



**FRISA FORJADOS S.A. DE C.V.**  
Valentín G. Rivero No. 127, Los Treviño  
Santa Catarina NL 66150  
+52 (81) 81530300  
[www.frisa.com](http://www.frisa.com)

## Certificate of Conformance

CERTIFIED COMPANY

ISO 9001: 2015

Date	Jun 07, 2024
Customer	SICOM INDUSTRIES LTD.
Purchase Order	18133
Part Number	SU-1010-1072 MAT
Quantity	2
Specification	ASTM B247 (AI 7075-T6) Rev. 20
Material	AI 7075
Frisa Job Order	763768
Heat	A22-23139
Serial Number	763768-01,763768-02

Frisa hereby certifies that the material described in the table above was produced and inspected according with to internal procedures of the company and fully meets the purchase order and specification requirements.

<https://www.frisa.com/terms-conditions.html>

Esteban Amezcua  
Quality Assurance Engineer  
Frisa Forjados S.A. de C.V.  
Phone: +52 (81) 8153-0300

Qty	Date	P.O. Number	Part No.	Job Order
2	07/06/2024	18133	SU-1010-1072 MAT	763768
<b>Description</b> Rolled Ring 24.670" X 21.380" X 13.500" .SERIAL NUMBER NOTE: 763768-01, 763768-02 .LINE ITEM: 001				

**HEAT: A22-23139 (2/2) PCS**
**CHEMICAL ANALYSIS**

HEAT No.		Mn %	Si %	Cr %	Cu %	Ti %	Fe %	Mg %	Zn %
A22-23139	Ladle	0.02000	0.08000	0.23500	1.65000	0.03000	0.16000	2.49000	5.69000
<b>Supplier</b>	VMG								

**HEAT TREATMENT**

Quantity	Heat Treat Lot No.	Heat Treatment	Temp. (°F)	Time at Temp (Hrs)	Cooling Medium	Quench. M. Temp. (°F)
2 PCS	758952	Solution	880	7.00	Water	
2 PCS	759037	Age	250	24.00	Air	
QTC	758952	Solution	880	7.00	Water	
QTC	759037	Age	250	24.00	Air	

**Heat: A22-23139**
**Track 148/030-24  
ID:**
**MECHANICAL PROPERTIES**
**TENSILE TEST**

Orientation	Position	Location	Heat Treat Lot No.	Yield Strength (PSI)	Tensile Strength (PSI)	Elong. (%)	A.R. (%)	Temp Tens °F	Post Welding HT		
									Temp °F	Time	Cycle
Radial	S		759037	70000	81700	14	19	77			
Tangential	S		759037	70100	80800	13	15	77			
Axial	S		759037	71600	83100	11	15	77			



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CERTIFIED COMPANY  
**ISO9001:2015**

**Material Test Report No.898967**

**Client: SICOM INDUSTRIES LTD.**

**Spec: ASTM B247 (AI 7075-T6) Rev. 20**

**Pag. 2/2**

Qty	Date	P.O. Number	Part No.	Job Order
2	07/06/2024	18133	SU-1010-1072 MAT	763768
<b>Description</b> Rolled Ring 24.670" X 21.380" X 13.500" .SERIAL NUMBER NOTE: 763768-01, 763768-02 .LINE ITEM: 001				

**OBSERVATIONS**

- . TEST SPECIMEN AND PIECES WERE HEAT TREAT TOGETHER
- . TEST SPECIMEN REMOVED FROM A PROLONGATION AFTER HEAT TREAT
- . TENSILE TEST: 0.500" DIAMETER SPECIMEN AND 2.0" GAUGE LENGTH
- . ULTRASONIC EXAMINATION PER: ASTM B594-19 Class AA
- . TEMPERATURE MONITORING AND RECORDING METHOD: 2 CONTACT THERMOCOUPLE
- . PIECES WERE ROUGH MACHINED PRIOR TO HEAT TREAT

WE HEREBY CERTIFY THAT ALL TEST RESULTS AND PROCESS INFORMATION CONTAINED HEREIN ARE CORRECT AND TRUE AS CONTAINED IN THE RECORDS OF THE COMPANY AND MEET THE PURCHASE ORDER / SPECIFICATIONS REQUIREMENTS. For warranties T&C please refer to the warranty T&C under the next link:  
<https://www.frisa.com/terms-conditions.html>

