

SAE Aerospace An SAE International Group	AEROSPACE MATERIAL SPECIFICATION	SAE AMS2768	REV. C
		Issued2005-08 Revised2010-07	
		Superseding AMS2768B	
Heat Treatment of Magnesium Alloy Castings			

RATIONALE

AMS2768C corrects footnotes to Table 3.

1. SCOPE

1.1 Purpose

This specification covers the engineering requirements for heat treatment of magnesium alloy castings and for parts machined from castings.

1.2 Application

This specification is applicable to castings of the following magnesium alloys:

AM100A	AZ63A	AZ81A	AZ91C	AZ91E	
AZ92A	EQ21A	EV31A	EZ33A	QE22A	
ZE41A	WE43A	WE43B	WE54A	ZK51A	ZK61A

1.3 When AMS2768 is specified and specific heat treat processing instructions are included in the material specification, the equipment and control requirements of AMS2768 shall apply. For alloys not specifically covered, the applicable provisions of this specification shall be invoked but temperatures, times, and quench procedures shall be as specified by the cognizant engineering organization.

1.4 It is permissible, for specific parts, to use equipment, practices and test methods which conformed to AMS-M-6857 and were previously acceptable to the purchaser.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AMS2768C>**

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2750 Pyrometry

AMS3025 Polyalkylene Glycol Heat Treat Quenchant

ARP1962 Training and Approval of Heat-Treating Personnel

2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM B 557 Methods of Tension Testing Wrought and Cast Aluminum and Magnesium Alloy Products

3. TECHNICAL REQUIREMENTS

3.1 Equipment

Equipment used for thermal processing shall conform to the requirements of this specification and AMS2750, except (1) requirements for working zone controls, instruments and sensors shall apply to all heating zones and (2) recordings from instruments may be stored on magnetic or optical media providing a hard copy is available on request.

3.1.1 Pyrometry

Shall meet the requirements of AMS2750.

3.1.2 Furnaces

3.1.2.1 Heating Media

Shall be air, protective atmosphere, combustible gases, or fluidized bed. Electrical heating elements and radiant tubes shall be shielded to prevent direct radiation from striking any part. The furnace products of combustion in the furnace, and the composition and maintenance of fluidized beds shall be such as to prevent attack or contamination of the parts, or impingement of the flame on the work.

3.1.2.2 Temperature Uniformity

The design and construction of the furnaces shall be such that the temperature in the working zone is capable of being maintained within ± 10 °F (6 °C) of the desired heat treating temperature after the charge has been brought up to temperature. At no time shall the temperature in any part of the working zone exceed the maximum permissible temperature for the alloy being heat treated (See Table 1).

3.1.3 Quenching

Unless otherwise approved by the cognizant engineering organization, the following provisions apply. Equipment shall be provided for quenching in water, air blast, spray, oil, or in polymer quenchants and for measuring quenchant temperature. Provisions shall be made for mechanical, hydraulic, or air agitation of the immersion quenching medium, or agitation of the parts, or both and for heating or cooling of the quenchant, as required. Air agitation of immersion quenchants shall be allowed, provided the air doesn't come in contact with the parts being quenched. Exception to the use of agitation is permitted provided that it has been demonstrated that the parts meet the specified properties in the final heat treated condition. The volume of quenching medium for immersion quenching shall be sufficient so that its temperature rise due to quenching meets the requirements of 3.2.8.3.1. Small parts heated and soaked in baskets may be quenched by dumping when basket loads are too heavy to allow adequate quenching by immersion of the full basket and provided that the parts are not damaged by dumping. Non immersion quench methods shall be documented and shall have demonstrated to produce the specified properties.

3.1.3.1 Polymer Quenchants

Polyalkylene glycol shall meet the requirements of AMS3025. Other synthetics may be used provided that they have demonstrated not to be detrimental to the material and that the parts meet the required specified properties in the final heat treated condition. Polymer concentration shall be established for the particular casting configuration prior to use.

3.1.4 Cleaning

Equipment shall be provided to clean castings before heat treatment, and to remove residual film from parts quenched in a polymer quenchant or oil from parts quenched or aged in oil baths.

3.2 Procedures

3.2.1 General

Cast parts that require heat treatment to a T4X, T5X, or T6X temper shall be heat treated in accordance with Tables 1 and 2 (See 3.2.4). Heat treatment shall be performed only on entire parts, never on a portion of a part. The process used to generate the necessary requirements shall be established and controlled for each part number to ensure that each lot of castings is treated in the same manner.

