



Designation: B686/B686M – 18

Standard Specification for Aluminum Alloy Castings, High-Strength¹

This standard is issued under the fixed designation B686/B686M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers aluminum-alloy high-strength castings designated as shown in [Table 1](#).

1.2 Castings covered by this specification are intended for use in airframe, missile, and other critical applications where high strength, ductility, and sound castings are required.

1.3 Alloy and temper designations are in accordance with ANSI H35.1/H35.1 (M).

1.4 Unless the order specifies the “M” specification designation, the material shall be furnished to the inch-pound units.

1.5 For acceptance criteria for inclusion of new aluminum and aluminum alloys and their properties in this specification, see [Annex A1](#) and [Annex A2](#).

1.6 *Units*—The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.7 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.8 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 The following documents of the issue in effect on the date of purchase form a part of this specification to the extent referenced herein:

2.2 ASTM Standards:²

- [B179 Specification for Aluminum Alloys in Ingot and Molten Forms for Castings from All Casting Processes](#)
- [B275 Practice for Codification of Certain Zinc, Tin and Lead Die Castings \(Withdrawn 2020\)³](#)
- [B557 Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products](#)
- [B557M Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products \(Metric\)](#)
- [B660 Practices for Packaging/Packing of Aluminum and Magnesium Products](#)
- [B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products](#)
- [B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products](#)
- [B917/B917M Practice for Heat Treatment of Aluminum-Alloy Castings From All Processes](#)
- [B985 Practice for Sampling Aluminum Ingots, Billets, Castings and Finished or Semi-Finished Wrought Aluminum Products for Compositional Analysis](#)
- [D3951 Practice for Commercial Packaging](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E34 Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys \(Withdrawn 2017\)³](#)
- [E94 Guide for Radiographic Examination Using Industrial Radiographic Film](#)
- [E155 Reference Radiographs for Inspection of Aluminum and Magnesium Castings](#)
- [E165 Practice for Liquid Penetrant Testing for General Industry](#)
- [E607 Test Method for Atomic Emission Spectrometric Analysis Aluminum Alloys by the Point to Plane Technique Nitrogen Atmosphere \(Withdrawn 2011\)³](#)
- [E716 Practices for Sampling and Sample Preparation of Aluminum and Aluminum Alloys for Determination of Chemical Composition by Spark Atomic Emission Spectrometry](#)

¹ This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.01 on Aluminum Alloy Ingots and Castings.

Current edition approved May 15, 2018. Published June 2018. Originally approved in 1981. Last previous edition approved in 2014 as B686/B686M – 14. DOI: 10.1520/B0686_B0686M-18.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard

TABLE 1 Chemical Composition Limits^{A,B,C,D}

Desig. ^G	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Ag	Be	Pb	Zr	FNs	Others ^E		Al. Min.
															Each	Total ^F	
A201.0	0.05	0.10	4.0–5.0	0.20–0.40	0.15–0.35	0.15–0.35	0.40–1.0	0.03	0.10	Rem.
354.0	8.6–9.4	0.20	1.6–2.0	0.10	0.40–0.6	0.10	0.20	0.05	0.15	Rem.
C355.0	4.5–5.5	0.20	1.0–1.5	0.10	0.40–0.6	0.10	0.20	0.05	0.15	Rem.
A356.0	6.5–7.5	0.20	0.20	0.10	0.25–0.45	0.10	0.20	0.05	0.15	Rem.
A357.0	6.5–7.5	0.20	0.20	0.10	0.40–0.7	0.10	0.04–0.20	...	0.04–0.07	0.05	0.15	Rem.

^A When single units are shown, they indicate the maximum amounts permitted.

^B Analysis shall be made for the elements for which limits are shown in this table.

^C The following applies to all specified limits in this table: For purposes of determining conformance to these limits, an observed value or a calculated value obtained from analysis shall be rounded to the nearest unit in the last right-hand place of figures used in expressing the specified limit in accordance with the rounding-off method of Practice E29.

^D In case of discrepancy between the values listed in Table 1 and those listed in the “Designations and Composition Limits for Aluminum Alloys in the Form of Castings and Ingot (known as the ‘Pink Sheets’), the composition limits registered with the Aluminum Association and published in the “Pink Sheets” shall be considered the controlling composition.

