



Designation: B 897 – 99a^{ε1}

Standard Specification for the Configuration of Zinc and Zinc Alloy Jumbo Ingot¹

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^{ε1} NOTE—Section 3. Terminology was added editorially in December 2000.

1. Scope

1.1 This specification covers zinc and zinc alloy cast in jumbo ingot form meeting dimensional requirements.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 The following standards 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:*

B 6 Specification for Zinc²

B 852 Specification for Zinc Alloys (CGG) for Continuous Hot-Dip Galvanizing of Steel Sheet²

B 899 Terminology Relating to Non-ferrous Metals and Alloys²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance With Specifications³

3. Terminology

3.1 Terms shall be defined in accordance with Terminology B 899.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *jumbo ingot, n*—large casting of zinc or zinc alloy designed for handling by mechanical equipment, which also is referred to as a strip jumbo.

4. Ordering Information

4.1 Orders for jumbo ingots under this specification shall include the following information:

4.1.1 This specification number and date,

4.1.2 Quantity (weight),

4.1.3 Name of material and grade, and the

4.1.4 Order may stipulate dimensions, or tolerances, or both, not meeting this specification only upon mutual written agreement between purchaser and producer.

5. Materials and Manufacture

5.1 The producer shall use care to have each lot of zinc metal or zinc alloy jumbo ingots be of as uniform quality as possible.

6. Dimensions, Mass, and Permissible Variations

6.1 Permissible variations in dimensions and tolerances shall be within the limits specified in Table 1 and Fig. 1 unless prior written agreement exists between purchaser and producer for nonstandard dimensions and tolerances.

TABLE 1 Zinc Jumbo Ingot Specification

Weight 2400 ± 100 lbs (1089 ± 45 kg) Table of Dimensions					
Drawing Identification Letter	Dimension Definition	Dimension, in.		Dimension, mm	
		min	max	min	max
A	Top length	48.75	50.25	1238	1276
B	Bottom overall length ^A	46.00	48.00	1168	1219
C	Top width	19.25	20.25	489	514
0.5C	Center of pin hole to length edge	9.63	10.13	245	257
D	Bottom overall width ^A	16.50	18.50	419	470
E	Height ^B	11.75	13.25	298	337
F	Center of pin hole to end edge	5.75	6.75	146	171
G	Height of side fork slots	3.00	4.00	76	102
J	Upper width of side fork slot	5.50	8.00	140	203
K	Lower width of side fork slot	8.00	10.50	203	267
L	Top pin hole diameter	3.00	5.00	76	127
M	Bottom pin hole diameter ^B	4.50	6.50	114	165
N	Bottom center leg width	11.50	15.25	292	387
P	Upper width of end fork slot ^{B,C}	5.50	8.00	140	203
R	Lower width of end fork slot ^C	7.50	10.00	191	254
S	Lower outer leg(s) length	6.50	8.00	165	203
T	Height of end fork slot	3.00	4.00	76	102

^ADimensions with curved corners are measured by placing straight edges on both sides of the curve and using the intersecting point for the reference measurement.

^BMinimum *P* dimension must be greater than the *M* dimension maximum.

^CMinimum *R* dimension must be greater than the *P* dimension maximum.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B 02.04 on Zinc and Cadmium.

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² *Annual Book of ASTM Standards*, Vol 02.04.

³ *Annual Book of ASTM Standards*, Vol 14.02.