

**TO:** TT Electronics Customers  
**FROM:** Ian Swindell, Calibration Services Operation Manager  
**SUBJECT:** Impacts of Latest Revision of AMS2750F  
**DATE:** 15 March 2020

**MEMORANDUM**

A key update in the latest revision of AMS2750 states that all control, recording and over temperature instruments shall be digital by June 2022. We have identified areas where we believe we can offer support to our customers to ensure the transition to Revision F is a smooth process for all involved.

Table 5, Sensor Reuse and Recalibration (as shown below), explains that all control and recording sensors must be calibrated **before** first use, and **replaced accordingly** following evaluation of the condition of the items in accordance with a preventive maintenance schedule.

Recently, we've noticed that most freezers used for heat treatment processes have their instrumentation calibrated and System Accuracy Test's performed in accordance to the specification. However, we have found that the controlling/recording sensors themselves have often not been calibrated before first use. It is now a mandatory requirement of AMS2750 that all calibration work must be carried out on controlling/recording sensors *prior* to first use.

Sensor Use	Sensor Type	Form	Recalibration <sup>(3)</sup>	Reuse <sup>(1)(2)</sup>
Control and Recording Sensors	All	All	Before first use	Replaced in accordance with 2.2.42, 3.1.4.4, 3.4.8, and 3.4.9
Load Sensors	Base	Expendable	Recalibration is not permitted	Limited by number of uses, temperature of use, and calendar days since first use (see 3.1.10.1, 3.4.8, and 3.4.9)
		Non-expendable	J & N: Quarterly E & K: Quarterly; permitted if used at or below 500.0 °F or 260.0 °C; not permitted if used above 500.0 °F or 260.0 °C	Limited by number of uses, temperature of use, and calendar days since first use (see 3.1.10.2, 3.4.8, and 3.4.9)
	Noble <sup>(4)</sup>	Expendable	Semi-annually except as stated in 3.4.8 and 3.4.9 (see Table 1)	No other restrictions except as stated in 3.4.8 and 3.4.9
		Non-expendable		

Moving forward into Revision F, preventative maintenance has become a critical aspect in all heat treatment processes. Without a schedule in place, thermal processing equipment should remain at the Normal Periodic TUS Frequency in accordance with Table 18/19. Given our expertise, we are in a position to offer a maintenance package to bring your equipment up to required specification.

3.5.5 TUS Intervals

- 3.5.5.1 Extended TUS intervals shall be based on both instrument type and history of the required number of consecutive successful periodic TUS shown in Tables 18 and 19. In addition, a documented equipment preventive maintenance program, in accordance with 2.2.42, shall be in effect.

If you have any questions or require clarification on this, or any other subject, please don't hesitate to contact us, we would be happy to assist and offer a formal quotation on request.

Kind Regards,

Ian Swindell  
Calibration Services Manager  
[Roxspur.service@ttelelectronics.com](mailto:Roxspur.service@ttelelectronics.com)