



Designation: B1013 – 20

Standard Specification for High Fluidity (HF) Zinc-Aluminum Alloy Thin Wall Die Castings¹

This standard is issued under the fixed designation B1013; 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 commercial zinc, zinc-aluminum castings and continuous cast bar stock, as designated and specified in [Table 1](#).

1.2 Systems of nomenclature used to designate zinc and zinc-aluminum (ZA) alloys used for casting are described in [Appendix X1](#).

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *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 date of order acceptance form a part of this specification to the extent referenced herein:

2.2 [ASTM Standards](#):²

[B557 Test Methods for Tension Testing Wrought and Cast](#)

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.04 on Zinc and Cadmium.

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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.

[Aluminum- and Magnesium-Alloy Products](#)

[B899 Terminology Relating to Non-ferrous Metals and Alloys](#)

[B949 Specification for General Requirements for Zinc and Zinc Alloy Products](#)

[E8 Test Methods for Tension Testing of Metallic Materials \[Metric\] E0008_E0008M](#)

[E23 Test Methods for Notched Bar Impact Testing of Metallic Materials](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

[E536 Test Methods for Chemical Analysis of Zinc and Zinc Alloys](#)

[2.3 North American Die Casting Association \(NADCA\):³
NADCA Product Specification Standards for Die Castings](#)

[2.4 ISO Standards](#):⁴

[ISO 3815-1 Zinc and zinc alloys — Part 1: Analysis of solid samples by optical emission spectrometry](#)

[ISO 3815-2 Zinc and zinc alloys — Part 2: Analysis by inductively coupled plasma optical emission spectrometry](#)

[2.5 Military Standard](#):⁵

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

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

[MIL-STD-2073-1D Marking for Shipment and Storage \(Military Agencies\)](#)

3. Terminology

3.1 Terms shall be defined in accordance with Terminology [B899](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *die casting, n*—a casting process in which molten metal is injected under high velocity and pressure into a metal

³ Available from North American Die Casting, Assn., 2000 5th Ave., River Grove, IL 60171, <http://www.diecasting.org>.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

TABLE 1 Chemical Requirements

Common Name	HF Alloy ^{A, B, C}
UNS	to be assigned
Element	
Aluminum	4.3–4.7
Magnesium	0.005–0.012
Copper, max	0.035
Iron, max	0.03
Lead, max	0.003
Cadmium, max	0.002
Tin, max	0.001
Zinc ^D	Remainder

^A For purposes of acceptance and rejection, the observed value or calculated value obtained from analysis should 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 procedure prescribed in Practice E29.

^B Zinc alloy castings may contain nickel, chromium, silicon, and manganese in amounts of 0.02, 0.02, 0.035, and 0.06 %, respectively. No harmful effects have ever been noted due to the presence of these elements in these concentrations and, therefore, analyses are not required for these elements.

^C The UNS designations were established in accordance with Practice E527. The last digit of a UNS number differentiates between alloys of similar composition. The UNS designations for ingot and casting versions of an alloy were not assigned in the same sequence for all alloys.

^D Determined arithmetically by difference.

die and solidified, also a product produced by such a process; alternately known as pressure die casting.

3.2.2 *high fluidity alloy, n*—a zinc alloy by nature of its composition is capable of producing die castings with thinner wall sections compared to typical die cast alloys; often less than 0.012 in. (0.30 mm) in thickness.

3.2.3 *thin wall die casting, n*—a die casting with wall sections that can be less than 0.012 in. (0.30 mm) in thickness.

4. Ordering Information

4.1 See Specification B949.

5. Chemical Requirements

5.1 The ingots shall conform to the requirements as to chemical composition as prescribed in Table 1. Conformance shall be determined in accordance with Specification B949.

6. Sampling for Determination of Chemical Composition (see Specification B949)

6.1 When a detailed chemical analysis is required with a shipment, it shall be called for in the contract or purchase order.

6.1.1 If the producer's or supplier's method of composition control is acceptable, sampling for chemical composition may be waived at the discretion of the purchaser.

6.2 *Number of Samples*—When required, samples for determination of chemical composition shall be taken to represent the following:

6.2.1 A sample shall be taken from each of two representative castings selected from each lot defined in 16.2.

6.3 *Methods of Sampling*—See Specification B949.

7. Methods for Chemical Analysis

7.1 The determination of chemical composition shall be made in accordance with Specification B949.

7.2 In case of dispute, the results secured by an approved method (or combination of approved methods), or by a method agreed upon by both parties, shall be the basis of acceptance.

7.2.1 Approved methods include: Test Methods E536, ISO 3815–1, or ISO 3815–2.

7.2.1.1 Test Methods E536 is generally applicable but must be slightly modified to cover the higher Al range. ISO 3815–1 and ISO 3815–2 are generic methods applied to zinc and zinc alloys. Each of the methods may be modified and formatted for the alloy to be assayed. An experienced chemist, using suitable or traceable reference materials, or both, along with valid quality assurance techniques, will be able to perform and validate the methods and demonstrate acceptable precision and accuracy.

7.3 For purposes of determining compliance with specified composition limits as given in Table 1, an observed or calculated value shall be rounded to the nearest unit in the last right-hand place of figures shown in Table 1, in accordance with the rounding method of Practice E29.

8. Physical Properties, Mechanical Properties, and Tests

8.1 Unless specified in the contract or purchase order, or specified on the detail drawing, acceptance of castings under this specification shall not depend on mechanical properties determined by tension or impact tests.

8.1.1 Appendix X2 shows typical mechanical properties, determined on separately cast test bars produced under carefully controlled conditions.

8.1.2 While these typical mechanical properties of separately cast test bars are useful for comparing the relative properties of various casting alloys, they should not be used to establish design limits or acceptance criteria.

8.1.3 If tension or impact tests are made on separately cast test bars, test specimens conforming to the dimensions shown in Test Methods B557 (the figure entitled, Standard Tension Test Specimen for Die Castings), Test Methods E8 (the figure entitled Standard Test Specimen for Cast Iron), and of Test Methods E23 (the figure entitled, Charpy (Simple-Beam) Impact Test Specimens, Types A, B, and C) shall be used, and process operating variables shall be optimized for the specific mold or die being used.

8.1.4 When specified in the contract or purchase order, castings shall withstand proof tests without failure as defined by agreement between the purchaser and the producer or supplier.

8.2 Appendix X3 shows typical physical properties of zinc and zinc-aluminum (ZA) casting alloys and does not constitute a part of this specification but is provided for informational purposes only.

9. Dimensions, Mass, and Permissible Variations

9.1 Permissible variations in dimensions shall be within the limits specified on the drawings or in the contract or purchase order.

9.1.1 For die castings, any dimensions for which a tolerance is not specified shall be in accordance with NADCA Product Specification Standards for Die Castings.