5066B, Amendment 1, Notice 2. Any part numbers established by the original specification remain unchanged.

The original Military Specification was adopted as an SAE standard under the provisions of the SAE Technical Standards Board (TSB) Rules and Regulations (TSB 001) pertaining to accelerated adoption of government specifications and standards. TSB rules provide for (a) the publication of portions of unrevised government specifications and standards without consensus voting at the SAE Committee level, and (b) the use of the existing government specification or standard format.

Under Department of Defense policies and procedures, any qualification requirements and associated qualified products lists are mandatory for DOD contracts. Any requirement relating to qualified products lists (QPL's) has not been adopted by SAE and is not part of this SAE technical document.

1. SCOPE:

1.1 Scope:

This specification covers carbon steel (1025) tubing of aircraft quality.

1.2 Classification:

1.2.1 Condition: Tubing shall be supplied in the following conditions, as specified (see 6.2):

- (A) Normalized
- (B) Cold drawn and stress relieved

2. APPLICABLE DOCUMENTS:

The following publications, of the issues in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2301	Aircraft Quality Steel Cleanliness, Magnetic Particle Inspection Procedure
AMS 2253	Tolerances, Carbon and Alloy Steel Tubing
AMS 2640	Magnetic Particle Inspection

2.2 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-I-6868	Inspection Process, Magnetic Particle
MIL-C-22235	Corrosion Preventive Oil, Nonstaining
FED-STD-151	Metals; Test Methods
FED-STD-183	Continuous Identification Marking of Iron and Steel Products
MIL-STD-163	Steel Mill Products, Preparation for Shipment and Storage
MS33532	Square and Rectangular Tubing - Carbon Steel and Alloy Steel .35 Carbon, Maximum
MS33534	Standard Dimensions for Streamlined and Oval Tubular Shapes
AND10102	Tubing - Standard Dimensions for Round Alloy Steel

3. REQUIREMENTS:

3.1 Material:

The tubing shall be of aircraft quality. The material shall be magnetically inspected in accordance with the procedures of AMS 2301, and shall not exceed the size and frequency rating limits indicated in the paragraph entitled "Disposition" of AMS 2301 (see 4.4).

3.1.1 Welded tubing: Welded tubing shall be made from flat rolled steel by a continuous welding process and shall be reduced by subsequent drawing to refine the microstructure of the weld zone and produce uniform grain size throughout.

3.1.2 Either welded or seamless tubing may be furnished at the option of the vendor.

3.2 Test data:

Test data shall be submitted in accordance with 4.1.1.