

# AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.  
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AMS 4420C

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MAGNESIUM ALLOY CASTINGS Page 1 of 3  
Sand  
6 Al 3 Zn As Cast

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. COMPOSITION:

Aluminum	5.3 - 6.7
Zinc	2.5 - 3.5
Manganese	0.15 min
Silicon	0.30 max
Copper	0.05 max
Nickel	0.01 max
Total Other Impurities	0.30 max
Magnesium	remainder

3. CASTING: (a) All metal which is poured into castings shall conform in composition to Section 2 above. The molten metal shall be subjected to superheating or other grain-refining treatment.

(b) A melt shall be the metal withdrawn from a batch furnace charge of 2,000 pounds or less as melted for pouring castings; or, when permitted by purchaser, a melt may be 3,000 pounds or less of metal withdrawn from one continuous furnace in not more than 4 consecutive hours.

4. TEST BARS AND ANALYTICAL SAMPLES: (a) Unless otherwise specified, tensile test bars as required in ASTM B80-44T and chemical analysis coupons of size and shape as agreed between vendor and purchaser shall be cast with each melt of castings. Test bars and coupons shall be supplied with castings when requested.

(b) Metal for casting tensile test bars and chemical analysis coupons shall be part of the melt used for the castings. Metal for tensile test bars shall be given the same superheating or other grain refining treatment given metal for castings. Tensile test bars shall be cast in molds made with the regular foundry mix of green sand, without using chills; chemical analysis coupons shall be cast in permanent molds.

5. CONDITION: Castings and test bars shall be furnished as cast.

6. PHYSICAL PROPERTIES: (a) Test bars poured as specified in Section 4 shall conform to the following minimum physical properties:

Tensile Strength, psi	24,000
Elongation, % in 2 in.	4
Hardness, Brinell, 500 kg load, 10 mm ball	48

(b) Hardness of castings, except at sprues or risers, shall be not less than Brinell 48, using 500 kg load and 10 mm ball or equivalent, or Brinell 57, using 1000 kg load and 10 mm ball.

(c) If castings are cut for examination, not less than four, and preferably ten, specimens taken from thick and thin sections of castings shall be tested. Average hardness of such specimens shall be as specified in 6 (b) above. Average tensile properties from such specimens shall be not less than the following

Tensile Strength, psi	18,000
Elongation, % in 2 in.	1.0

7. QUALITY: (a) Castings shall be of uniform quality and condition, and free from defects detrimental to fabrication or to performance of the parts. If injurious defects are revealed during fabrication, castings shall be subject to rejection. Castings shall have smooth surfaces and shall be well cleaned.

(b) Unless otherwise specified, castings shall be produced under radiographic control. This shall consist of radiographic examination of castings until proper foundry technique, which will produce castings free from harmful internal defects, is established for each pattern.

(c) Radiographic and other quality standards shall be as agreed between purchaser and vendor.

(d) Castings and parts made therefrom shall be subject to examination by any method which will reveal defects.

(e) Castings shall not be repaired by plugging, welding or other methods, without written permission from the purchaser.

(f) Castings shall not be impregnated, chemically treated, or coated to prevent leaking, unless specified or allowed by written permission which states the method to be used. Impregnated castings shall be marked "IMP".

(g) Castings shall be of sufficient size to allow for finishing to drawing requirements, but excessive size or weight will not be permitted.

8. REPORTS: (a) Unless otherwise specified, vendor of castings shall furnish with each shipment three copies of a notarized report showing results of tests made to determine conformance of the castings and test bars to this specification. If accuracy of control is adequate, each melt need not be analyzed but frequency of analysis shall be as agreed between purchaser and vendor.

(b) Unless otherwise specified vendor of finished or semi-finished parts shall furnish with each shipment three copies of a notarized report showing purchase order number, material specification number, contractor or other direct supplier of castings, part number, and quantity. When castings for making parts are produced or purchased by the parts vendor, that vendor shall inspect each lot of castings to determine conformance to the requirements of this specification, and shall include in the report a certification that the castings conform, or shall include copies of laboratory reports showing results of tests made to determine conformance.

9. IDENTIFICATION: Castings shall be identified in accordance with AMS 2804.