



Standard Specification for Sintered Aluminum Structural Parts¹

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1. Scope

1.1 This specification covers sintered aluminum structural parts made primarily from aluminum powders to which controlled amounts of master alloys or elemental copper, magnesium, and silicon have been added by blending.

1.2 This specification covers the following variables:

1.2.1 *Composition*—Depending upon levels of copper, magnesium, and silicon content, two grades, and

1.2.2 *Density*—Type.

1.3 Parts ordered to this specification will be in one of the following conditions:

1.3.1 As-sintered,

1.3.2 As-repressed for additional density, or

1.3.3 All other conditions plus heat treated.

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 *ASTM Standards*:

B 243 Terminology of Powder Metallurgy²

B 328 Test Method for Density, Oil Content, and Interconnected Porosity of Sintered Metal Structural Parts and Oil-Impregnated Bearings²

E 8 Test Methods for Tension Testing of Metallic Materials³

3. Terminology

3.1 *Definitions*—Definitions of powder metallurgy terms can be found in Terminology B 243. Additional descriptive information is available in the Related Material Section of Volume 02.05 of the *Annual Book of ASTM Standards*.

4. Ordering Information

4.1 Orders for material to this specification shall include the following information:

4.1.1 Dimensions (see 9.1),

4.1.2 Chemical composition (see 6.1),

4.1.3 Density (see 7.1),

4.1.4 State of heat treatment,

4.1.5 Mechanical property requirements (see 8.1), and

4.1.6 Certification (see 14.1).

5. Materials and Manufacture

5.1 Structural parts shall be made by molding and sintering metal powders to produce finished parts conforming to the requirements of this specification.

6. Chemical Composition

6.1 The material shall conform to the requirements of Table 1.

6.2 The chemical analysis shall be made in accordance with the methods prescribed in the latest edition of the *Annual Book of ASTM Standards*, Vol 03.05, or any other approved method agreed upon between the manufacturer and the purchaser.

7. Density

7.1 The parts shall conform to the density range prescribed in Table 2.

7.2 The density shall be measured in accordance with Test Method B 328.

7.3 If the density does not vary more than 0.1 g/cm³ from one section of the structural part to any other section, the overall density shall fall within the limits prescribed in Table 2.

7.4 If the density varies more than 0.1 g/cm³ from one section of the structural part to any other section, the manufacturer and the purchaser shall agree upon a critical section of the part where the stresses are the highest. The density of this critical section rather than the average density shall fall within the limits prescribed in Table 2.

8. Mechanical Properties

8.1 The manufacturer and the purchaser shall agree on qualification tests for the determination of mechanical properties.

8.2 These tests shall be performed on production parts.

8.3 These tests shall be determined after consideration of the function of the part.

8.4 The limits and sampling plan shall be agreed upon between the manufacturer and purchaser.

8.5 All shipments of parts subsequent to the establishment

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² *Annual Book of ASTM Standards*, Vol 02.05.

³ *Annual Book of ASTM Standards*, Vol 03.01.



TABLE 1 Chemical Requirements

Element	Composition, %	
	AXX-6061 ^A	ACXX-2014 ^A
Copper	0.5 max	3.5–5.0
Magnesium	0.4–1.2	0.2–0.8
Silicon	0.2–0.8	1.2 max
Aluminum, min	96.0	91.5
Total of other elements, determined by difference, max	1.5	1.5

^A An “XX” denotes position of thermal condition designation.

TABLE 2 Density

Type	Dry Density, g/cm ³
I	2.30 to 2.45
II	2.45 to 2.60
III	2.60 min

of testing conditions shall conform to the limits agreed upon.

NOTE 1—The mechanical properties in tension and compression that may be expected from standard specimens molded to size are given in Appendix X1 of this specification.

9. Dimensions and Tolerances

9.1 Permissible variations in dimensions shall be within the limits specified on the drawings describing the structural parts accompanying the order or shall be within the limits specified in the order.

10. Workmanship, Finish, and Appearance

10.1 Structural parts shall be uniform in composition.

10.2 When parts are cut or fractured, the exposed surface shall be of uniform appearance.

11. Sampling

11.1 *Lot*—Unless otherwise specified, a lot shall consist of parts of the same form and dimensions made from powders of the same composition molded and sintered under the same conditions and submitted for inspection at one time.

