

ALUMINUM ALLOY FORGINGS
7.5Zn - 1.6Mg - 0.7Cu - 0.55Mn (76S-T6)

This specification has been declared "NONCURRENT" by the Aerospace Materials Division, SAE, as of 11-18-66. It is recommended that this specification not be specified for new designs.

This cover sheet should be attached to the original issue of the subject specification.

This specification has been declared "CANCELLED" by the Aerospace Materials Division, SAE, as of 7- 1-81. By this action, subject specification number and title will be deleted from the active specification index of Aerospace Material Specifications.

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5.1.1.2 Forgings, With Grain Flow: When test specimens are machined from forgings not over 3 in. in thickness or from large forgings which have been machined to a 3 in. maximum section before heat treatment, with the axis approximately parallel to the forging flow lines, the tensile properties shall conform to those specified in 5.1.1.1, except that elongation may be as low as 10.0%, unless otherwise agreed upon by purchaser and vendor.

5.1.1.3 Forgings, Across Grain Flow: When test specimens are machined from forgings not over 3 in. in thickness or from large forgings which have been machined to a 3 in. maximum section before heat treatment so that the axis is other than approximately parallel to the forging flow lines, the tensile properties shall conform to the following requirements.

Tensile Strength, psi	65,000 min
Yield Strength at 0.2% Offset or at 0.0146 in. in 2 in. Extension Under Load (E = 10,300,000), psi	55,000 min
Elongation, % in 4D	3 min

5.1.1.3.1 The elongation requirement applies only to test specimens having a gage length diameter not less than 0.25 in. and cut so that the length of the specimen is in a plane parallel to the parting plane.

5.1.1.3.2 If any individual specimen fails to meet the requirements of 5.1.1.3, two additional specimens shall be cut from adjacent areas in the same forging or from the same area in two additional forgings. Should either of these specimens fail to meet the values specified in 5.1.1.3, the entire lot may be rejected.

5.1.2 Hardness: Forgings shall have hardness not lower than Brinell 140 using 500 kg load and 10 mm ball or 1000 kg load and 9/16 in. ball, or not lower than Brinell 145 using 1000 kg load and 10 mm ball.

Ø 5.2 Hand Forgings:

5.2.1 Tensile Properties After Heat Treatment: Hand forgings 3 in. and under in thickness, and test coupons not more than 3 in. in thickness from larger hand forgings, shall, after proper solution and precipitation heat treatment, conform to the following requirements, based on the cross-sectional area of the forging before machining. Tensile test specimens shall be taken substantially parallel to and perpendicular to the length of the hand forging in such a manner as to represent the center of the forging.

Ident. Class	Cross-Sectional Area Square Inches	Length Ranges	Tensile Strength psi, min		Yield Strength at 0.2% Offset psi, min		Elongation % in 2 in. or l_D min	
			Longitudinal	Long Transverse	Longitudinal	Long Transverse	Longitudinal	Long Transverse
CL 1	16 & under	up to 3 times width, incl	70,000	65,000	60,000	55,000	14.0	3.0
CL 2	16 & under	over 3 times width	68,000	63,000	58,000	53,000	11.0	2.0
CL 3	over 16 to 36, incl	up to 3 times width, incl	67,000	62,000	57,000	52,000	9.0	2.0

5.2.1.1 If material is tested in the short transverse direction, the tensile strength requirement shall be not lower than that shown for the long transverse direction by more than 3,000 psi; the yield strength requirement shall be not lower than that for the long transverse direction; and the elongation requirement shall be not lower than that for the long transverse direction by more than 3 percentage points but in any case shall be not lower than 1%. The elongation requirement applies only when based on test specimens having a gage length diameter not less than 0.25 inch.

∅ 5.2.1.2 Routine testing for longitudinal properties is not required.

5.2.2 Hardness After Heat Treatment: Hand forgings 3 in. and under in thickness and larger forgings with sections machined to 3 in. and under in thickness before heat treating shall, after proper solution and precipitation heat treatment, have hardness not lower than Brinell 140 using 500 kg load and 10 mm ball or 1000 kg load and 9/16 in. ball, or not lower than Brinell 145 using 1000 kg load and 10 mm ball.

5.3 Forgings with Special Requirements: When purchase order specifies "Special Purpose", detailed grain flow in forgings and/or minimum tensile property requirements of tensile test specimens cut from forgings shall be as specified on the drawing or as agreed upon by purchaser and vendor.

5.4 Forging Stock:

5.4.1 When a sample of stock is forged to a test coupon and heat treated in the same manner as forgings, a tensile test specimen taken from the heat treated coupon shall have properties not lower than those specified in 5.1.1.1 and 5.1.2. If a test specimen taken from the stock after heat treatment in the same manner as forgings has properties not lower than those specified in 5.1.1.1 and 5.1.2, the test shall be accepted as equivalent to the test of a forged coupon. Neither of these tests is required in routine inspection.

5.4.2 Unless otherwise specified, tolerances shall be in accordance with commercial practice for the class ordered.

6. QUALITY: Material shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external defects detrimental to fabrication or to performance of parts.