

AEROSPACE MATERIAL SPECIFICATION



AMS 4294

Issued
Reaffirmed

FEB 2001
APR 2006

Aluminum Alloy Extrusions
1.0Mg - 0.60Si - 0.28Cu - 0.20Cr (6061-T5511)
Press Heat Treated, Stress Relieved by Stretching, Straightened, and Artificially Aged

UNS A96061

1. SCOPE:

1.1 Form:

This specification covers an aluminum alloy in the form of extruded bars and rods.

1.2 Application:

These extrusions have been used typically for parts requiring moderate strength and where distortion during machining must be minimized, but usage is not limited to such applications.

1.2.1 These extrusions have been used for applications which do not require the technical requirements and quality assurance provisions of AMS 2772 heat treatment.

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 canceled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2355	Quality Assurance Sampling and Testing, Aluminum Alloys and Magnesium Alloys, Wrought Products, Except Forging Stock, and Rolled, Forged, or Flash Welded Rings
MAM 2355	Quality Assurance Sampling and Testing, Aluminum Alloys and Magnesium Alloys, Wrought Products, Except Forging Stock, and Rolled, Forged, or Flash Welded Rings, Metric (SI) Units

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2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 594 Ultrasonic Inspection of Aluminum-Alloy Wrought Products for Aerospace Applications
 ASTM B 666/B 666M Identification Marking of Aluminum and Magnesium Products
 ASTM B 807 Extrusion Press Solution Heat Treatment for Aluminum Alloys

2.3 ANSI Publications:

Available from ANSI, 11 West 42nd Street, New York, NY 10036-8002.

ANSI H35.2 Dimensional Tolerances for Aluminum Mill Products
 ANSI H35.2M Dimensional Tolerances for Aluminum Mill Products (Metric)

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined in accordance with AMS 2355 or MAM 2355.

TABLE 1 - Composition

Element	min	max
Silicon	0.40	0.8
Iron	--	0.7
Copper	0.15	0.40
Manganese	--	0.15
Magnesium	0.8	1.2
Chromium	0.04	0.35
Zinc	--	0.25
Titanium	--	0.15
Other Elements, each	--	0.05
Other Elements, total	--	0.15
Aluminum	--	--

3.2 Condition:

Extrusion press heat-treated (press quenched), stress relieved by stretching to produce a nominal permanent set of 1.5%, but not less than 1% nor more than 3%, and artificially aged to the T5511 temper. Heat treatments shall be performed in accordance with ASTM B 807.

- 3.2.1 Extrusions may receive minor straightening, after stretching, of an amount necessary to meet the requirements of 3.5.
- 3.2.2 Extrusions shall be supplied with an as-extruded surface finish; light polishing to remove minor surface imperfections is permissible provided such imperfections can be removed within specified dimensional tolerances.

3.3 Properties:

Extrusions shall conform to the following requirements, determined in accordance with AMS 2355 or MAM 2355:

- 3.3.1 Tensile Properties: Shall be as shown in Table 2.

TABLE 2A - Minimum Tensile Properties, Inch/Pound Units

Nominal Diameter or Least Thickness (Bars and Rods) Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches or 4D %
1.000 to 7.000, incl	40.0	36.0	10

TABLE 2B - Minimum Tensile Properties, SI Units

Nominal Diameter or Least Thickness (Bars and Rods) Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm or 4D %
25.4 to 177.8, incl	276	248	10

3.4 Quality:

Extrusions, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to usage of the extrusions.

- 3.4.1 When specified, extrusions shall be subjected to ultrasonic inspection in accordance with ASTM B 594. Extrusions, 0.50 inch (12.7 mm) and over in nominal diameters or least distance between parallel sides, not exceeding 600 pounds (272 kg) per piece, or a 10 to 1 width-to-thickness ratio, shall meet ultrasonic Class B.

3.5 Tolerances:

Shall conform to all applicable requirements of ANSI H35.2 or ANSI H35.2M.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of extrusions 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 extrusions conform to specified requirements.

4.2 Classification of Tests:

Composition (3.1), tensile properties (3.3.1), ultrasonic inspection when specified (3.4.1), and tolerances (3.5) are acceptance tests and, except for composition, shall be performed on each inspection lot.

4.3 Sampling and Testing:

Shall be in accordance with AMS 2355 or MAM 2355.

4.4 Reports:

The vendor of extrusions shall furnish with each shipment a report stating that the extrusions conform to the chemical composition, ultrasonic inspection when specified, and tolerances and showing the numerical results of tests on each inspection lot to determine conformance to the other acceptance test requirements. This report shall include the purchase order number, inspection lot number, AMS 4294, size or section identification number, and quantity.

4.5 Resampling and Retesting:

Shall be in accordance with AMS 2355 or MAM 2355.

5. PREPARATION FOR DELIVERY:

5.1 Identification:

Shall be in accordance with ASTM B 666/B 666M.

5.2 Packaging:

Extrusions 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 extrusions to ensure carrier acceptance and safe delivery.

6. ACKNOWLEDGMENT:

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