3.2.1.1 Rework Solution Cycles

Castings requiring re-heat treating may be solution heat treated using the cycles listed in Table 3 (See 8.2.2.1).

3.2.2 Racking and Spacing

Product shall be supported or hung and spaced to permit flow of the heating and cooling media over all surfaces to ensure that the castings will meet the specified requirements. Written instructions, drawings, photographs, etc. shall be used as necessary to ensure proper spacing.

3.2.2.1 Water Entrapment

Racks and fixtures used for solution heat treatment shall be constructed to preclude entrapment of water.

3.2.3 Loading

The furnaces shall be at or below the maximum solution treating temperature when the parts are loaded.

3.2.4 Control instrument(s) shall be set within the temperature range specified in Table 1 for solution treating and should be set at the recommended temperature specified in Table 2 for aging. Sensor/control offsets, if used, shall comply with AMS2750.

3.2.5 Soaking

Soaking time starts when all temperature control sensing elements are within 10 °F (6 °C) of the set or offset temperature.

3.2.5.1 Interruptions during solution treatment are permitted provided the minimum soak time is met and at least a 2-hour soak time occurs after the interruption. During aging treatments a maximum of four interruptions are permitted for removal or loading of parts. The time between door opening and furnace or load thermocouple recovery is not to be counted as part of the total aging time.

3.2.6 Logs

A record (written or electronic storage media), traceable to temperature recording information (chart(s) or electronic storage media) and to shop travelers or other documentation, shall be kept for each furnace and load. The information on the combination of documents shall include: equipment identification, approved personnel's identification, date, part number or product identification, number of parts, alloy, lot identification, AMS2768C or other applicable specification, actual thermal processing times and temperatures used. When applicable, atmosphere control parameters, quench delay, quenchant type, polymer concentration and quenchant temperature shall also be recorded. The maximum thickness, when process parameters are based on thickness, shall be recorded and shall be taken as the minimum dimension of the heaviest section of the part. The log data shall be recorded in accordance with the heat treater's documented procedures.

3.2.7 Cleaning

Prior to heat treatment, parts shall be cleaned to assure that there will be no adverse effects to the surfaces following heat treatment. Residue from heating and quenching media shall be removed from parts after heat treatment.

3.2.8 Solution Heat Treating

3.2.8.1 Temperature

Cast parts that require solution heat treatment shall be soaked within the temperature ranges specified in Table 1.

3.2.8.1.1 For solution heat treating AZ63A (type 1 and 2), AZ81A, AZ91C, AZ91E, AZ92A (type 1), AM100A, and ZK61A, the castings shall be heated slowly to prevent eutectic melting which is cause for rejection. Incremental steps or a uniform heating rate, which requires at least 2 hours to raise the temperature from 640 °F (338 °C) to the heat treating temperature, shall be used (See 8.5).

3.2.8.1.2 AZ92A (type 2) and QE22A may be charged into the furnace which is at the heat treating temperature.

3.2.8.1.3 Evidence of high temperature oxidation shall be cause for rejection (See 3.4.2.1). A protective atmosphere containing sufficient sulfur dioxide, carbon dioxide, or satisfactory oxidation inhibitor shall be used when solution heat treating at or above 750 °F (399 °C) (See 8.3).

3.2.8.2 Soaking Time

The castings shall be held at temperature for a sufficient time to secure adequate solution heat treatment. Recommended soaking times at temperature for castings up to 1 inch (25.4 mm) thickness are provided in Table 1. A longer soaking time may be required for castings with heavier sections.

3.2.8.3 Quenching

Parts, after being soaked at the solution heat treating temperature for the required time, shall be quenched.

3.2.8.3.1 Immersion Quenchant Temperature

During the quench, the quenchant temperature shall not rise more than 25 °F (14 °C). To prevent excessive warpage and possible cracking, castings may be quenched in oil or water with temperature varying from cold to hot (212 °F or 100 °C) or in a polymer quenchant at room temperature providing it is substantiated that the combination of quench and solution temperature will produce mechanical properties meeting the material specification. Exceptions to the temperature rise are permitted provided that it has been demonstrated by testing and documentation that the parts meet the required specified properties in the final heat treated condition.