^E “Others” includes listed elements for which no specific limit is shown as well as unlisted metallic elements. The producer may analyze samples for trace elements not specified in the specification. However, such analysis is not required and may not cover all metallic “Others” elements. Should any analysis by the producer or the purchaser establish that an “Others” element exceeds the limit of “Each” or that the aggregate of several “Others” elements exceeds the limit of “Total,” the material shall be considered nonconforming.

^F The sum of those “Others” metallic elements 0.010 % or more each, expressed to the second decimal before determining the sum.

^G For a cross reference of current and former alloy designations see the Aluminum Association’s “Designations and Composition Limits for Aluminum Alloys in the Form of Castings and Ingot (known as the ‘Pink Sheets’)”.

[E1251 Test Method for Analysis of Aluminum and Aluminum Alloys by Spark Atomic Emission Spectrometry](#)

[E2422 Digital Reference Images for Inspection of Aluminum Castings](#)

[IEEE/ASTM SI 10 Standard for Use of the International System of Units \(SI\): The Modern Metric System](#)

2.3 *AMS Standard*.⁴

[AMS 2771 Heat Treatment of Aluminum Alloy Castings](#)

2.4 *ANSI Standards*.⁵

[H35.1/H35.1 \(M\)-2006 Alloy and Temper Designation Systems for Aluminum](#)

[Z1.4 Sampling Procedures and Tables for Inspection by Attributes](#)

2.5 *Military Standard*.⁶

[MIL-STD-129 Marking for Shipment and Storage](#)

2.6 *Federal Standard*.⁶

[Fed. Std. No. 123 Marking for Shipment \(Civil Agencies\)](#)

2.7 *Aluminum Associations Standard*⁵

[Designations and Chemical Composition Limits for Aluminum Alloys in the Form of Castings and Ingot \(The Pink Sheets\)](#)

2.8 *Other Standards*.⁷

[CEN EN 14242 Aluminum and Aluminum Alloys—Chemical Analysis—Inductively Coupled Plasma Optical Emission Spectral Analysis](#)

3. Terminology

3.1 *Definitions*—Refer to Terminology B881 for definitions of product terms used in this specification.

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

⁵ Available from Aluminum Association, Inc., 1400 Crystal Drive Suite 430 Arlington, VA 22202, <http://www.aluminum.org>.

⁶ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://dodssp.daps.dla.mil>.

⁷ Available from European Committee for Standardization (CEN), 36 Rue de Stassart, B-1050, Brussels, Belgium, <http://www.cenorm.be>.

4. Classification

4.1 Castings shall be classified by inspection classes.

4.1.1 *Classes (Inspection)*:

4.1.1.1 *Class 1*—A class of casting, the single failure of which would result in the loss of a missile, aircraft, or other vehicle.

4.1.1.2 *Class 2*—Class 1 castings not included in Class 1, the single failure of which would cause significant danger to operating personnel or would result in a significant operational penalty. In the case of missiles, aircraft, and other vehicles, this includes loss of major components, loss of control, unintentional release of inability to release armament stores, or failure of weapon installation components.

4.1.1.3 *Class 3*—Castings having a margin of safety of 200 % or less.

4.1.1.4 *Class 4*—Castings having a margin of safety of greater than 200 %, or for which no stress analysis is required. All target drone castings and aerospace ground support equipment fall in this category, except for such critical parts, the failure of which would make the equipment unsatisfactory and cause the vehicles which they are intended to support to be inoperable.

4.1.2 *Grades (Radiographic Quality)*:

NOTE 1—Caution should be exercised in specifying the grade of maximum permissible radiographic discontinuity level to be met in the casting. Radiographic quality has only a qualitative relationship to mechanical properties. In general, the highest property levels of an alloy will require the higher grades of radiographic quality. However, section size and shape parameters may be able to tolerate certain discontinuities without significant reduction in functional integrity. Too severe soundness requirements may cause the part producibility to be impractical or uneconomical.

4.1.2.1 *Grade A*—A grade in which there is no discernible discontinuity visible on the radiograph of the specified area of the casting.

4.1.2.2 *Grade B*—A premium grade of casting for critical applications or specified area of a casting with low margins of safety.