NO WELDING REPAIRS IS ALLOWED AND USED IN FRISA ALL MATERIALS ARE MERCURY FREE

CER F-001-3

Esteban Amezcua

QUALITY ASSURANCE ENGINEER



# Vista Metals Georgia

800 Martin Luther King Jr. Drive  
 Adairsville, GA 30103  
 (770) 773-7653



## Certificate of Inspection and Conformance

Shipment # 532502

**Customer:**

Friza Forjados S.A. De C.V.  
 Valentin G. Rivero No. 127  
 Col. Los Trevino  
 Sta. Catalina, N.L., 66150 MX  
 P.O.# FF-29545

Certified report of chemical analysis  
 (all values are percent concentration)  
 Test Method: ASTM E-1251 & QW824-02

Heat	Size	Alloy	AL	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	V	Ti	Pb	Sn	Na	B	Zr	Li	Ca	Be	Bi	Sr
A22-23138	14.5	7075	89.65	0.09	0.17	1.58	0.02	2.40	0.235	0.01	5.78	0.010	0.028	0.0014	0.000	0.0000	0.002	0.018	0.000	0.000	0.00009	0.000	0.000
A22-23139	14.5	7075	89.59	0.08	0.16	1.65	0.02	2.49	0.235	0.01	5.69	0.011	0.030	0.0014	0.000	0.0000	0.002	0.019	0.000	0.000	0.00008	0.000	0.000

*Sup 12-14-22*



Highest caliber. So is the metal.™

# Vista Metals Georgia

800 Martin Luther King Jr. Drive  
Adairsville, GA 30103  
(770) 773-7653



## Certificate of Inspection and Conformance


Shipment # 532502

Applicable Specifications:

Notes: AISCAN Reading: H = 0.048 ml/100g For Cast - A22-23138 AISCAN Reading: H = 0.048 ml/100g For Cast - A22-23139

Vista Metals Georgia certifies that the material in this shipment meets the requirements of all the applicable specifications/purchase order and verifiable evidence of inspections and testing is available for inspection.

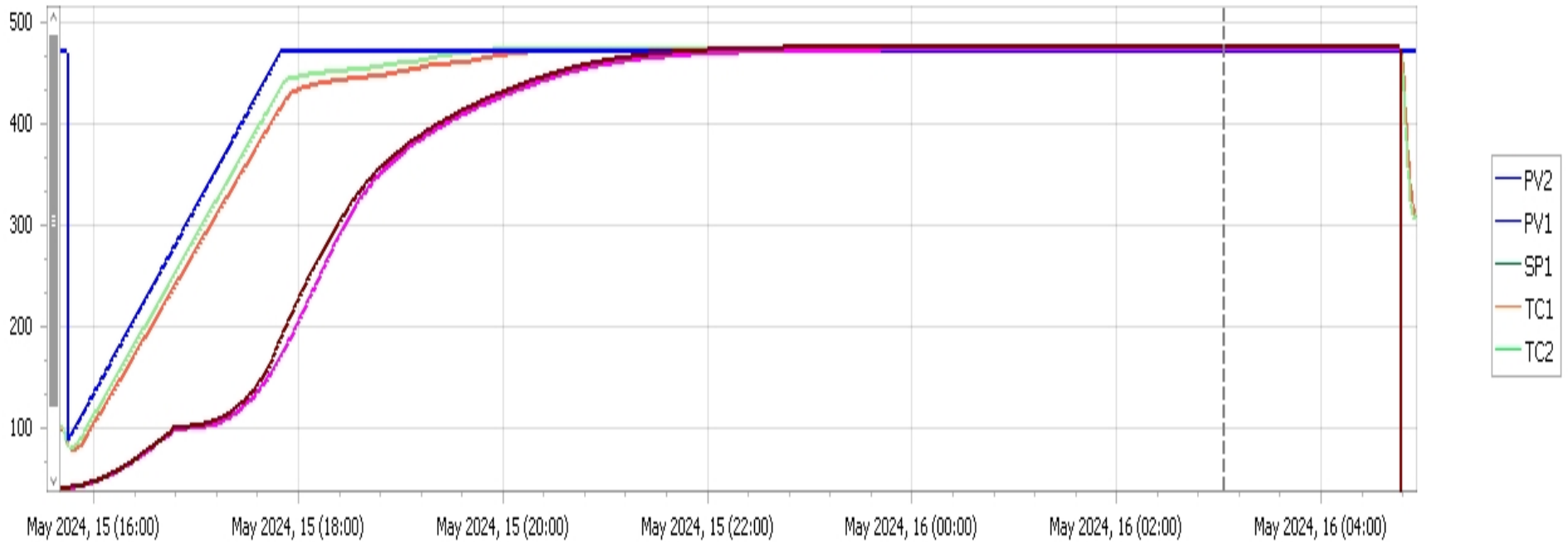
Country of Origin, Melt, and Manufacture: U.S.A.

