

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 4215

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

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Revised

ALUMINUM ALLOY CASTINGS, PREMIUM GRADE 5Si - 1.2Cu - 0.5Mg (C355)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.

2. COMPOSITION:

| | |
|-------------------------|-----------|
| Silicon | 4.5 - 5.5 |
| Copper | 1.0 - 1.5 |
| Magnesium | 0.4 - 0.6 |
| Iron | 0.20 max |
| Titanium | 0.20 max |
| Manganese | 0.10 max |
| Zinc | 0.10 max |
| Other Impurities, each | 0.05 max |
| Other Impurities, total | 0.15 max |
| Aluminum | remainder |

3. CONDITION: Solution and precipitation heat treated.

4. TECHNICAL REQUIREMENTS:

4.1 Casting: Castings shall be produced in lots from metal conforming to Section 2. Metal remelted from previously analyzed ingot may be poured directly into castings. Furnace or ladle additions of small amounts of grain refining elements or alloys are permissible. Unless otherwise agreed upon by purchaser and vendor, molten metal taken from alloying furnaces, with or without additions of foundry operating scrap (gates, sprues, risers, and rejected castings) shall not be poured into castings unless first converted to ingot, analyzed, and remelted or until the composition of a sample taken after the last addition to the melt has been found to conform to Section 2. The type of mold used for castings is not restricted.

4.1.1 A melt shall be the metal withdrawn from a batch furnace charge of 2000 lb or less as melted for pouring castings or, when permitted by purchaser, a melt shall be 4000 lb or less of metal withdrawn from one continuous furnace in not more than 8 consecutive hours.

4.1.2 A lot shall consist of castings poured from a single melt in not more than 8 consecutive hours.

4.2 Cast Test Specimens: When tensile test specimens and chemical analysis specimens are required, they shall be cast as follows and, when requested, shall be supplied with the castings.

Section 8.3 of the SAE Technical Board rules provides that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no attempt to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

4.2.1 Tensile Test Specimens: Shall be cast with each lot of castings, shall be standard (0.5 in. diameter at the reduced parallel section), and shall be cast to size in molds representative of the practice used for castings. Metal for the specimens shall be part of the melt which is used for the castings. If the metal for castings is given any treatment, such as fluxing or cooling and re-heating, the metal for the specimens shall be a portion of the metal so treated, and during such treatment shall be heated to the same maximum temperature and held for approximately the same length of time as the molten metal for castings.

4.2.2 Chemical Analysis Specimens: Shall be cast from each melt and shall be of size and shape agreed upon by purchaser and vendor.

4.3 Heat Treatment: All castings and tensile test specimens representing them shall be solution and precipitation heat treated in such a manner as to ensure conformance to the requirements of 4.4 and 4.5. At least one set of tensile test specimens shall, during each stage of heat treatment, be put into a batch type furnace with each load of castings or into a continuous furnace at intervals of not longer than 3 hours.

4.4 Tensile Properties:

4.4.1 Specimens Cut from Castings:

4.4.1.1 Test specimens cut from any area of the castings shall conform to the following requirements:

| | |
|---|------------|
| Tensile Strength, psi | 35,000 min |
| Yield Strength at 0.2% Offset or at 0.0094 in. in 2 in. Extension Under Load (E = 10,300,000), psi | 28,000 min |
| Elongation, % in 2 in. | 2 min |

4.4.1.1.1 Conformance to these requirements may be used as basis for acceptance of castings.

4.4.1.2 When specified on the order, tensile test specimens taken in locations indicated on the drawing, from a casting chosen at random to represent the lot, shall have the properties indicated on the drawing for each specimen.

4.4.2 Tensile Test Specimens: The following requirements apply only when cast specimens are required.

| | |
|---|------------|
| Tensile Strength, psi | 37,000 min |
| Yield Strength at 0.2% Offset or at 0.0098 in. in 2 in. Extension Under Load (E = 10,300,000), psi | 30,000 min |
| Elongation, % in 2 in. | 1 min |

4.5 Hardness of Castings: Except at sprues and risers, castings shall have hardness of Brinell 65 - 95 using 500 kg load and 10 mm ball or 1000 kg load and 9/16 in. ball, or Brinell 70 - 100 using 1000 kg load and 10 mm ball.

5. QUALITY:

- 5.1 Castings shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts. Castings shall have smooth surfaces and shall be well cleaned.
- 5.2 Radiographic and other quality standards shall be as agreed upon by purchaser and vendor.
- 5.3 Unless otherwise specified, castings shall be produced under radiographic control. This shall consist of radiographic examination of castings until proper foundry technique, which will produce castings free from harmful internal imperfections, is established for each part number, and of production castings as necessary to ensure maintenance of satisfactory quality.
- 5.4 Castings shall not be repaired by plugging, welding, or other methods, without written permission from purchaser.
- 5.5 Castings shall not be impregnated, chemically treated, or coated to prevent leaking, unless specified or allowed by written permission which states the method to be used. Impregnated castings shall be marked IMP.

6. REPORTS:

- 6.1 Unless otherwise specified, the vendor of castings shall furnish with each shipment three copies of a report of the results of tensile tests on specimens cut from castings from each lot and a statement that the chemical composition of the castings conforms to the requirements of this specification. This report shall include the purchase order number, lot number, material specification number, part number, and quantity.
- 6.2 Unless otherwise specified, the vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number, contractor or other direct supplier of castings, part number, and quantity. When castings for making parts are produced or purchased by the parts vendor, that vendor shall inspect each shipment or lot of castings to determine conformance to the requirements of this specification, and shall include in the report a statement that the castings conform, or shall include copies of laboratory reports showing the results of tests to determine conformance.

- 7. IDENTIFICATION: Unless otherwise specified, castings shall be identified in accordance with the latest issue of AMS 2804 including the lot number and heat treatment batch number.

8. APPROVAL:

- 8.1 To assure uniformity of quality, sample castings from new or reworked patterns or molds shall be approved by purchaser, unless such approval be waived.