4.1.2.3 *Grade C*—A high-quality grade of casting or area of a casting for general applications.

4.1.2.4 *Grade D*—A grade included for less important areas of a casting.

5. Ordering Information

5.1 Orders for material under this specification shall include the following information:

5.1.1 This specification designation (which includes the number, the year, and the revision letter, if applicable),

NOTE 2—For inch-pound application, specify Specification B686 and for metric application specify Specification B686M. Do not mix units.

5.1.2 Alloy number (Section 7.1 and Table 1), radiographic grade (4.1.2 and Table 2), inspection class of castings (4.1.1 and Table 3 [Table 4]), and class of mechanical properties (Table 5 and [Table 6]),

5.1.3 Tensile property requirements on the drawing or purchase order (9.1.5, 15.4, 15.5, Table 3 [Table 4], and Table 5 [Table 6]),

5.1.4 Identification of product information (Section 11),

5.1.5 Applicable drawings or part number, and

5.1.6 The quantity in either pieces or [kilograms].

5.2 Additionally, orders for material to this specification shall include the following information when required by the purchaser:

5.2.1 Whether heat treatment is to be performed in accordance with AMS 2771 (10.2),

5.2.2 Where the preproduction samples shall be sent, activity responsible for testing, and instructions concerning submittal of the test reports (14.2.1 and 14.2.2),

5.2.3 Penetrant inspection standards (15.2),

5.2.4 Whether Practices B660 apply and, if so, the levels of preservation, packaging, and packing required (17.4),

5.2.5 Whether marking in accordance with Fed. Std. No. 123, Practice D3951, or MIL-STD-129 applies (17.4), and

5.2.6 Whether certification is required (Section 18).

6. Materials and Manufacture

6.1 The responsibility of furnishing castings that can be laid out and machined to the finished dimensions within the permissible variations specified, as shown on the blueprints or drawings, shall rest with the producer, except where pattern equipment is furnished by the purchaser and any dimensional discrepancies can be clearly attributed to the pattern equipment as furnished.

6.1.1 Unless otherwise specified, only aluminum alloy conforming to the requirements of Specification B179 or producer's foundry scrap (identified as being made from alloy conforming to Specification B179) shall be used in the remelting furnace from which molten metal is taken for pouring

TABLE 2 Discontinuity-Level Requirements for High-Strength Aluminum Castings—Maximum Permissible in Accordance with (Film Reference Radiographs E155 or Digital Reference Radiographs E2422)

NOTE 1—When two or more types of discontinuities are present within a 2 by 2-in. [50 by 50-mm] area to an extent equal to or not significantly better than the acceptance standards for respective discontinuities, the castings shall be rejected.

NOTE 2—When two or more types of discontinuities are present within a 2 by 2-in. [50 by 50-mm] area and the predominating discontinuity is not significantly better than the acceptance standard, the casting shall be considered borderline.

NOTE 3—Borderline castings shall be reviewed for acceptance or rejection by competent engineering personnel from the manufacturer and purchaser.

NOTE 4—Gas holes, sand spots, and inclusions allowed by this table shall be cause for rejection when closer than twice their maximum dimension to an edge or extremity of a casting.

NOTE 5—Castings with the following characteristics apply to Alloy A201.1 only:

1. Banding or striated segregation shall be acceptable to the extent that the mechanical properties in the affected section meet the requirements of Table 3.

2. Healed hot tears or discrete segregation cracks, evidenced by linear irregular white lines, shall be rejected.

3. Spheroidal segregation, evidenced by white spheroids, shall be evaluated for size and concentration by using the standards for gas holes.

Discontinuity	Radiograph	Grade A		Grade B		Grade C		Grade D	
		Section Thickness, in.							
		1/4 [6 mm]	3/4 [19 mm]	1/4 [6 mm]	3/4 [19 mm]	1/4 [6 mm]	3/4 [19 mm]	1/4 [6 mm]	3/4 [19 mm]
Gas holes	1.1	none		1	1	2	2	5	5
Gas porosity (round)	1.21	none		1	1	3	3	7	7
Gas porosity (elongated)	1.22	none		1	1	3	4	5	5
Shrinkage cavity	2.1	none		1	^A	2	^A	3	^A
Shrinkage porosity or sponge	2.2	none		1	1	2	2	4	3
Foreign material (less dense material)	3.11	none		1	1	2	2	4	4
Foreign material (more dense material)	3.12	none		1	1	2	1	4	3
Segregation	none		none		none		none	
Cracks	none		none		none		none	
Cold shuts	none		none		none		none	
Laps	none		none		none		none	
Surface irregularity			not to exceed drawing tolerance					
Core shift			not to exceed drawing tolerance					

^A Not available. Use 1/4 in. [6 mm] for all section thicknesses.

