



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

## Program Instructions

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TA6V / INCO 718

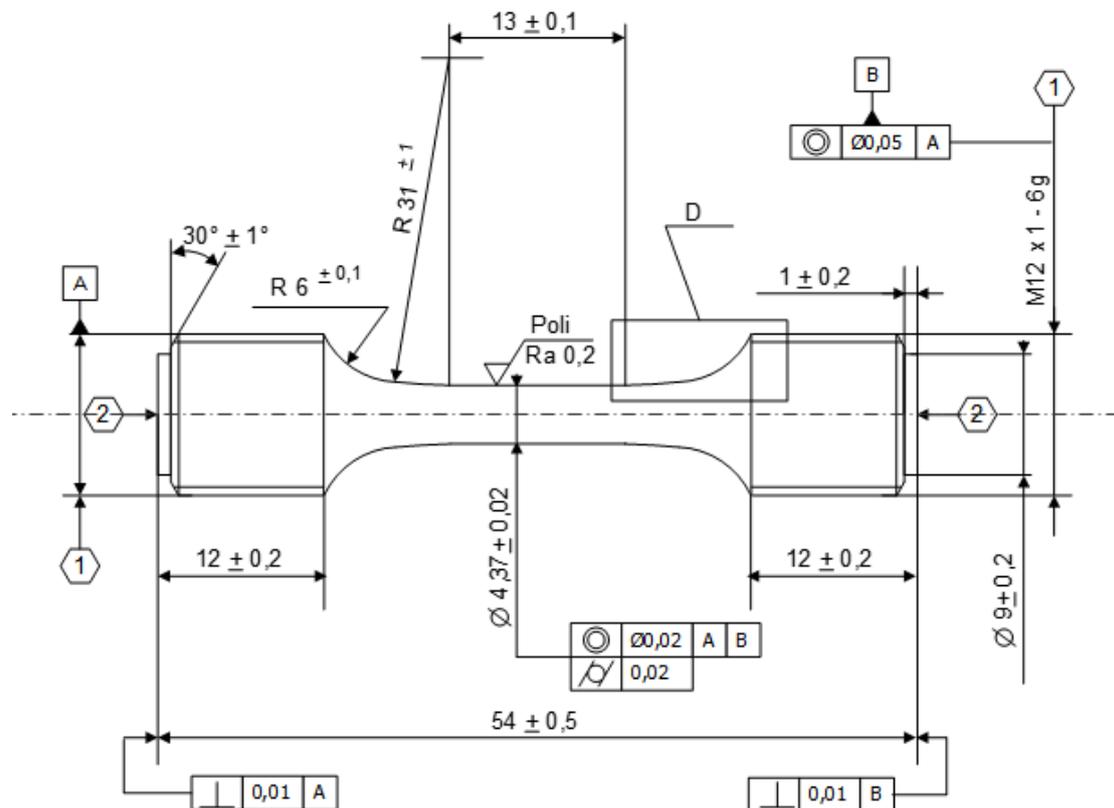
You shall respect the HSE policy of your laboratory for each performed test.

**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 2 specimens each month for this period and send them for evaluation of residual stress.

### Instructions to participant laboratories

**Please read these instructions carefully BEFORE starting the tests.**

1. Two blanks ( $\varnothing 14 \times 60$  mm), one for each material (TA6V and INCO 718), are to be machined each month. 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.
2. In case of loss or deterioration of a PTP sample(s) please contact a member of the PTP team for a replacement.
3. 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

