



**SAFRAN Machining
Surveillance Program
TA6V / INCO 718**

Program Instructions

SAFRAN Machining Surveillance Program
TA6V / INCO 718

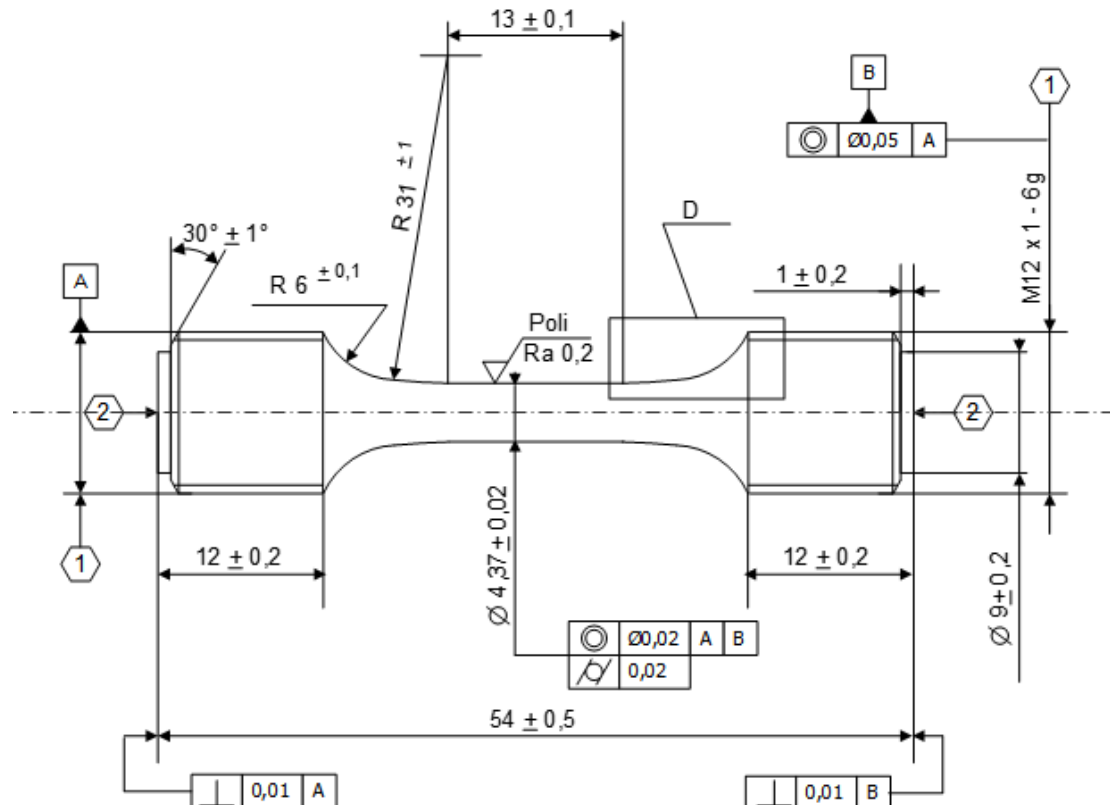
You shall respect the HSE policy of your laboratory for each performed test.

Foreword: This program is mandated by SAFRAN and does not replace your participation in kit 14-1 Machining for SAFRAN or other sponsors. This program is on a 12-month timeline. Participants are required to machine 1 specimen each month for this period and it for evaluation of residual stress.

Instructions to participant laboratories

Please read these instructions carefully BEFORE starting the tests.

- One blank ($\varnothing 14 \times 60$ mm), is to be machined every month. Materials have to be alternated every month.
Example : Month #1 : 1 specimen in Inconel 718, Month #2: 1 specimen in TA6V, Month #3 : 1 specimen in Inconel, (...)
Blanks are sent in packages containing 2 samples. Specimens ID are to be engraved on the head of specimen after machining for the purpose of traceability.
- In case of loss or deterioration of a PTP sample(s) please contact a member of the PTP team for a replacement.
- The specimens shall be machined according to the drawing **485-920-525-0 version F:**



1

\varnothing EXT 11,974 / 11,794
 \varnothing on the flanks: 11,324 / 11,209
 \varnothing INT max 10,891