3.2.8.3.2 Immersion Quench Delay Time

The quench delay time shall not exceed 30 seconds. The delay shall be measured from the time the furnace door of an air furnace starts to open, or the first portion of the load emerges from a fluidized bed, to complete immersion of the load in the quenchant. This delay time may be exceeded providing that the cooling rate does not result in a loss of any mechanical property typically obtained by the established process for that casting configuration.

3.2.8.3.3 Quenchant Contact Time

Castings which are quenched by immersion shall be kept immersed in the quenchant for not less than 2 minutes per inch of thickness, or fraction thereof in the thickest section. Alternatively, castings shall be kept immersed in the quenchant for not less than 2 minutes after boiling ceases. Parts quenched in boiling water shall remain immersed for not less than 2 minutes. Castings quenched in an air blast or spray shall remain in contact with the quench media until surface temperatures are reduced to 212 °F (100 °C).

3.2.9 Aging

Precipitation heat treatment or artificial aging, when T5 or T6 tempers are specified, shall be performed at the temperature and times required to develop the specified properties. Aging conditions which have been used satisfactorily are shown in Table 2. No protective atmosphere is required.

3.2.10 Straightening after final aging is prohibited unless otherwise specified by the cognizant engineering organization.

3.3 Qualification

3.3.1 Suppliers

Facilities performing heat treatment in accordance with this specification shall be subject to approval by the cognizant quality assurance organization (See 8.2.7).

3.3.2 Personnel

All responsible heat treating personnel at leadsman and foreman levels performing heat treatment in accordance with this specification shall be qualified as specified in 4.5.

3.4 Acceptance

3.4.1 The routine operation of the equipment and heat treating procedure shall be judged by the mechanical properties obtained on the test bars heat treated with every furnace charge and tested in accordance with ASTM B 557.

3.4.2 Microscopic Examination

The tensile test may be supplemented by a microscopic examination of the test bars or selected castings at the discretion of the cognizant engineering organization. At least one representative sample for each of the specified tests shall be taken. If the furnace selected for routine inspection contains a load which is homogeneous as to alloy, form and size of part, two specimens shall be selected to represent the least massive and the most massive portions of the charge. In the event of a nonhomogeneous load as to type of alloy, and when the recommended heat treatments for the respective alloys differ, additional samples shall be prepared.

3.4.2.1 Eutectic Melting and High Temperature Oxidation

Specimens from the heat treated samples shall be prepared for microscopic examination. The unetched surface shall be examined at 500X minimum magnification with a metallurgical microscope. The presence of eutectic melting or high temperature oxidation shall be considered evidence of improper heat treatment (See 3.4.3.3). Porosity should not be confused with eutectic melting.

3.4.3 Improper Heat Treatment

3.4.3.1 Improper Equipment

If any of the tests indicate that the heat treatment was improper (3.4) and was caused by poor performance of the furnace (and not improper settings or insufficient time in the furnace), the furnace shall not be used for further heat treating until it is demonstrated that all equipment and operating requirements of this specification are being met.

3.4.3.2 Status of Materials

Materials heat treated in the furnace since the time of the previous tests and found unsatisfactory shall be rejected or reheat treated (beginning with the solution heat treatment) in an acceptable furnace, depending on the character of the failed tests.

3.4.3.3 If the test samples show eutectic melting or high temperature oxidation, the casting lot(s) shall be rejected and no reheat treatment permitted.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of the product shall supply all samples for vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to specified requirements.

4.2 Inspection

The cognizant quality assurance organization may review heat treating records and the results of tests and inspections to verify that heat treatment conformed to all requirements of this specification.

4.3 Records

Records shall be kept available to purchaser for 5 years after performance of heat treatment. The records shall contain all data necessary to verify conformance to the requirements of this specification.

4.3.1 If the heat treating procedure is considered proprietary, the vendor may certify that the information is proprietary and is on file. The procedures shall be available for review by personnel representing the cognizant engineering or quality organizations.

4.4 Process Control

The cognizant quality assurance organization may perform any inspections, surveillance, tests, and statistical process control analyses necessary to ensure that parts are heat treated in accordance with this specification.

4.5 Personnel Qualification

ARP1962 provides an example of a program for training and approval and lists the associated operations.