TABLE 3 Mechanical Properties of Specimens^A Cut from Designated Areas of Casting^B (Inch-Pound Units)

Desig. ^E	Class Number	Tensile Strength, min, ksi	Yield Strength, 0.2 % Offset, min, ksi	Elongation in 2 in. or 4D, min, %
A201.0 ^C	1	60.0	50.0	3
	2 ^D	60.0	50.0	5
354.0	1	647.0	36.0	3
	2 ^D	50.0	42.0	2
C355.0	1	41.0	31.0	3
	2	44.0	33.0	3
	3 ^D	50.0	40.0	2
A356.0	1	38.0	28.0	5
	2	40.0	30.0	3
	3 ^D	45.0	34.0	3
A357.0	1	45.0	35.0	3
	2 ^D	50.0	40.0	5

^A For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi, and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E29.

^B For any casting process utilized, special mold, or sand mold permanent mold with chills may be used. Properties in other areas may vary with mold process and foundry techniques used but will be inspected under foundry control (0.1.2). Special negotiated properties may be called for by the drawing note.

^C Alloy A201.0 is intended for use in the –T7 temper, which provides a high level of resistance to stress-corrosion cracking when properly heat treated. In other tempers, alloy A201.0 may exhibit susceptibility to stress-corrosion cracking. Additionally, its tendency for hot shortness may make alloy A201.0 unsuitable in some casting designs.

^D This class is obtainable in favorable casting configurations and must be negotiated with the foundry for particular configuration desired. See Note 1 and 8.3.

^E ASTM alloy designations are in Practice B275.

directly into castings. Additions of small amounts of modifiers and grain refining elements or alloys are permitted.

6.1.2 Pure materials, recycled materials, and master alloys may be used to make alloys conforming to this specification, provided chemical analysis can be taken and adjusted to conform to Table 1 prior to pouring any castings.

7. Chemical Composition and Sampling

7.1 The product shall conform to the chemical composition limits prescribed in Table 1. Conformance shall be determined by the producer by taking samples at the time castings are poured in accordance with Practices E716 and analyzed in accordance with Test Methods E34, E607, or E1251, or CEN EN 14242. If the producer has determined the composition of the material during casting, they shall not be required to sample and analyze the finished product.

7.1.1 A sample for determining of chemical composition shall be taken to represent the following:

7.1.1.1 Not more than 2000 lb [1000 kg] of clean castings (gates and risers removed) or a single casting poured from one furnace.

7.1.1.2 Castings poured continuously from one furnace for not more than eight consecutive hours.

7.2 If it becomes necessary to analyze castings for conformance to chemical composition limits, the method used to sample castings for the determination of chemical composition shall be in accordance with Practice B985. Analysis shall be performed in accordance with Practices E716, Test Methods E34, E607, or E1251, or CEN EN 14242 (ICP method).

8. Preproduction Sample

8.1 In advance of production, unless otherwise specified in the contract or order, two castings heat treated and straightened to drawing requirements shall be submitted as directed by the purchaser for examination and written approval. One casting shall be completely laid out by the foundry and identified as the “dimensional sample” for dimensional approval. The other casting shall be identified as the “foundry control sample” and shall be for all other inspections and requirements as necessary for approval.

8.2 The submitted castings shall be fully representative of the foundry practice that will be used in production. If temporary gating was used to develop suitable foundry practice, the submitted casting shall be made after the gating has been installed. If chills are required, their size and location shall also be permanently identified and recorded. Pouring temperature of the submitted casting shall be recorded. All details of manufacture and processing shall be recorded and documented by photographs, sketches, specifications, and manufacturing procedures.

