



400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE MATERIAL SPECIFICATION

SAE AMS-4214

REV
GIssued 1941-09-01
Revised 1991-01-01

Superseding AMS-4214F

Submitted for recognition as an American National Standard

CASTINGS, ALUMINUM ALLOY SAND
5.0Si - 1.2Cu - 0.50Mg (355.0-T71)
Solution Heat Treated and Stabilized

UNS A03550

1. SCOPE:

1.1 Form: This specification covers an aluminum alloy in the form of sand castings.

1.2 Application: Primarily for components requiring strength up to 450°F (232°C).

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

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

2.1.1 Aerospace Material Specifications:

- AMS-2360 - Room Temperature Tensile Properties of Castings
- AMS-2635 - Radiographic Inspection
- AMS-2645 - Fluorescent Penetrant Inspection
- AMS-2646 - Contrast Dye Penetrant Inspection
- AMS-2694 - Repair Welding of Aerospace Castings
- AMS-2771 - Heat Treatment of Aluminum Alloy Castings
- AMS-2804 - Identification, Castings

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SAE AMS-4214 Revision G

2.2 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM B 557 - Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products

ASTM B 557M - Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products (Metric)

ASTM B 660 - Packaging/Packing of Aluminum and Magnesium Products

ASTM E 10 - Brinell Hardness of Metallic Materials

ASTM E 34 - Chemical Analysis of Aluminum and Aluminum Alloys

ASTM E 155 - Reference Radiographs for Inspection of Aluminum and Magnesium Castings

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight,

Ø determined by wet chemical methods in accordance with ASTM E 34, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Silicon	4.5	5.5
Copper	1.0	1.5
Magnesium	0.40	0.6
Iron (3.1.1)	--	0.6
Manganese (3.1.1)	--	0.50
Zinc	--	0.35
Titanium	--	0.25
Chromium	--	0.25
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

3.1.1 If iron content exceeds 0.45%, manganese content shall be not less than one-half the iron content.

3.2 Condition: Solution heat treated and stabilized.

3.3 Casting: Castings shall be produced in lots from metal conforming to 3.1. Metal remelted from previously analyzed ingot may be poured directly into castings. Furnace or ladle additions of grain-refining elements or alloys are permissible. Molten metal taken from alloying furnaces, with or without additions of foundry operating scrap (gates, sprues, risers, and rejected castings), shall not be poured into castings unless first converted to ingot, analyzed, and remelted or unless the composition of a sample taken after the last addition to the melt conforms to 3.1.

3.3.1 A melt shall be the metal withdrawn from a batch-furnace charge of 2000 pounds (907 kg) or less as melted for pouring castings or, when permitted by purchaser, a melt shall be 4000 pounds (1814 kg) or less of metal withdrawn from one continuous furnace in not more than eight consecutive hours.

SAE AMS-4214 Revision G

3.3.2 A lot shall be all castings poured from a single melt in not more than eight consecutive hours and solution heat treated and stabilized in the same heat treat batch.

3.4 Cast Test Specimens: Chemical analysis specimens and tensile specimens shall be cast as follows and, when requested, shall be supplied with the castings:

3.4.1 Chemical Analysis Specimens: Shall be cast from each melt and shall be of \emptyset any convenient size, shape, and form.

3.4.2 Tensile Specimens: Shall be cast with each lot of castings, shall be of standard proportions conforming to ASTM B 557 or ASTM B 557M with 0.500 inch (12.70 mm) diameter at the reduced parallel gage section, and shall be cast to size in molds made of the regular foundry mix of sand, without using chills. Metal for the specimens shall be part of the melt which is used for the castings. If the metal for castings is given any treatment, such as fluxing or cooling and reheating, the metal for the specimens shall be a portion of the metal so treated and, during such treatment, shall be heated to the same maximum temperature and held for approximately the same time as the molten metal for the castings. The temperature of the metal during pouring of the specimens shall be not lower than that during pouring of the castings.

3.5 Heat Treatment: Castings and representative tensile specimens shall be solution heat treated in accordance with AMS-2771 and stabilized by heating to $475^{\circ}\text{F} \pm 10$ ($246^{\circ}\text{C} \pm 6$), holding at heat for 4 - 6 hours, and cooling in air; at least one set of specimens shall, during each stage of heat treatment, be put into a batch-type furnace with each load of castings or into a continuous furnace at intervals of not longer than three hours.

3.6 Properties: Castings and representative tensile specimens produced in accordance with 3.4.2 shall conform to the following requirements:

3.6.1 Tensile Properties: Shall be as follows, determined in accordance with ASTM B 557 or ASTM B 557M; conformance to the requirements of 3.6.1.1 shall be used as basis for acceptance of castings except when purchaser specifies that the requirements of 3.6.1.2 apply:

3.6.1.1 Separately Cast Specimens:

Tensile Strength, minimum	30,000 psi (207 MPa)
Yield Strength at 0.2% Offset, minimum	22,000 psi (152 MPa)
Elongation in 4D, minimum	1.0%

3.6.1.2 Specimens Cut from Castings: Specimens as in 4.3.4 shall meet the following requirements:

Tensile Strength, minimum	22,500 psi (155 MPa)
Elongation in 4D, minimum	0.25%

SAE AMS-4214 Revision G

3.6.1.2.1 When properties other than those of 3.6.1.2 are required, tensile specimens as in 4.3.4 taken from locations indicated on the drawing, from a casting or castings chosen at random to represent the lot, shall have the properties indicated on the drawing for such specimens. Property requirements may be designated in accordance with AMS-2360.

