

AEROSPACE

MATERIAL SPECIFICATIONS

AMS4127C

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

485 Lexington Ave., New York, N. Y. 10017

Issued 5-1-54
Revised 3-15-66

ALUMINUM ALLOY FORGINGS

1. 0Mg - 0.60Si - 0.30Cu - 0.20Cr (6061-T6)

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. **FORM:** Die forgings, rolled rings, and forging stock.
3. **COMPOSITION:**

	min	max
Ø		
Magnesium	0.8	1.2
Silicon	0.40	0.8
Copper	0.15	0.40
Chromium	0.04	0.35
Iron	--	0.7
Zinc	--	0.25
Manganese	--	0.15
Titanium	--	0.15
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

4. **CONDITION:**

- 4.1 **Die Forgings and Rolled Rings:** Solution and precipitation heat treated. Quenching from the solution temperature shall be at a rate fast enough for the material to meet the following requirements, but shall be as slow as practicable in order to keep internal stresses at a minimum.
- 4.2 **Forging Stock:** As fabricated.

5. **TECHNICAL REQUIREMENTS:**

- 5.1 **Die Forgings and Rolled Rings:**

- 5.1.1 **Tensile Properties:**

- 5.1.1.1 **Test Specimens:** Test specimens, machined from separately forged coupons or from forging stock representing the forgings and in either case heat treated with the forgings, or machined from prolongations on heat treated die forgings, shall conform to the following requirements:

Tensile Strength, psi	38,000 min
Yield Strength at 0.2% Offset or at 0.0111 in. in 2 in. Extension Under Load (E = 9,900,000), psi	35,000 min
Elongation, % in 4D	10 min

Section 8.3 of the SAE Technical Board rules provides that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no obligation 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 applying 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."

- 5.1.1.2 Die Forgings, With Grain Flow: When test specimens are machined from forgings not over 4 in. in thickness with the axis approximately parallel to the forging flow lines, the tensile properties shall conform to those specified in 5.1.1.1, except that elongation may be as low as 7%, unless otherwise agreed upon by purchaser and vendor.
- 5.1.1.3 Die Forgings, Across Grain Flow: When test specimens are machined from die forgings not over 4 in. in thickness so that the axis is other than approximately parallel to the forging flow lines, the tensile properties shall conform to those specified in 5.1.1, except that elongation may be as low as 5%, unless otherwise agreed upon by purchaser and vendor.
- 5.1.1.4 Rolled Rings, Tangential: When test specimens are machined from rolled rings not over 2-1/2 in. in thickness with axis tangential to ring OD (axis parallel to direction of rolling), the tensile properties shall conform to those specified in 5.1.1.1, unless otherwise agreed upon by purchaser and vendor.
- 5.1.1.5 Rolled Rings, Axial: When test specimens are machined from rolled rings not over 2-1/2 in. in thickness with axis parallel to axis of ring (axis transverse to direction of rolling), the tensile properties shall conform to those specified in 5.1.1.1, except that elongation may be as low as 8%, unless otherwise agreed upon by purchaser and vendor.
- 5.1.2 Hardness: Forgings shall have hardness not lower than Brinell 80 using 500 kg load and 10 mm ball or 1000 kg load and 9/16 in. ball, or not lower than Brinell 85 using 1000 kg load and 10 mm ball.
- 5.2 Forging Stock:
- 5.2.1 When a sample of stock is forged to a test coupon and heat treated in the same manner as forgings, a tensile test specimen taken from the heat treated coupon shall have properties not lower than those specified in 5.1.1.1 and 5.1.2. If a test specimen taken from the stock after heat treatment in the same manner as forgings has properties not lower than those specified in 5.1.1.1 and 5.1.2, the test shall be accepted as equivalent to the test of a forged coupon. Neither of these tests is required in routine inspection.
- 5.2.2 Unless otherwise specified, tolerances shall conform to all applicable requirements of the latest issue of AMS 2201.
6. QUALITY: Material shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.
7. REPORTS:
- 7.1 Unless otherwise specified, the vendor of forgings shall furnish with each shipment three copies of a report stating that the forgings conform to the chemical composition and technical requirements of this specification. This report shall include the purchase order number, material specification number, size or part number, and quantity.
- 7.2 Unless otherwise specified, the vendor of forging stock shall furnish with each shipment three copies of a report stating that the chemical composition of the stock conforms to the requirements specified. This report shall include the purchase order number, material specification number, size, and quantity.
- 7.3 Unless otherwise specified, 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, 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.