11.2 *Chemical Analysis*—If required by purchase agreement, at least one sample for chemical analysis shall be taken

from each lot. A representative sample of chips may be obtained by dry milling, drilling or crushing at least two pieces with clean dry tools without lubrication. In order to obtain oil-free chips, the parts selected for test shall have the oil extracted in accordance with Test Method B 328, if necessary.

11.3 *Mechanical Tests*—The manufacturer and purchaser shall agree on a representative number of specimens for mechanical tests.

12. Inspection

12.1 Unless otherwise specified, inspection of parts supplied on contract shall be made by the purchaser.

13. Rejection and Rehearing

13.1 Parts that fail to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with test results, the producer or supplier may make claim for rehearing.

14. Certification

14.1 When specified in the purchase order or contract, a producer’s certification shall be furnished to the purchaser that the parts were manufactured, sampled, tested, and inspected in accordance with this specification and have been found to meet the requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

14.2 The purchase order shall specify whether or not the certification includes chemistry.

14.3 Upon request of the purchaser in the contract or order, the certification of an independent third party indicating conformance to the requirements of this specification may be considered.

15. Keywords

15.1 as-repressed; as-sintered; density; interconnected porosity; oil-impregnated; powder metallurgy; sintered aluminum; structural parts; thermal condition

APPENDIX

(Nonmandatory Information)

X1. MECHANICAL PROPERTIES AND HARDNESS DATA

X1.1 Data for the mechanical properties of sintered aluminum specimens are given in Table X1.1. The data do not constitute a part of this specification. They merely indicate to the purchaser the mechanical properties that may be expected from special tension specimens conforming to the density and

chemical requirements specified. It should be understood that the values represent specimens molded to size and not specimens cut from commercial parts. See Fig. 20 of Test Methods E 8.

TABLE X1.1 Typical Properties^A

Material Designation Code ^B	Type	Ultimate Tensile Strength		Tensile Yield Strength (0.2 % offset)		Elongation in 25 mm or 1 in., %	Apparent Rockwell Hardness
		MPa	psi	MPa	psi		
AT1-6061	I	83	12 000	62	9 000	4.0	60–65 HRH
AT4-6061	I	97	14 000	79	11 500	3.5	65–70 HRH
AT6-6061	I	138	20 000	131	19 000	0.5	80–85 HRH
AT1-6061	II	128	18 500	69	10 000	6.0	80–85 HRH
AT4-6061	II	159	23 000	103	15 000	5.0	50–55 HRE
AT6-6061	II	207	30 000	193	28 000	2.0	65–70 HRE
ACT1-2014	I	138	20 000	97	14 000	2.0	80–85 HRH
ACT4-2014	I	165	24 000	145	21 000	2.0	55–60 HRE
ACT6-2014	I	207	30 000	172	25 000	0.5	65–70 HRE
ACT1-2014	II	152	22 000	117	17 000	3.0	85–90 HRH
ACT4-2014	II	179	26 000	152	22 000	2.5	55–60 HRE
ACT6-2014	II	241	35 000	228	33 000	1.0	70–75 HRE
ACT1-2014	III	172	25 000	152	22 000	3.0	55–60 HRE
ACT4-2014	III	221	32 000	179	26 000	2.5	70–75 HRE
ACT6-2014	III	290	42 000	279	40 000	2.0	80–85 HRE

^A Typical sintering atmosphere for the above grades may be nitrogen, dissociated ammonia, or vacuum.

^B Description of Thermal Conditions:

T1 as-sintered.

T4 solution heat treated at (505 to 520°C) 940 to 970°F, cold water quenched and aged minimum of 4 days at room temperature.

T6 solution heat treated at (505 to 520°C) 940 to 970°F, cold water quenched and aged 18 h at (160 to 175°C) 320 to 350°F.

X1.2 Hardness values are given as apparent values, as described in General Description of Production, Properties, and Uses of Metal Powder Sintered Bearings, and Sintered Metal Powder Structural Parts (see gray pages).

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