3.6.2 Hardness of Castings: Castings, except at gate and riser locations, should have hardness of 65 - 86 HB/10/500 or 70 - 92 HB/10/1000, determined in accordance with ASTM E 10, but castings shall not be rejected on the basis of hardness if the tensile property requirements of 3.6.1.2 are met.

3.7 Quality:

3.7.1 Castings, 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 castings.

3.7.1.1 Castings shall have smooth surfaces and shall be well cleaned.

3.7.2 Castings shall be produced under radiographic control. This control shall consist of radiographic examination of castings in accordance with AMS-2635 until proper foundry technique, which will produce castings free from harmful internal imperfections is established for each part number and of production castings as necessary to ensure maintenance of satisfactory quality.

3.7.3 When specified, castings shall be subjected to fluorescent penetrant inspection in accordance with AMS-2645, to contrast dye penetrant inspection in accordance with AMS-2646, or to both.

3.7.4 Radiographic, fluorescent penetrant and/or contrast dye penetrant when specified, and other quality standards shall be as agreed upon by purchaser and vendor. ASTM E 155 may be used to define radiographic acceptance standards.

3.7.5 Castings shall not be repaired by peening, plugging, welding, or other methods without written permission from purchaser.

3.7.5.1 When permitted in writing by purchaser, defects in castings resultant from the casting process may be removed and the castings reworked by welding in accordance with AMS-2694.

3.7.6 Castings shall not be impregnated, chemically treated, or coated to prevent leakage unless specified or allowed by written permission of purchaser, designating the method to be used.

SAE AMS-4214 Revision G

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of castings shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the castings conform to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Except as specified in 4.2.1.1, tests for composition (3.1), tensile properties of separately-cast specimens (3.6.1.1) or, when specified, tensile properties of specimens cut from castings (3.6.1.2), and quality (3.7) are acceptance tests and shall be performed to represent each melt or lot as applicable.

4.2.1.1 Tensile properties of specimens cut from castings shall be determined only when specified by purchaser or when separately-cast specimens are not available. Tensile properties of separately-cast specimens need not be determined when tensile properties of specimens cut from castings are determined.

4.2.2 Periodic Tests: Tests for hardness (3.6.2) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.2.3 Preproduction Tests: Tests for all technical requirements are preproduction tests and shall be performed prior to or on the first-article shipment of a casting to a purchaser, when a change in material and/or processing requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

4.3 Sampling and Testing: Shall be in accordance with the following:

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4.3.1 At least one chemical analysis specimen in accordance with 3.4.1 from each melt and/or a casting from each lot.

4.3.2 One tensile specimen in accordance with 3.4.2 from each lot except when purchaser requires properties of specimens cut from castings.

4.3.3 Two preproduction castings in accordance with 4.4.1 of each part number.

SAE AMS-4214 Revision G

4.3.4 One or more castings from each lot when properties are required from specimens machined from castings. Specimens shall conform to ASTM B 557 or ASTM B 557M and shall be either 0.500 inch (12.70 mm) diameter at the reduced parallel gage section, subsize specimens proportional to the standard, or standard sheet-type specimens. For determining conformance to the requirements of 3.6.1.2, if specimen locations are not shown on the drawing, not less than four tensile specimens, two from the thickest section and two from the thinnest section, shall be cut from a casting or castings from each lot.

4.4 Approval:

4.4.1 Sample castings from new or reworked patterns and the casting procedure shall be approved by purchaser before castings for production use are supplied, unless such approval be waived by purchaser.

4.4.2 Vendor shall establish, for production of sample castings of each part number, parameters for the process control factors which will produce acceptable castings; these shall constitute the approved casting procedure and shall be used for producing production castings. If necessary to make any change in parameters for the process control factors, vendor shall submit for reapproval a statement of the proposed changes in processing and, when requested, test specimens, sample castings, or both. Production castings incorporating the revised operations shall not be shipped prior to receipt of reapproval.

4.4.2.1 Control factors for producing castings include, but are not limited to, the following:

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Type of furnace
Furnace atmosphere
Fluxing or deoxidation procedures
Gating and risering practices
Metal pouring temperature; variation of $\pm 50^{\circ}\text{F}$ ($\pm 28^{\circ}\text{C}$) from the established limit is permissible
Solidification and cooling procedures
Solution and stabilization heat treatment cycles
Cleaning operations
Methods of inspection

4.4.2.1.1 Any of the above process control factors for which parameters are considered proprietary by the vendor may be assigned a code designation. Each variation in such parameters shall be assigned a modified code designation.

4.5 **Reports:** The vendor of castings shall furnish with each shipment a report showing the results of tests for chemical composition of at least one casting or of separately-cast specimens from each melt and the results of tests for tensile properties of separately-cast specimens representing each lot or, when specified, of specimens cut from castings from each lot. This report shall include the purchase order number, lot number, AMS-4214G, part number, and quantity.