



AEROSPACE MATERIAL SPECIFICATION

AMS4611

REV. H

Issued 1942-12
Revised 2003-10
Reaffirmed 2014-04

Superseding AMS4611G

Brass, Naval, Bars and Rods
60.5Cu - 38.7Zn - 0.8Sn
Half Hard (H02)
(Composition similar to UNS C46400)

RATIONALE

AMS4611H has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE:

1.1 Form:

This specification covers a copper alloy (naval brass) in the form of bars and rods.

1.2 Applications:

These products have been used typically for automatic screw machine parts, but usage is not limited to such applications. These products have better corrosion resistance than AMS 4610 but are less readily machinable.

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, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or www.sae.org.

AMS 2221 Tolerances, Copper and Copper Alloy Bars and Rods
AMS 4610 Brass, Free-Cutting, Bars and Rods, 61.5Cu - 35Zn - 3.1Pb Half Hard (H02)

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2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or www.astm.org.

ASTM B 154	Mercurous Nitrate Test for Copper and Copper Alloys
ASTM B 249	General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes, and Forgings
ASTM B 249M	General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes, and Forgings (Metric)
ASTM B 858	Ammonia Vapor Test for Determination of Susceptibility to Stress Corrosion Cracking in Copper Alloys
ASTM E 8	Tension Testing of Metallic Materials
ASTM E 8M	Tension Testing of Metallic Materials (Metric)
ASTM E 478	Chemical Analysis of Copper Alloys

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 478, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element (3.1.1)	min	max
Copper	59.0	62.0
Tin	0.50	1.0
Lead	--	0.20
Iron	--	0.10
Sum of Named Elements (3.1.3)	99.6	--
Zinc (See 3.1.2)	remainder	

- 3.1.1 These composition limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements by agreement between the manufacturer or supplier and purchaser.
- 3.1.2 Zinc may be reported as "remainder", as the difference between the sum of results for all elements and 100%, or as the result of direct analysis.
- 3.1.3 When all named elements in Table 1 are analyzed, the sum shall be 99.6 percent minimum, but such determination is not required for routine acceptance of each lot.

3.2 Condition:

Cold finished, half-hard (H02) temper (See 8.2).

3.3 Properties:

The product shall conform to the following requirements:

- 3.3.1 Tensile Properties: Shall be as shown in Table 2, determined in accordance with ASTM E 8 or ASTM E 8M except as specified in 4.3.2.1.

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

Nominal Thickness Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches or 4D %, min
Up to 0.500, incl	60.0	27.0	22 (See 3.3.1.1)
Over 0.500 to 1.000, incl	60.0	27.0	25
Over 1.000 to 2.500, incl	58.0	26.0	25
Over 2.500 to 3.500, incl	54.0	25.0	27
Over 3.500	54.0	22.0	30

TABLE 2B - Minimum Tensile Properties, SI Units

Nominal Thickness Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm or 4D %, min
Up to 12.70, incl	414	186	22 (See 3.3.1.1)
Over 12.70 to 25.40, incl	414	186	25
Over 25.40 to 63.50, incl	400	179	25
Over 63.50 to 88.90, incl	372	172	27
Over 88.90	372	152	30

- 3.3.1.1 In no case shall the gage length be less than 1 inch (25 mm).

- 3.3.2 Embrittlement: Specimens as in 4.3.3.1 shall withstand, without cracking, immersion in mercurous nitrate solution in accordance with ASTM B 154, Procedure A, or the Ammonia Vapor Test in accordance with ASTM B 858.

3.4 Quality:

The product, 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 product.

3.5 Tolerances:

Shall conform to AMS 2221 as applicable to nonrefractory alloys.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of the product 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 product conforms to specified requirements.

4.2 Classification of Tests:

All technical requirements are acceptance tests and shall be performed on each lot.

4.3 Sampling and Testing:

Shall be in accordance with ASTM B 249 or ASTM B 249M and the following:

4.3.1 Composition: One sample from each lot.

4.3.2 Tensile Properties: One sample from each lot.

4.3.2.1 Tensile tests shall be performed on full-section specimens when practicable. When machined specimens are required, the axis of the specimen shall coincide with the central axis of the piece except that for bars and rods over 1.50 inches (38.1 mm) in nominal diameter or distance between parallel sides, the axis shall be midway between center and surface of the piece. The longitudinal axis of the tensile specimen shall be parallel to the direction of rolling or drawing.

4.3.3 Embrittlement: One sample from each lot, unless otherwise agreed upon by purchaser and vendor.

4.3.3.1 Specimens for embrittlement test shall be full cross-sections of the product and shall have length of approximately 6 inches (152 mm) or twice the nominal diameter or least distance between parallel sides, whichever is greater.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of tests for chemical composition, tensile properties, and embrittlement of each lot and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, lot number, AMS 4611H, size, and quantity.

4.5 Resampling and Retesting:

If any specimen used in the above tests fails to meet specified requirements, disposition of the product may be based on the results of testing two additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet specified requirements shall be cause for rejection of the product represented. Results of all tests shall be reported.