2

Center holes
 ISO6411 – A1,6/3,35

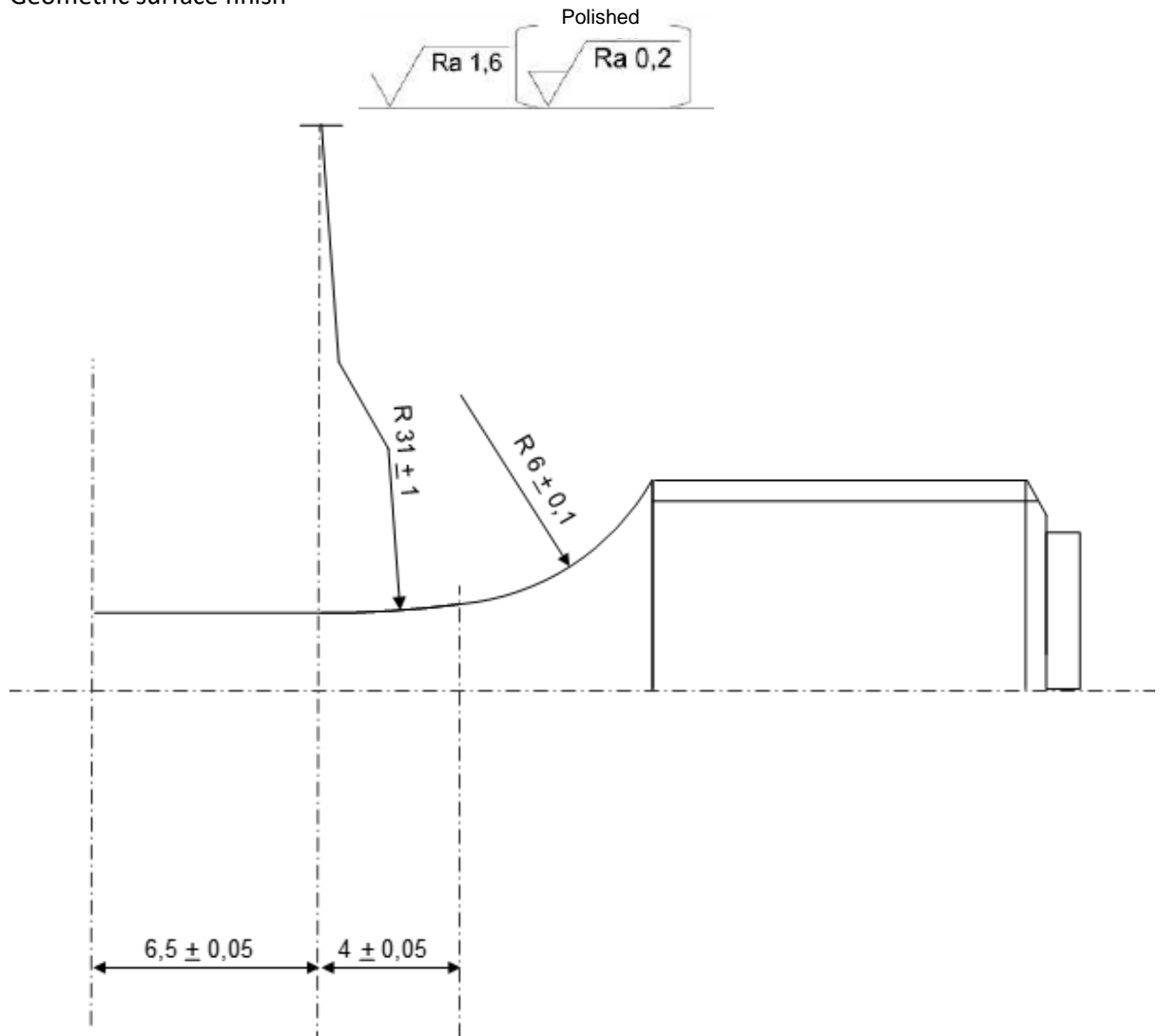


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Geometric surface finish



Note: R6 must be tangent to R31

- The machining shall be performed respecting the following conditions:
 - Different operator each month if technically possible
 - Each month means one month between machining of two packages containing 2 samples

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5. The following information is to be reported each month on the PTP website for each sample:

- Operator ID
- Machining sheet registration number (Document containing the machining sequences with parameters)
- Machining sheet version and date of edition
- Date of machining for each sample
- Dimensional check report

Specimen traceability will be checked by PTP.

An independent laboratory will perform **surface residual stress measurements** according to DMC 0107 (3 locations per specimen at 120° per specimen).

A visual representation of each Residual stress values will be available on the PTP website for participants to see and for sponsor to analyse.

Evaluation of residual stress values are described as follows:

- RCA created : At least one individual residual stress value is outside the 0, -400 MPa range.
- Alert : Five consecutive increases or decreases of the residual stress mean value.
- Alert : Standard deviation exceeds 35.79 MPa for one set of measurements.
- Alert : Machined specimens due for the month were not sent for evaluation before the deadline.

RCA : Root Cause Analysis has to be performed and completed on line by the laboratory

Alert : The Safran team is informed about the deviation, no RCA has to be completed at this step.


6. Machined specimens are to be sent in their original packaging (for traceability) each month at the following address for evaluation:

ArianeGroup
À l'attention de Thierry Bergey
Forêt de Vernon BP806
27207 VERNON Cedex

Please make sure you send the samples with all the required documentation and with the mention "no commercial value".

7. Machining shall start **as soon as test specimens are received**. Please contact the following e-mail address for any technical or administrative query.

Shipment date from:	November 9th 2022
Date range for sending of machined specimens:	Between 1st and 15th of each month
Technical and administrative support:	info@ptpscheme.com

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Machined samples sent after the deadline will be evaluated with the next month batch and your lab will be flagged as failed for this month (RCA process).

8. To ensure the confidential treatment of your results in the final report, you will be allocated a unique identity number when you register for the program.
9. Collusion and falsification of your PTP results are totally forbidden. In case of identification or suspicion of collusion or falsification, the laboratory will be excluded from the program and the sponsors will be immediately informed. The sponsors could ask you proofs of your records and analyses, so be sure to conserve data, curves, and specimens.

REVISION HISTORY

Issue Date	Issue N°	Changes
03/10/2022	1	Document creation
05/01/2023	2	Updated deadline for sending of samples §7 + updated information about customs in §6
12/01/2024	3	Reduction to 2 specimens per month to 1 specimen per month