Q.A. Stamp: 	Signed: <i>Michael Paschke</i>	Date: 12/14/2022
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# Heat Treatment Chart

Furnace #: Horno TT 48

HT LOT: 758952



#1 Temperature SetPoint	471	°C
Zone 1 Furnace Temperature	471	°C
Zone 2 Furnace Temperature	471	°C

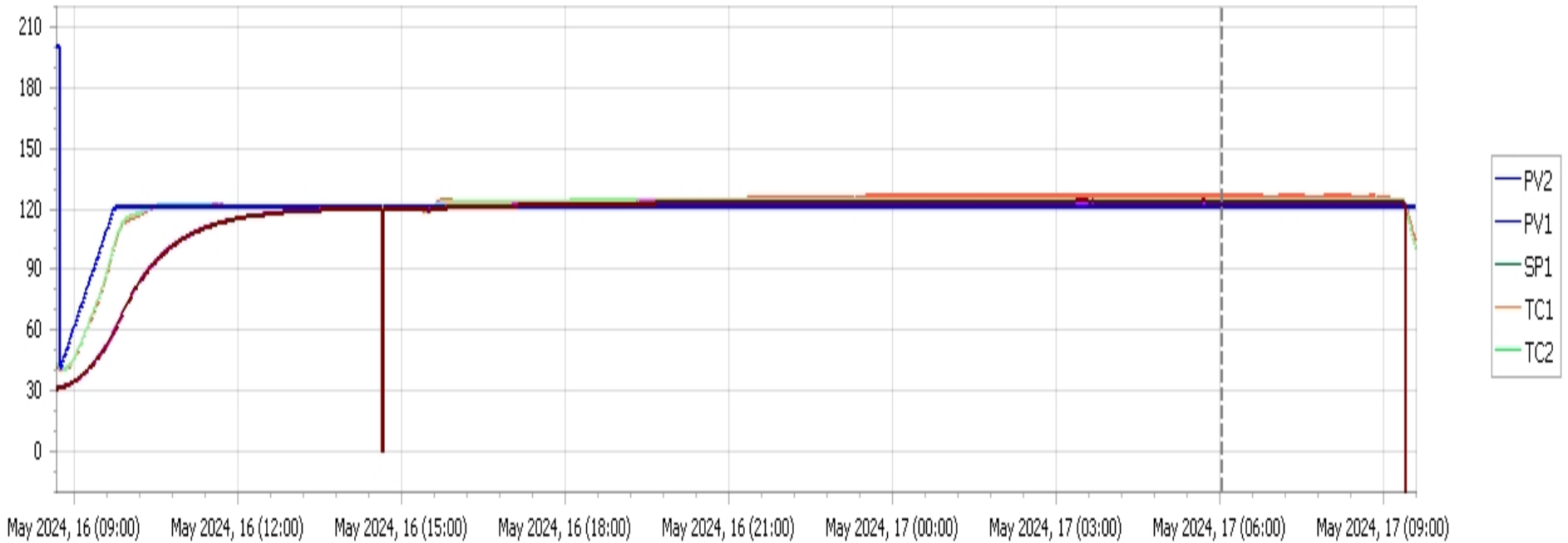
#1 Contact Thermocouple	471.6	°C
#2 Contact Thermocouple	474.7	°C

Heat treat lot Number	758952	#
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# Heat Treatment Chart

Furnace #: Horno TT 49

HT LOT: 759037



#1 Temperature SetPoint	121	°C
Zone 1 Furnace Temperature	124	°C
Zone 2 Furnace Temperature	126.1	°C

#1 Contact Thermocouple	123.3	°C
#2 Contact Thermocouple	123.3	°C

Heat treat lot Number	759037	#
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**Job Order** 763768

10/500 kg.     10/3000 kg.

