

AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
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AMS 4217

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Revised

ALUMINUM ALLOY CASTINGS (Sand) 7 Silicon (356 - T6)

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

| | |
|-------------------------|-----------|
| Silicon | 6.5 - 7.5 |
| Magnesium | 0.2 - 0.4 |
| Iron | 0.6 max |
| Copper | 0.2 max |
| Titanium | 0.2 max |
| Manganese | 0.1 max |
| Zinc | 0.1 max |
| Other Impurities, each | 0.05 max |
| Other Impurities, total | 0.15 max |
| Aluminum | remainder |
3. CASTING: (a) During melting, the metal shall be heated to not over 1450°F. The metal being poured into the mold shall not exceed a temperature of 1400°F. Written permission must be obtained from the purchaser by letter or by revising the drawing before deviating from the requirements of this paragraph.

(b) The metal for making tensile test bars of the standard size for testing shall form a part of the melt or heat which is used for the castings. In the event the metal for the castings is given any treatment such as fluxing, or cooling and reheating, the metal for the test bars shall form a portion of the metal so treated. The metal for the test bars and castings may be separated into lots for pouring, but the variation in temperature between the lots in the pouring ladles shall not exceed 20°F at the time the final temperature reading is made, which shall be immediately before pouring into the molds. The mold shall be made with the regular foundry mix of green sand without using chills.
4. HEAT TREATMENT: (a) The test bars, together with the castings which they represent, shall be heated to the required temperature and time for the solution treatment, and quenched in water which is boiling before the quench.

(b) The test bars, together with the castings which they represent, after the solution treatment as in paragraph 4(a) shall be heated uniformly to a minimum temperature of 300°F, held at heat for not less than 1 hour and cooled in air. The hardness of the castings shall then be within the limits of Brinell 65-95 when tested with a 500 kg load and a 10 mm ball, or the equivalent.
5. TEST BARS: (a) Tensile test bars shall be cast with each melt of castings, unless otherwise specified. A melt shall mean a furnace charge (1000 pounds or less) of metal as melted for pouring castings. In the case of continuous melting, a melt shall mean that amount of metal melted under similar conditions and required for the pouring of 1000 pounds of cleaned castings. Test bars are to be supplied with the castings when requested.