



# AEROSPACE MATERIAL SPECIFICATION

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

**AMS 5022H**  
Superseding AMS 5022G

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## STEEL BARS, FORGINGS, AND TUBING, FREE CUTTING 0.14 - 0.20C (SAE 1117)

### 1. SCOPE:

- 1.1 Form: This specification covers a free-cutting carbon steel in the form of bars, forgings, mechanical tubing, and forging stock.
- 1.2 Application: Primarily for use on parts requiring good machinability and response to carburizing heat-treatment.

### 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, Pennsylvania 15096.

#### 2.1.1 Aerospace Material Specifications:

AMS 2231 - Tolerances, Carbon Steel Bars  
AMS 2253 - Tolerances, Carbon and Alloy Steel Tubing  
AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels  
AMS 2350 - Standards and Test Methods  
AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products Except Forgings and Forging Stock  
AMS 2372 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Forgings and Forging Stock  
AMS 2808 - Identification, Forgings

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

ASTM E10 - Brinell Hardness of Metallic Materials  
ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

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

#### 2.3.1 Federal Standards:

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

### 3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E350, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

SAE Technical Board rules provide that: "All technical reports, including standards, approved practices recommended, 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 recommended practice, and no commitment to conform to or be guided by any technical report. 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."

	min	max
Carbon	0.14	0.20
Manganese	1.00	1.30
Phosphorus	--	0.040
Sulfur	0.08	0.13

- 3.1.1 When agreed upon by purchaser and vendor, manganese may be as high as 1.60.
- 3.1.2 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

3.2 Condition: The product shall be supplied in the following condition:

- 3.2.1 Bars and Mechanical Tubing 2.50 In. (63.5 mm) and Under in OD or Distance Between Parallel Sides: Cold finished, suitable for machining on high speed automatic screw machines.
- 3.2.2 Bars and Mechanical Tubing Over 2.50 In. (63.5 mm) in OD or Distance Between Parallel Sides: Hot finished and normalized or otherwise heat treated to produce best machining qualities.
- 3.2.3 Forgings: Normalized or otherwise heat treated to produce best machining qualities.
- 3.2.4 Forging Stock: As ordered by the forging manufacturer.

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

3.3.1 Hardness: Shall be as follows or equivalent, determined in accordance with ASTM E10 on the surface except on rounds, where a flat as necessary for Brinell accuracy may be made.

3.3.1.1 Bars:

∅	Nominal Diameter or Distance Between Parallel Sides		Brinell Hardness	
	Inches	(Millimetres)	min	max
	Up to 1.00, excl	(Up to 25.4, excl)	156	207
	1.00 to 2.50, incl	(25.4 to 63.5, incl)	143	207
	Over 2.50	(Over 63.5)	--	179

3.3.1.2 Tubing:

∅	Nominal OD		Brinell Hardness	
	Inches	(Millimetres)	min	max
	Up to 1.00, excl	(Up to 25.4, excl)	156	250
	1.00 to 2.50, incl	(25.4 to 63.5, incl)	143	250
	Over 2.50	(Over 63.5)	--	179

∅ 3.3.1.3 Forgings: Not higher than 179 HB.

3.4 Quality: The product shall be uniform in quality and condition, clean, sound, and free from foreign materials and, consistent with the type of steel involved, from internal and external imperfections detrimental to fabrication or to performance of parts.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, bars and tubing will be acceptable in mill lengths of 6 - 20 ft (1.8 - 6.1 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of the following:

Ø 3.6.1 Bars: AMS 2231.

3.6.2 Mechanical Tubing: AMS 2253.

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 assure 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 or routine control tests.

Ø 4.3 Sampling: Shall be in accordance with the following:

Ø 4.3.1 Bars and Mechanical Tubing: AMS 2370.

Ø 4.3.2 Forgings and Forging Stock: AMS 2372.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment three copies of a report stating that the chemical composition and hardness conform to the requirements of this specification. This report shall include the purchase order number, material specification number and its revision letter, size, and quantity. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.

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.

Ø 4.5 Resampling and Retesting: Shall be in accordance with the following:

Ø 4.5.1 Bars and Mechanical Tubing: AMS 2370.

Ø 4.5.2 Forgings and Forging Stock: AMS 2372.

5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as follows:

5.1.1 Bars and Tubing: Individual pieces or bundles shall have attached a durable tag marked with the purchase order number, AMS 5022H, and nominal size or shall be boxed and the box marked with the same information.

5.1.2 Forgings: In accordance with AMS 2808.

5.1.3 Forging Stock: As agreed upon by purchaser and vendor.