Customer: SICOM INDUSTRIES LTD.  
 PO: 18133  
 Line Item: 001

Part Number: SU-1010-1072 MAT  
 Specification: ASTM B247 (Al 7075-T6) Rev. 20  
 Specified range: 135 - 999    HBW    Indentation Qty: 1

SN	Heat	Heat treat lot	Date *	Equipment	Scope	1
763768-01	A22-23139	759037	27/05/2024	KE-74	BOSS-19	157 HBW/P
763768-02	A22-23139	759037	27/05/2024	KE-74	BOSS-19	160 HBW/P

Testing standard: ASTM E10-23 / ASTM E110-14

\* (dd/MM/yyyy)

Applied Load: 500 Kg.

Type of penetrator: 10 mm tungsten carbide ball, 20X Scope used

Test Performed at ambient temperature

Test block serial number Internal verification:

Equipment : KE-74

Block Serial Number : 040003

Value / Average (HBW): 142 | 141

Forging Part Number:

Serial Number of hardness test equipment:

KE-74      Serie: KE-74      Model: B-1      Calibration Date: Apr 15,2024    Jul 15,2024

BOSS-19    Serie: 995 GS    Model: OS-300-7    Calibration Date: Nov 22,2023    Nov 22,2024

Hardness test : Accept



Inspector: Armando Cordero Martinez



# NON DESTRUCTIVE TESTING PERSONNEL CERTIFICATION RECORD



## FRISA

FRISA Certify to

**David Guadalupe Hernandez Mendez**

Certificate N°: FRI-UT 247 as

**Ultrasonic Testing Inspector Level II**

He has provided the evidence of continuing satisfactory technical performance and has met the re-certification requirements, according to FRISA Written Practice NDT I-01 based on the recommended practice ASNT SNT TC-1A

<b>Frisa Hired Date:</b>	Jan 22, 2007	<b>NDT Hired Date:</b>	May 30, 2022
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<b>Last or Initial Certification Date:</b>	April 20, 2023	<b>By:</b> Frisa Forjados SA de CV
<b>Recertified by Satisfactory Technical Performance and Training/Re-Examination</b>	<b>Date:</b> N/A	<b>By:</b> Frisa Forjados SA de CV
<b>Recertification Due Date:</b>	April 30, 2026	

- This certificate expires in 3 years or if personnel terminate employment at Frisa per ASME.  
 This certificate expires in 5 years or if personnel terminate employment at Frisa per NAS410.

### Education Record

<b>Education Level:</b>	High School Graduated
<b>Certificate and/or Degree obtained date:</b>	July 2006

### NDT Training Record

Course name	Level	Dates	Hours	Instructor name	Imparted by
Ultrasonic	II	Feb 6 to 11, 2023	48	Jorge Abel Lara	FRISA Forjados
Ultrasonic	I	June 13 to 18, 2022	48	Jorge Abel Lara	FRISA Forjados

### Method Experience

Employer	Method	Level	Experience Months and/or Hrs	Dates		Document Reference
				From	To	
Frisa Forjados	UT	Trainee	1920 hrs	May 2022	To date	Experience Letter

### Examinations (Vision & Method)

Vision Acuity at the certification time (subsequent examinations shall be available in the personal file)						Method Examinations				
Near Vision		Results:	Distance Vision		Results:	Exam	Score	Date(mdy)	Retest Score	Date(mdy)
Right Eye	20/20	Uncorrected	Right Eye	20/20	Corrected	General	80	02.11.23		
Left Eye	20/20	Uncorrected	Left Eye	20/20	Corrected	Specific	80	02.11.23		
Evaluation:			Evaluation:			Practical	100	03.23.23		
Color Contrast Perception Result:			Normal		Color:	N/A	Composite Score:	86.66		
Initial vision acuity test date				March 24, 2023		Comments:				