8.3 The user of this specification is specifically cautioned to verify the capability of the foundry to competently produce parts to the specification. On-site survey should be performed to verify the producers’ technical, manufacturing, and quality control capabilities. Verification of properties of sample test parts is suggested. The ability to produce guaranteed property castings requires technical knowledge, foundry technique, and vigorous controls uncommon to conventional foundries.

TABLE 4 Mechanical Properties of Specimens^A Cut from Designated Areas of Casting^B (SI Units) [Metric]^C

Desig. ^F	Class Number	Tensile Strength, min, MPa	Yield Strength, 0.2 % Offset, min, MPa	Elongation in 5D, min, %
A201.0 ^D	1	415	345	3
	2 ^E	415	345	5
354.0	1	325	250	3
	2 ^E	345	290	2
C355.0	1	285	215	3
	2	305	230	3
	3 ^E	345	275	2
A356.0	1	260	195	5
	2	275	205	3
	3 ^E	310	235	3
A357.0	1	310	240	3
	2 ^E	345	275	5

^A For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 1 MPa, and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E29.

^B For any casting process utilized, special mold or sand mold, or permanent mold, with chills may be used. Properties in other areas may vary with mold process and foundry techniques used but will be inspected under foundry control (8.3). Special negotiated properties may be called for by the drawing note.

^C Guidelines for metric conversion from the *Tempers for Aluminum and Aluminum Alloys, Metric Edition (Tan Sheets)* were used to convert the tensile and yield values to SI units. Section 15.4 and 15.5.3 state that the “coupons must meet the tensile property requirements specified,” therefore there has been no reduction in elongation values during metric conversion.⁸

^D Alloy A201.0 is intended for use in the –T7 temper, which provides a high level of resistance to stress-corrosion cracking when properly heat treated. In other tempers, alloy A201.0 may exhibit susceptibility to stress-corrosion cracking. Additionally, its tendency for hot shortness may make alloy A201.0 unsuitable in some casting designs.

^E This class is obtainable in favorable casting configurations and must be negotiated with the foundry for particular configuration desired. See Note 1 and 8.3.

^F ASTM alloy designations are in Practice B275.

9. Radiographic Soundness and Mechanical Property Control

9.1 Prior to production, radiographic and mechanical property control shall be established. Castings shall be examined by radiographic methods for internal discontinuities. Sectioning and etching may be performed to determine the presence of internal discontinuities. Full-size casting or tension specimens machined from castings shall be tested for conformance to the required mechanical properties. This control shall be continued until the gating and other foundry practices have been established to produce castings conforming to this specification.

9.1.1 *Radiographic Requirements*—After the foundry control methods have been established as specified in 8.1, 8.2, and 8.3, castings shall be radiographically inspected as specified in 15.1. Unless otherwise specified in the contract or order, acceptance shall be by comparison with a standard set of radiographs contained in Reference Radiograph E155. Unless otherwise specified, radiographic indications shall be identified in terms of the discontinuities listed in Table 2. Unless otherwise specified, acceptance shall be made in accordance with one of four grades specified on the engineering drawing (4.1.2). When no grade is specified, Grade C shall apply. When a drawing specifies “critical” area and indicates no grade, Grade B shall apply to that area and Grade C to the remainder of the casting.

9.1.1.1 Acceptability is indicated in Table 2 by the indexed number of the E155 radiograph which is acceptable for the applicable grade. To be acceptable to the applicable grade, a casting must be acceptable for all discontinuities listed in Table 2. Nonconformance with the applicable standard for any single discontinuity shall make a casting nonacceptable.

9.1.2 *Acceptance Procedure*—The radiographs shall be reviewed to determine conformance to Table 2. Unless otherwise noted, mechanical property test coupons shall be located in relation to the radiographs and high- and low-stress areas of the casting. Mechanical properties tests shall be made to assure conformance to this specification. Mechanical property test coupons sectioned through areas of discrete allowable radiographic soundness discontinuities should be tested for information only and shall not be cause for rejection of the casting or lot except when the test coupon includes a significant portion of the total cast section.

9.1.3 *Foundry Control Approval*—Production of a given casting shall not begin until the foundry control is approved, unless such approval is waived in writing by the purchaser.