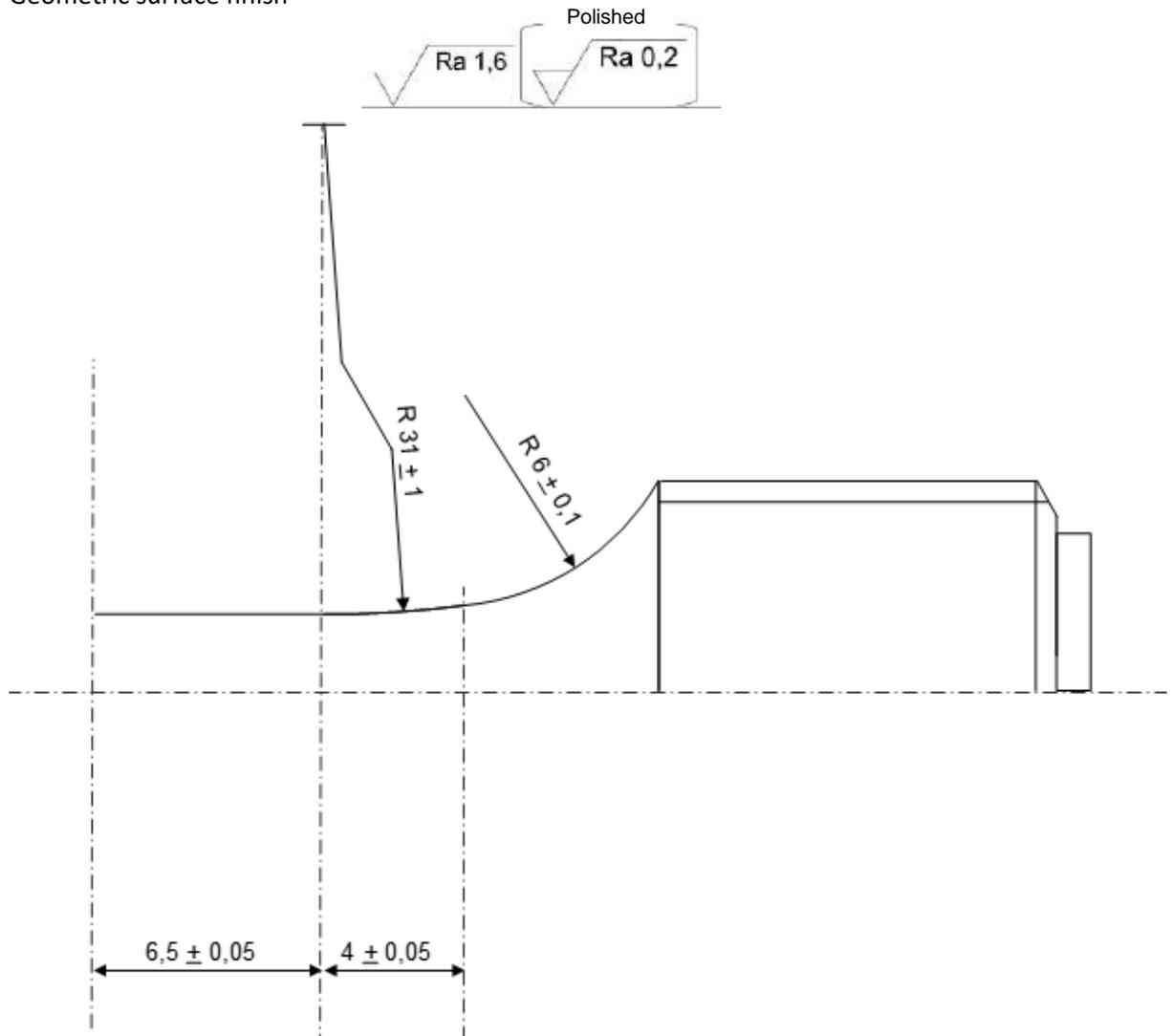


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Geometric surface finish



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.

Failed residual stress values are described as follows:

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

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

**ArianeGroup**  
**À l'intention 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.

|  |  |
|--|--|
| <b>Shipment date from:</b>                           | <b>November 9th</b>  |
| <b>Date range for sending of machined specimens:</b> | <b>Between 1<sup>st</sup> and 15th of each month</b>       |
| <b>Technical and administrative support:</b>         | <a href="mailto:info@ptpscheme.com">info@ptpscheme.com</a> |

**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).**

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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 |