<p><b>Jorge Abel Lara</b> FRISA NDT Responsible ASNT Level III No. 179394</p>	<p><b>Gerardo Cantu</b> FRISA Forjados Quality Manager</p>
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DR: LAZARO VELA RODRIGUEZ  
MEDICO CIRUJANO OFTALMOLOGO.  
CED PROF: 115029

REPORTE OFTALMOLOGICO:

NOMBRE : DAVID GUADALUPE HERNANDEZ MENDEZ  
EDAD : 35 AÑOS  
EMPRESA : FRISA FORJADOS  
DEPARTAMENTO: PND.

**PRUEBA SNELLEN / SNELLEN TEST.**

AGUDEZA VISUAL: O.D.20/ 20  
(VISUAL ACUITY) O.I. 20/ 20

VISION CROMATICA O.D.: NORMAL O.I. NORMAL  
(COLOR PERCEPTION)

**REFERENCIA PRUEBA JAEGER**

JAEGER 1-2 A 12 DISTANCIA O.D: NORMAL O.I. NORMAL

FONDO DE OJO O.D: NORMAL O.I. NORMAL

ESTEREO AGUDEZA O.D NORMAL O.I. NORMAL

EXAMEN OFTALMOLOGICO O.D NORMAL O.I. NORMAL

RESULTS: A.O ACEPTADO SIN LENTES

DIAGNOSTICO: A.O EMETROPE

PLAN: ANUAL

LA EXAMINACION CUMPLE CON LO ESTABLECIDO CON LA PRACTICA ESCRITA DE CERTIFICACION DE PERSONAL DE FRISA FORJADOS NDTI-001, ELABORADA DE ACUERDO A LA PRACTICA RECOMENDADA ASNT SNT-TC-1 Y A LA PRACTICA ESCRITA DE CERTIFICACION DE PERSONAL DE FRISA FORJADOS NDTI-021 ELABORADA DE ACUERDO A LA ESPECIFICACION NAS-410 Y CUMPLE CON EL PROCEDIMIENTO FRISA FORJADO PERSONAL I-005

EXAMINATION ACCORDING TO THE ESTABLISHED IN FRISA FORJADOS WRITTEN PRACTICE FOR PERSONNEL CERTIFICATION NDTI-001 BASED ON THE RECOMMENDED PRACTICE ASNT SNT -TC -1A AND TO THE WRITTEN PRACTICE FOR PERSONNEL CERTIFICATION NDT I -021 BASED ON THE SPECIFICATION NAS-410 AND CUMPLIES WITH THE PROCEDURE FRISA FORJADOS PERSONAL I-005

MONTERREY, N.L. A 21 MARZO 2024

EYE EXAM DATE : MARZO 2024 EXAM DUE DATE: MARZO 2025

DR LAZARO VELA RODRIGUEZ



No. 110 Nte  
Col. V. Centro C.P. 64000  
Monterrey, N. L.  
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**MATRIZ**

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Tels. 81-8342-9948  
y 81-8345-0909

**SUCURSAL**

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Tel. 81-9627-5505

**CORREO**

comty1@hotmail.com

**PAGINA**

www.centrooptico.mx



## ULTRASONIC TEST REPORT

Customer: SICOM INDUSTRIES LTD.

Job Order: 763768	Purchase Order: 18133	Line Item: 001	Part Number/DWG: SU-1010-1072 MAT
Material Spec: ASTM B247 (AI 7075-T6) Rev. 20	Dimensions: 627x543x343 mm	Heat: A22-23139	Qty: 2
NDE Specification: ASTM B594-19 Class AA	Description: Rolled Ring	Test Date: Jun/06/2024	

## EQUIPMENT

Brand: Olympus	Model: Epoch 650	Serial No: 231556401	Calibration Date: Jan/25/2024	Due: Jan/25/2025
Type of Inspection: Contour	Method: Contact Manual			
Temperature: 90, °F	Surface Condition: Machined		Surface Roughness: 250 rms	

