

BRITISH STANDARD

**BS EN
755-1 : 1997**

Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles

Part 1. Technical conditions for inspection and delivery



S

The European Standard EN 755-1 : 1997 has the status of a
British Standard

ICS 77.150.10

NO COPYING WITHOUT BSI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW



Committees responsible for this British Standard

The preparation of this British Standard was entrusted to Technical Committee NFE/35, upon which the following bodies were represented:

Aluminium Federation
 Aluminium Stockholders' Association
 Association of Light Alloy Refiners Limited
 Magnesium Industry Council
 Ministry of Defence

The following bodies were also represented in the drafting of the standard, through subcommittees and panels:

Association of British Welded Aluminium Tube Makers
 Institution of Structural Engineers
 Metal Packaging Manufacturers' Association

This British Standard, having been prepared under the direction of the Engineering Sector Board, was published under the authority of the Standards Board and comes into effect on 15 September 1997

© BSI 1997

Amendments issued since publication

Amd. No.	Date	Text affected

The following BSI references relate to the work on this standard:
 Committee reference NFE/35
 Draft for comment 92/49092 DC

ISBN 0 580 28303 8

National foreword

This Part of BS EN 755 has been prepared by Technical Committee NFE/35 and is the English language version of EN 755 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 1 : 1997 Technical conditions for inspection and delivery*, published by the European Committee for Standardization (CEN).

This British Standard is published under the direction of the Engineering Sector Board whose Technical Committee NFE/35 has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on interpretation, or proposals for change, and keep UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

This Part of BS EN 755 is published together with:

- BS EN 755 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles*
 Part 2 *Mechanical properties*
 BS EN 754 *Aluminium and aluminium alloys — Cold drawn rod/bar and tube*
 Part 1 *Technical conditions for inspection and delivery*
 Part 2 *Mechanical properties*

As a result of the publication of the above standards, BS 4300 : Part 5 : 1973 is withdrawn and the following British Standards listed in the table are partially superseded.

NOTE. The table gives the full list of European Standards which partially supersede the British Standards.

British Standards partially superseded by this standard and other European Standards				
BS 1471 : 1972	BS 1474 : 1987	BS 4300 : Part 4 : 1973	BS 4300 : Part 12 : 1969	BS 4300 : Part 15 : 1973
EN 515	EN 515	EN 515	EN 515	EN 515
EN 573-3	EN 573-3	EN 573-3	EN 573-3	EN 573-3
EN 573-4	EN 573-4	EN 573-4	EN 573-4	EN 574-4
EN 754-1	EN 755-1	EN 755-1	EN 755-1	EN 755-1
EN 754-2	EN 755-2	EN 755-2	EN 755-2	EN 755-2
	EN 755-3	EN 755-3	EN 755-3	EN 755-3
	EN 755-4	EN 755-4	EN 755-4	EN 755-4
	EN 755-5	EN 755-5	EN 755-5	EN 755-5
	EN 755-6	EN 755-6	EN 755-6	EN 755-6



In addition, the British Standards in the table will be withdrawn when the following European Standards are published:

EN 754	<i>Aluminium and aluminium alloys — Cold drawn rod/bar and tube</i>
Part 7	<i>Seamless tubes, tolerances on dimensions and form</i>
Part 8	<i>Porthole tubes, tolerances on dimensions and form</i>
EN 755	<i>Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles</i>
Part 7	<i>Seamless tubes, tolerances on dimensions and form</i>
Part 8	<i>Porthole tubes, tolerances on dimensions and form</i>
Part 9	<i>Profiles, tolerances on dimensions and form</i>
EN 12020	<i>Aluminium and aluminium alloys — Extruded precision profiles in alloys EN AW 6060/EN AW 6063</i>
Part 1	<i>Technical conditions for inspection and delivery</i>
Part 2	<i>Tolerances on dimensions and form</i>

NOTE. International and European Standards, as well as overseas standards, are available from Customer Services, BSI, 389 Chiswick High Road, London W4 4AL.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN title page, pages 2 to 12, an inside back cover and a back cover

EUROPEAN STANDARD
 NORME EUROPÉENNE
 EUROPÄISCHE NORM

EN 755-1

April 1997

ICS 77.150.10

Descriptors: Aluminium, aluminium alloys, wrought products, extruded products, metal bars, metal tubes, metal sections, delivery, inspection, tests, specifications

English version

Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 1: Technical conditions for inspection and delivery

Aluminium et alliages d'aluminium — Barres, tubes et profilés filés — Partie 1: Conditions techniques de contrôle et de livraison

Aluminium und Aluminiumlegierungen — Stranggepreßte Stangen, Rohre und Profile — Teil 1: Technische Lieferbedingungen

This European Standard was approved by CEN on 1997-03-10. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
 Comité Européen de Normalisation
 Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

© 1997 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national members.

Ref. No. EN 755-1 : 1997 E

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 132, Aluminium and aluminium alloys, the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 1997, and conflicting national standards shall be withdrawn at the latest by October 1997.

Within its programme of work, Technical Committee CEN/TC 132 entrusted CEN/TC 132/WG 5, Extruded and drawn products, to prepare the following standard:

EN 755-1 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 1: Technical conditions for inspection and delivery*

This standard is part of a set of nine standards. The other standards deal with:

EN 755-2 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 2: Mechanical properties*

EN 755-3 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 3: Round bars, tolerances on dimensions and form*

EN 755-4 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 4: Square bars, tolerances on dimensions and form*

EN 755-5 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 5: Rectangular bars, tolerances on dimensions and form*

EN 755-6 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 6: Hexagonal bars, tolerances on dimensions and form*

prEN 755-7 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 7: Seamless tubes, tolerances on dimensions and form*

prEN 755-8 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 8: Porthole tubes, tolerances on dimensions and form*

prEN 755-9 *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 9: Profiles, tolerances on dimensions and form*

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

Contents

	Page		Page
Foreword	2		
1 Scope	4		
2 Normative references	4		
3 Definitions	4		
3.1 extruded rod/bar	4		
3.2 extruded tube	4		
3.3 seamless tube	4		
3.4 porthole/bridge tube	4		
3.5 porthole/bridge die	4		
3.6 profile	4		
3.7 hollow profile	5		
3.8 solid profile	5		
3.9 inspection lot	5		
3.10 heat treatment batch or lot	5		
3.11 sample	5		
3.12 specimen	5		
3.13 test piece	5		
3.14 test	5		
4 Orders or tenders	5		
5 Requirements	6		
5.1 Production and manufacturing processes	6		
5.2 Quality control	6		
5.3 Chemical composition	6		
5.4 Mechanical properties	6		
5.5 Freedom from surface defects	6		
5.6 Tolerances on dimensions and form	6		
5.7 Other requirements	6		
6 Test procedures	6		
6.1 Sampling	6		
6.2 Test methods	7		
6.3 Re-tests	7		
7 Inspection documents	8		
7.1 General	8		
7.2 Documents established on the basis of inspections and tests performed by qualified personnel who are involved in the manufacturing process and/or belong to the quality control department	8		
		7.3 Documents established on the basis of inspections and tests performed or supervised by qualified personnel organizationally independent from the manufacturing department, according to the requirements specified on the order and carried out on the products for delivery or on the relevant inspection lot	8
		8 Marking of products	8
		9 Packaging	8
		10 Arbitration	8
		Annexes	
		A (normative) Types of test pieces	9
		B (normative) Location of test pieces	10



* 5 *