4.6 Reports

The vendor shall furnish with each shipment a report referencing the heat treatment log number, the results of tests to determine conformance to this specification, and a statement that the parts were processed in accordance with the requirements of this specification. This report shall include the purchase order number, AMS2768C, alloy designation and material specification number, part number, and quantity.

5. PREPARATION FOR DELIVERY

5.1 Packaging

5.1.1 All parts shall be preserved and wrapped or packaged to ensure protection from corrosion and damage during handling, transportation, and storage.

5.1.2 The product shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling packaging, and transportation of the product to ensure carrier acceptance and safe delivery.

6. ACKNOWLEDGMENT

A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

7. REJECTIONS

Castings and parts not heat treated in accordance with this specification, or to modifications authorized by purchaser, will be subject to rejection.

8. NOTES

8.1 A change bar (I) located in the left margin is for the convenience of the user in locating areas where technical revisions, not editorial changes, have been made to the previous issue of this document. An (R) symbol to the left of the document title indicates a complete revision of the document, including technical revisions. Change bars and (R) are not used in original publications, nor in documents that contain editorial changes only.

8.2 Terms used in AMS are clarified in ARP1917 and as follows:

8.2.1 Solution Heat Treatment

Soaking parts at an elevated temperature for a sufficient time to put alloying constituents into solid solution followed by quenching to retain the condition until the parts are aged.

8.2.2 Aging (Precipitation Heat Treatment)

Soaking solution heat treated parts at a moderately elevated temperature to precipitate alloying constituents from solid solution to develop strength and corrosion resistance properties.

8.2.2.1 Re-solutioning

On T4/T6 alloys, there is a potential for grain growth to occur if re-solutioning is required, particularly if welding has been done.

8.2.3 Polymer Quenchant

A water solution of polyalkylene glycol or other synthetic material used when minimum distortion or low residual stresses are desired.

8.2.4 Parts

The words "parts", "casting", and "cast parts" as used in this specification have the same meaning and are used interchangeably. Small parts are those that are under 0.250 inch (6.35 mm) in nominal thickness and weigh 2 pounds (0.9 kg) or less.

8.2.5 Recovery and Soaking Time

Recovery time is elapsed time between insertion of parts in a heating medium and start of soaking time. Soaking time starts when all temperature control sensing elements and load thermocouples (if used) are within 10 °F (6 °C) of the set or offset temperature.

8.2.6 Cognizant Engineering Organization

A term applied to the engineering organization responsible for the design of the parts or a designee of that organization.

8.2.7 Cognizant Quality Assurance Organization

A term applied to the quality assurance organization which is allied to the cognizant engineering organization or its designee.

8.3 A potential fire hazard exists in the heat treatment of magnesium alloys. If, through oversight or failure of the temperature control equipment, the temperature of the furnace appreciably exceeds the maximum solution heat treating temperature of the alloy, the castings may ignite and burn. A suitable sulfur dioxide or carbon dioxide atmosphere prevents the starting of a fire until the temperature limits have been exceeded by a considerable amount. Many heat treaters use an atmosphere of 0.5 to 1.0 percent sulfur dioxide, or carbon dioxide in a minimum concentration of 3 percent to 950 °F (510 °C) or 5 percent up to about 1000 °F (538 °C). Once a magnesium fire has started, the sulfur dioxide or carbon dioxide supply to the furnace should be shut off, since the burning magnesium unites with the oxygen of these materials. Each furnace used should be equipped with a safety cutout which will turn the power off to the heating elements and blowers in the event of any malfunctioning or failure of the temperature control equipment. These safety cutouts should be set at a temperature of no more than 10 °F (6 °C) above the maximum temperature permitted for the alloy being heat treated. Air flow switches should also be installed to guard against the stoppage of circulation of air and they should be interconnected with a manual reset control.

8.3.1 When protective atmospheres referred to in 8.2 are used, the concentration in the furnace atmosphere should be checked at periodic intervals.

8.4 An effective method of extinguishing a magnesium fire in a gas tight furnace is to introduce boron trifluoride gas (BF₃) through a small opening into the closed furnace. Details of this method may be found in NFPA Bulletin No. 480, "Storage, Handling, and Processing of Magnesium", which is issued by the National Fire Protection Association. Argon, Nitrogen, Sulfur Hexafluoride (SF₆), Hydrofluorocarbon gas 1,1,1,2-tetrafluoroethane (HFC134a), and other inert gases or compounds, can be used to flood a furnace to extinguish a magnesium fire.