## Calibration Set Up

Set No.	Transd Size	Freq MHz	SN	Model	Brand	Angle	Screen Range	Refer dB	Tran dB	Scan dB	Sensitivity Method	Reference Size	Scan Surface	Scan Num
1	7x18 mm	2.00 MHz	57467	SEB2E	GE-Krautkramer	0	2	55	0	6	DAC FBH	3/64" (Aluminum)	OD/FACE	0
2	0.75" X 1.00"	2.25 MHz	38717	ABS-020608-GP	Technisonic	45	5	58	0	0	DAC FBH	3/64" FBH	OD	0
3	24 mm	2.00 MHz	1427865	PF2R-24	Panametrics	0	14	60	0	6	DAC FBH	3/64" (Aluminum)	FACE	0

DAC: Distance amplitude correction curve / BR: Back reflection Technique /FSH: Full screen height / FBH: Flat bottom hole / SDH: Side drilled hole/TPB: Test piece block

## Block Serial Number

Set Num	Block Serial Number
1	43499-04 ,43499-05 ,43499-06 ,43499-02 ,43499-01 ,43499-07 ,43499-03
2	AMS-2154 45°
3	43499-04 ,43499-05 ,43499-06 ,43499-02 ,43499-01 ,43499-07 ,43499-03

Couplant	Gel Quimedics QS1/water-propilen glicol-celulosa	Cable Length	6 feet	Cable Type	BNCLEMO
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RESULTS	Accepted
REMARKS	None recordable indication found
Customer SN	763768-01,763768-02

Number	Inspector Name	NDT Cert Level	Certification Due Date	Signature
1	David Hernández	Level II SNT-TC-1A	Apr/30/2026	



**DIMENSIONAL MACHINE SHOP REPORT NUMBER 326259**

**Job Order No.** 763768

**Qty:** 1

**Part Number:** SU-1010-1072 MAT

**Date:** 06/05/2024

**PO Number:** 18133

**Notes:**

**Forging Part Number :**

X= no go    √= go

**HEAT NUMBER:**

A22-23139

**LOT**

759037

DIMENSION	VALUE	TOLERANCE		UNIT	PIECE 1 Line item 001 Serial No 763768-01 Status PASS											
		-	+													
O.D.	24.670 (626.618)	0.062 (1.575)	0.062 (1.575)	in (mm)	24.677 (626.796) (√)											
I. D.	21.380 (543.052)	0.062 (1.575)	0.062 (1.575)	in (mm)	21.390 (543.306) (√)											
Height	13.500 (342.900)	0.062 (1.575)	0.062 (1.575)	in (mm)	13.504 (343.002) (√)											
SURFACE FINISH	250.000	250.000	0.000	Rms	200.000 (√)											

Waiver authorized by:

\_\_\_\_\_

Waiver's cause:

\_\_\_\_\_

Date:

\_\_\_\_\_

Sign:

Inspected by:

\_\_\_\_\_ JUAN ANGEL AGUILAR AVILA



**DIMENSIONAL MACHINE SHOP REPORT NUMBER 326274**

**Job Order No.** 763768

**Qty:** 1

**Part Number:** SU-1010-1072 MAT

**Date:** 06/05/2024

**PO Number:** 18133

**Notes:**

**Forging Part Number :**

X= no go    √= go

**HEAT NUMBER:**

A22-23139

**LOT**

759037

DIMENSION	VALUE	TOLERANCE		UNIT	PIECE 2 Line item 001 Serial No 763768-02 Status PASS											
		-	+													
O.D.	24.670 (626.618)	0.062 (1.575)	0.062 (1.575)	in (mm)	24.679 (626.847) (√)											
I. D.	21.380 (543.052)	0.062 (1.575)	0.062 (1.575)	in (mm)	21.390 (543.306) (√)											
Height	13.500 (342.900)	0.062 (1.575)	0.062 (1.575)	in (mm)	13.504 (343.002) (√)											
SURFACE FINISH	250.000	250.000	0.000	Rms	200.000 (√)											

Waiver authorized by:

\_\_\_\_\_

Waiver's cause:

\_\_\_\_\_

Date:

\_\_\_\_\_

Sign:

Inspected by:

\_\_\_\_\_ JUAN ANGEL AGUILAR AVILA