9.1.4 *Manufacturing Changes*—The manufacturer shall use the same foundry practices and the same heat-treating procedures for production castings as for approved sample castings. If necessary to make any change, the foundry shall notify the purchaser prior to the first shipment of castings incorporating

TABLE 5 Mechanical Properties of Specimens^A Cut from Any Area of Casting^B (Inch-Pound Units)

Desig. ^E	Class of Mechanical Property (see 5.1.2) ^C	Tensile Strength, min, ksi	Yield Strength, 0.2 % Offset, min, ksi ^C	Elongation in 2 in. or 4, min, %
A201.0 ^D	10	60.0	50.0	3
	11	56.0	48.0	1.5
354.0	10	47.0	36.0	3
	11	43.0	33.0	2
C355.0	10	41.0	31.0	3
	11	37.0	30.0	1
	12	35.0	28.0	1
A356.0	10	38.0	28.0	5
	11	33.0	27.0	3
	12	32.0	22.0	2
A357.0	10	38.0	28.0	5
	11	41.0	31.0	3

^A For any casting process utilized, special mold or sand mold, or permanent mold, with chills may be used. Properties in other areas may vary with mold process and foundry techniques used but will be inspected under foundry control (8.3). Special negotiated properties may be called for by the drawing note.

^B For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi, and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E29.

^C For any alloy, yield strength will be reasonably consistent throughout the casting. This should be considered when selecting combinations of classes from Table 3 and Table 5. See Note 1 and 8.3.

^D Alloy A201.0 is intended for use in the –T7 temper, which provides a high level of resistance to stress-corrosion cracking when properly heat treated. In other tempers, alloy A201.0 may exhibit susceptibility to stress-corrosion cracking. Additionally, its tendency for hot shortness may make alloy A201.0 unsuitable in some casting designs.

^E ASTM alloy designations are in Practice B275.

such a change, and shall submit sample castings produced by the changed procedure for approval in accordance with Section 9. A sample casting may be required by the purchaser to assure that any of the following change(s) do not adversely affect the quality of the casting:

- 9.1.4.1 When a new pattern or permanent mold is used,
- 9.1.4.2 For each new pattern or cavity in multiple tooling,
- 9.1.4.3 When a duplicate pattern or mold is to be used,
- 9.1.4.4 When any change is made in gates, risers, or chills,
- 9.1.4.5 When any change in the “as-cast” shape is made,
- 9.1.4.6 When strength requirements are raised,
- 9.1.4.7 When an old pattern is transferred to a new vendor,
- 9.1.4.8 When another alloy is used, or
- 9.1.4.9 When melting or processing techniques are changed.

9.1.5 *Tensile Properties*—The mechanical properties of test specimens, taken as specified in 9.1.2, shall conform to the requirements of Table 3 [Table 4] or Table 5 [Table 6]. The strength requirement of the casting tested in full size shall be as agreed upon between the foundry and the purchaser.

10. Heat Treatment

10.1 Heat treatment shall be performed in accordance with Practice B917/B917M.

10.2 When specified, heat treatment shall be in accordance with AMS 2771.

11. Identification of Product

11.1 Where practicable, or unless otherwise specified in the contract or order, each casting shall be identified with the part

number and the serial number by the use of raised numbers in a location indicated on the drawing. When no location is shown on the drawing, the numbers shall be so located as not to be machined off in finishing to the required dimensions.

11.1.1 Castings on which it is impractical to provide raised numerals shall be marked in accordance with the purchaser’s requirements.

12. Dimensions

12.1 The dimensions of the castings shall be within the dimensions and tolerances specified on the applicable drawing.

13. Workmanship, Finish, and Appearance

13.1 Requirements such as surface finish, parting line projections, snagging projections where gates and risers were removed, and so forth, may be checked visually. It is advisable to have agreed upon observational standards representing both acceptable and unacceptable material.

13.1.1 Castings may be repaired only by processes approved and agreed upon between the producer and purchaser; that is, welding, impregnation, chemical treatment or coating to prevent leaking, peening, blending, soldering, and so forth. Limitations on the extent and frequency of such repairs, and methods of inspection of repaired areas should also be agreed upon.

13.1.2 Castings shall not be mechanically straightened after precipitation heat treatment without written permission from the purchaser.