



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

AMS 4500E

Superseding AMS 4500D

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COPPER SHEET, STRIP, AND PLATE
Soft Annealed (CDA 110)

UNS C11000

1. SCOPE:

1.1 Form: This specification covers unalloyed copper in the form of sheet, strip, and plate.

1.2 Application: Primarily for electrical components and formed and drawn parts such as gaskets and washers.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2222 - Tolerances, Copper and Copper Alloy Sheet, Strip, and Plate

AMS 2350 - Standards and Test Methods

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM B193 - Resistivity of Electrical Conductor Materials

ASTM B248 - General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar

ASTM E18 - Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

ASTM E53 - Chemical Analysis of Copper, (Electrolytic Determination of Copper)

ASTM E290 - Semi-Guided Bend Test for Ductility of Metallic Materials

2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

2.3.2 Military Specifications:

MIL-C-3993-Copper and Copper-Base Alloy Mill Products, Packaging of

3. TECHNICAL REQUIREMENTS:

SAE Technical Board rules provide that: "All technical reports, including standards approved by the Board, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or specification. 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."

- 3.1 Material: Shall be electrolytic tough pitch or oxygen-free copper conforming to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E53, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

	min	max
Copper + silver	99.90	--
Other Elements, total	--	0.10

- 3.2 Condition: Cold rolled and fully recrystallized, in soft, bright annealed temper.

- 3.3 Properties: The product shall conform to the following requirements:

- 3.3.1 Bending: The product shall withstand, without cracking, bending in accordance with ASTM E290 at room temperature flat on itself with axis of bend parallel to the direction of rolling.

- 3.3.2 Hardness: Shall be not higher than the following, determined in accordance with ASTM E18:

Nominal Thickness		Hardness max
Inch	(Millimetres)	
0.015 to 0.030, excl	(0.38 to 0.76, excl)	HR15T 68
0.030 and over	(0.76 and over)	HRF 65

- 3.3.3 Electrical Resistivity: Shall be not greater than $0.15328 \Omega \cdot \text{g}/\text{m}^2$, determined in accordance with ASTM B193.

- 3.4 Quality: The product, as received by the purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the product.

- 3.5 Tolerances: Unless otherwise specified, tolerances shall conform to AMS 2222 as applicable to non-refractory alloys.

4. QUALITY ASSURANCE PROVISIONS:

- 4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the product conforms to the requirements of this specification.

- 4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests.

- 4.3 Sampling: Shall be in accordance with ASTM B248.

4.4 Reports:

- 4.4.1 The vendor of the product shall furnish with each shipment three copies of a report stating that the product conforms to the chemical composition and other technical requirements of this specification. This report shall include the purchase order number, lot number, material specification number and its revision letter, size, and quantity.

4.4.2 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 and its revision letter, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

4.5 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the product may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the product represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

5.1 Identification: Each sheet, strip, and plate shall be identified as in 5.1.1 unless line marking as in 5.1.2 is specified by purchaser.

5.1.1 Each sheet, strip, and plate shall be marked near one end, coils being marked near the outside end, with AMS 4500E, lot number, manufacturer's identification, and nominal thickness, using any suitable marking fluid. As an alternate method, individual pieces or bundles shall have attached a durable tag marked with the above information or shall be boxed and the box marked with the same information.

5.1.2 When specified by the purchaser, each sheet, strip and plate shall be marked on one face, in the respective location indicated below, with AMS 4500E, lot number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be clearly legible, shall be applied using a suitable marking fluid, and shall be removable in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the product or its performance and shall be sufficiently stable to withstand normal handling. The specification number, manufacturer's identification, and nominal thickness shall be continuously line marked; the lot number may be included in the line marking, or may be marked at one location on each piece.

5.1.2.1 Flat Strip 6 In. (152 mm) and Under in Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm).

5.1.2.2 Flat Sheet, Flat Strip Over 6 In. (152 mm) in Width, and Plate: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm), the rows being spaced not more than 6 in. (152 mm) apart and alternately staggered.

5.1.2.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1.2 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1.2. When the inside end of the coil is inaccessible, as when the product is wound on cores, the tag or label may be attached to the core.

5.2 Packaging:

5.2.1 The product shall be prepared for shipment in accordance with commercial practice to ensure carrier acceptance and safe transportation to the point of delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

5.2.2 For direct U. S. Military procurement, packaging shall be in accordance with MIL-C-3993, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2.1 will be acceptable if it meets the requirements of Level C.