



TMML SPECIFICATIONS



ALUMINIUM SHEET / COIL

Issue No: 01 Rev No.: 00
 Date: 01.07.2014
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 Doc No.: MS-TMML-ENGG-PE-7.3-153

1. SCOPE:

This standard covers the requirements for wrought aluminium and aluminium alloy sheet and strip for general engineering purposes.

2 - DESCRIPTION:

Material used in manufacturing of parts intended for use in bus for transport of passengers.

3 - REQUIREMENTS:

Material shall confirms to IS 737 – 2008 for H2 19000 Grade (H2 – strain hardened and partially annealed) *or latest.*

Chemical Compositions

Chemical Names	Values
Aluminum (Al)	99.0 (min)
Copper (Cu)	0.1 (max)
Magnesium (Mg)	0.2
Silicon (Si)	0.5
Iron (Fe)	0.7 (max)
Manganese (Mn)	0.1
Zinc (Zn)	0.1 (max)
Chromium (Cr)	-
Remarks	Cu+Mg+Si+Fe+Mn+Zn≤1.0

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Review & Release Control by

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Approved by

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Effective Date
01.07.2014

Copy No. 1

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 Phone: 080-27735051-27735003
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26/09/20



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Mechanical properties

		Values
Tensile Strength (MPa)		90min-130max
Min elongation on 50mm gauge length % for thickness	0.5-0.8	5
	0.8-1.3	6
	1.3-2.6	8
	2.6-6.3	8
Bend test, radius of bend		Close

4. DIMENSIONS AND TOLERANCES:

The dimensions and tolerances of sheet and strip shall be as given in IS 2676.

5. MARKING:

- 1) Each package/coil of sheet and strip may be suitably marked for identification, with the name of the manufacturer, grade, condition of the material and batch number. The supplier shall furnish a certificate that the material supplied complies with the requirements of this standard.
- 2) BIS certification Marking: The material may also be marked with the standard Mark.

6. PACKAGING:

Should be packed so as to avoid transit damages. Every pack has to have the printed mark / sticker indicating -sheet thickness, no of sheets in pack, gross wt of the pack & net wt (total sheet wt in a pack)

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NOTE:

- 1) Supplier should submit the test report along with the material supply with batch traceability.
- 2) Third party testing should be conducting from the following testing agencies.
 - a) BIS Approved Lab
 - b) NABL Approved Lab
 - c) CIRT
 - d) ARAI
 - e) ICAT

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