

<div style="background-color: black; width: 100%; height: 20px; margin-bottom: 5px;"></div> Engineering Requirement		No: 57-00630 Rev -	
		Date: 10/1/01	Page 1 of 1
Title: Stainless Steel Sheet Metal <div style="background-color: black; width: 100%; height: 15px; display: inline-block;"></div>		Authorization No. <div style="background-color: black; width: 100%; height: 15px; display: inline-block;"></div>	Rev. Description: Initial Release

Purpose: The purpose of this Engineering Requirement is to define exceptions to the contents of . Material Specification VN04-3. These exceptions are necessary in order to meet special theoretical minimum weight & material thickness specifications. In addition, special flatness and oil canning limits are defined herein.

Scope: The number "57-00630" shall be specified in material blocks on engineering drawings and as the material number for BOM item masters, in lieu of VN04-3.

Application: Raw material specification

Specifications:

1.0 Tolerances on material thickness: (Bold Italics = preferred material sizes)

Material Gauge	Nominal Material Thickness	Tolerance on Nom. Material Thickness	Max. / Min. Material Thickness	See Note(s)
20	.0355	<i>+ / -.0040</i>	<i>.0395 / .0315</i>	2 & 3
16	.0595	<i>+.0060 / -.0025</i>	<i>.0655 / .0570</i>	1 & 3
14	.0751	<i>+.0070 / -.0051</i>	<i>.0821 / .0700</i>	1 & 3
12	.1054	<i>+ / -.0090</i>	<i>.1144 / .0964</i>	2 & 3
11	.1200	<i>+.0100 / -.0050</i>	<i>.1300 / .1150</i>	1 & 3
10	.1350	<i>+ / -.0120</i>	<i>.1470 / .1230</i>	2 & 3

2.0 Flatness Tolerance:

Material Thickness Range	<div style="background-color: black; width: 100%; height: 15px; display: inline-block;"></div> Flatness Tol. (Measured over 4ft.)	See Note(s)
under .062	.375	4 & 5
.062 to .1875	.250	4 & 6

3.0 Oil Canning Characteristics:

Material supplied to the requirements of this specification shall not exhibit any oil canning characteristics after punching or shearing. Oil canning is defined as an obvious deformation caused by residual material stresses; typically released by shearing or punching the sheet into smaller sizes. Sheet deformation shall not exceed one forth the material thickness as measured over two linear feet or one half the material thickness as measured over four linear feet. Measurements shall be taken on a flat horizontal surface with the material at room temperature.

4.0 Notes:

1. Min. thickness derived from purchasing agreement, exhibit C, dtd. 12/17/99.
2. Min. thickness derived from ASTM A480, Table A2.13.
3. Max. thickness derived from ASTM A480, Table A2.13.
4. flatness tolerance equals 50% of comparable ASTM value (maximum deviation from a horizontal flat surface) per – Lancaster Steel supply agreement.
5. Tolerance value calculated from ASTM A480, Table A2.16, 36" – 60" wide sheet.
6. Tolerance value calculated from ASTM A480, Table A2.16, to 60" wide sheet.

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