



# AEROSPACE MATERIAL SPECIFICATION

AMS4479

Issued

2015-01

Aluminum Alloy, Extruded Profiles (2824-T3511)  
4.0Cu - 1.35Mg - 0.7Mn  
Solution Heat Treated and Stress Relieved by Stretching  
(Composition similar to UNS A92824)

## RATIONALE

AMS4479 is a new specification for aluminum alloy 2824 extruded profiles, solution heat treated and stress relieved by stretching.

### 1. SCOPE

#### 1.1 Form

This specification covers an aluminum alloy in the form of extruded profiles with a maximum cross-sectional area of 25 in<sup>2</sup> (160.29 cm<sup>2</sup>) and nominal thicknesses from 0.250 to 2.500 inch, inclusive (6.3 to 63.50 mm, inclusive).

#### 1.2 Application

These extrusions have been used typically for machined parts requiring dimensional stability during machining processes, high strength and damage tolerance, but usage is not limited to such applications.

1.2.1 Certain processing procedures may cause this product to become susceptible to stress-corrosion cracking; ARP823 recommends practices to minimize such conditions.

### 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.

#### 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](http://www.sae.org).

AMS2355 Quality Assurance, Sampling and Testing, Aluminum Alloys and Magnesium Alloy, Wrought Products (Except Forging Stock), and Rolled, Forged, or Flash Welded Rings

AMS2772 Heat Treatment of Aluminum Alloy Raw Materials

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2015 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)  
Tel: +1 724-776-4970 (outside USA)  
Fax: 724-776-0790  
Email: [CustomerService@sae.org](mailto:CustomerService@sae.org)  
SAE WEB ADDRESS: <http://www.sae.org>

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AMS4479>

AS1990 Aluminum Alloy Tempers

ARP823 Minimizing Stress-Corrosion Cracking in Wrought Heat-Treatable Aluminum Alloy Products

## 2.2 ANSI Publications

Available from American National Standards Institute, 25 West 43rd Street, New York, NY 10036-8002, Tel: 212-642-4900, [www.ansi.org](http://www.ansi.org).

ANSI H 35.2 Dimensional Tolerances for Aluminum Mill Products

ANSI H 35.2M Dimensional Tolerances for Aluminum Mill Products (Metric)

## 2.3 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](http://www.astm.org).

ASTM B 594 Ultrasonic Inspection of Aluminum Alloy Wrought Products for Aerospace Applications

ASTM B 660 Packaging of Aluminum and Magnesium Products

ASTM B 666/B 666M Identification Marking of Aluminum and Magnesium Products

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined in accordance with AMS2355.

**TABLE 1 - Composition**

Element	min	max
Silicon	--	0.08
Iron	--	0.11
Copper	3.7	4.3
Manganese	0.50	0.9
Magnesium	1.1	1.6
Chromium	--	0.05
Zinc	--	0.25
Titanium	--	0.15
Other Elements, each	--	0.05
Other Elements, total	--	0.15
Aluminum	remainder	

### 3.2 Condition

Extruded, solution heat treated and stress relieved by stretching to produce a nominal permanent set of 2%, but not less than 1% nor more than 3%, to the -T3511 temper (See AS1990).

3.2.1 Product shall be supplied with an as-extruded surface finish; light polishing to remove minor surface conditions is permissible provided such conditions can be removed within specified dimensional tolerances.

3.2.2 Product may receive minor straightening, after stretching, of an amount necessary to meet the requirements of 3.6.

### 3.3 Heat Treatment

Solution heat treatment shall be in accordance with AMS2772, with the solution heat treating temperature range between 910 and 930 °F.

### 3.4 Properties

Product shall conform to the following requirements, determined on the mill produced size in accordance with AMS2355:

3.4.1 Longitudinal and long transverse tensile properties, when specified (See 8.5), of extrusions with a maximum cross-sectional area of 25 square inches (160.29 cm<sup>2</sup>), shall be as specified in Table 2.

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

Nominal Thickness Inches	Specimen Orientation	Tensile Strength ksi	Yield Strength At 0.2% Offset ksi	Elongation in 2 inches or 4D %
0.250 to 0.499, incl	Longitudinal	71.0	54.0	12
	Long-Transverse	68.0	48.0	--
0.500 to 0.749, incl	Longitudinal	73.0	55.0	11
	Long-Transverse	68.0	47.0	8
0.750 to 0.999, incl	Longitudinal	73.0	55.0	11
	Long-Transverse	67.0	47.0	8
1.000 to 1.499, incl	Longitudinal	74.0	56.0	11
	Long-Transverse	66.0	47.0	8
1.500 to 1.999, incl	Longitudinal	74.0	56.0	11
	Long-Transverse	65.0	46.0	8
2.000 to 2.500, incl	Longitudinal	74.0	56.0	10
	Long-Transverse	64.0	46.0	8

**TABLE 2B - Minimum Tensile Properties, SI Units**

Nominal Thickness Millimeters	Specimen Orientation	Tensile Strength MPa	Yield Strength At 0.2% Offset MPa	Elongation in 50.8 mm or 4D %
Over 6.3 to 12.67, incl	Longitudinal	490	372	12
	Long-Transverse	469	331	--
Over 12.67 to 19.02, incl	Longitudinal	503	379	11
	Long-Transverse	469	324	8
Over 19.02 to 25.37, incl	Longitudinal	503	379	11
	Long-Transverse	462	324	8
Over 25.37 to 38.07, incl	Longitudinal	510	386	11
	Long-Transverse	455	324	8
Over 38.07 to 50.77, incl	Longitudinal	510	386	11
	Long-Transverse	448	317	8
Over 50.77 to 63.50, incl	Longitudinal	510	386	10
	Long-Transverse	441	317	8

3.4.2 Mechanical properties outside the range covered by 3.4.1 shall be agreed upon between purchaser and producer.

### 3.5 Quality

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

3.5.1 When specified, each extruded profile having a maximum width-to-thickness ratio of 10:1 shall meet ultrasonic class B requirements, as described in ASTM B 594 (See 8.5).

### 3.6 Tolerances

Shall conform to all applicable requirements of ANSI H 35.2 or ANSI H 35.2M.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The vendor of the products 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 products conform to specified requirements.

### 4.2 Classification of Tests

#### 4.2.1 Acceptance Tests

Composition (3.1), longitudinal and long transverse (when specified) tensile properties (3.4.1), ultrasonic inspection when specified (3.5.1), and tolerances (3.6) are acceptance tests and, except for composition, shall be performed on each inspection lot.

### 4.3 Sampling and Testing

Shall be in accordance with AMS2355.

### 4.4 Reports

The vendor of the product shall furnish with each shipment a report stating that the product conforms to the 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, AMS4479, size or section identification number, and quantity. This report shall also identify the producer, the product form, and the size of the mill product.

4.4.1 When the product size is outside the range covered by 3.4.1, the report shall contain a statement to that effect.

### 4.5 Resampling and Retesting

Shall be in accordance with AMS2355.

## 5. PREPARATION FOR DELIVERY

### 5.1 Identification

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

### 5.2 Packaging

Products shall be prepared for shipment in accordance with ASTM B 660 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. ACKNOWLEDGEMENT

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