



Designation: B 176 – 04

Standard Specification for Copper-Alloy Die Castings¹

This standard is issued under the fixed designation B 176; 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 approval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification establishes the requirements for copper-alloy die castings. The alloys specified are Copper Alloy UNS Nos. C85700, C85800, C86500, C 87800, C99700, and C99750.²

1.2 *Units*—Values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units, which are provided for information only and are not considered standard.

2. Referenced Documents

2.1 *ASTM Standards*:³

B 824 Specification for General Requirements for Copper Alloy Castings

E 8 Test Methods for Tension Testing of Metallic Materials

E 23 Test Methods for Notched Bar Impact Testing of Metallic Materials

E 255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition

E 527 Practice for Numbering Metals and Alloys (UNS)

2.2 *American Die Casting Institute*:

“E” Series Product Standards⁴

2.3 *Federal Standard*:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁵

2.4 *Military Standards*:

MIL-STD-129 Marking for Shipment and Storage (Military Agencies)⁵

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.05 on Castings and Ingots for Remelting.

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² The UNS system for copper and copper alloys (see Practice **E 527**) is a simple expansion of the former standard designation system accomplished by the addition of a prefix “C” and a suffix “00”. The suffix can be used to accommodate composition variations of the base alloy.

³ 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.

⁴ Available from the American Die Casting Institute, 2340 Des Plaines Ave., Des Plaines, IL 60018.

⁵ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, ATTN: NPODS.

MIL-P-116 Methods of Preservation⁵

3. General Requirements

3.1 The following sections of Specification **B 824** constitute a part of this specification.

3.1.1 Terminology (Section 3),

3.1.2 Number of Tests and Retests (Section 10) (Note to users: Paragraph 10.3 of Specification **B 824** applies only when mechanical requirements are specified in the purchase order.),

3.1.3 Test Methods (Section 12),

3.1.4 Significance of Numerical Limits (Section 13),

3.1.5 Inspection (Section 14),

3.1.6 Rejection and Rehearing (Section 15),

3.1.7 Certification (Section 16),

3.1.8 Test Report (Section 17),

3.1.9 Product Marking (Section 18), and

3.1.10 Supplementary Requirements.

3.2 In addition, when a section with a title identical to that referenced in 3.1, above, appears in this specification, it contains additional requirements which supplement those appearing in Specification **B 824**.

4. Terminology

4.1 For general terms related to copper and copper alloys, refer to Terminology B 846.

5. Ordering Information

5.1 Include the following information when placing orders for die castings under this specification as applicable:

5.1.1 Specification title, number, and year of issue,

5.1.2 Part name and number,

5.1.3 Copper Alloy UNS Number,

5.1.4 Quantity and delivery schedule, as required,

5.1.5 Engineering drawing of die casting, when required, giving all necessary dimensions and tolerances and showing latest revisions and allowances for machining, if any. Location of ejector pin marks or parting lines shall be at the option of the manufacturer unless specifically designated on the drawing.

5.1.6 When die castings are purchased for agencies of the U.S. government the Supplementary Requirements of Specification **B 824** may be specified.

5.2 The following requirements are optional and should be specified in the purchase order when required.

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

TABLE 1 Chemical Requirements

Copper Alloy UNS No.	Major Elements										Residual Elements						
	Copper	Tin	Lead	Zinc	Iron	Nickel including Cobalt	Aluminum	Manganese	Silicon	Iron	Antimony	Nickel Cobalt	Sulphur	Phosphorous	Aluminum	Manganese	Silicon
C85700	58.0–64.0 ^A	0.50–1.5	0.8–1.5	32.0–40.0	0.7	...	1.0	0.8	...	0.05
C85800	57.0 min ^A	1.5	1.5	31.0–41.0	0.50	0.05	0.50	0.05	0.01	0.55	0.25	0.25 ^B
C86500	55.0–60.0 ^A	1.0	0.40	36.0–42.0	0.40–2.0	...	0.50–1.5	0.10–1.5	1.0
C87800	80.0 min ^A	0.25	0.15	12.0–16.0	3.8–4.2	0.15	0.05	0.20	0.05	0.01	0.15	0.15	^{B,C}
C99700	54.0 min ^A	1.0	2.0	19.0–25.0	...	4.0–6.0	0.50–3.0	11.0–15.0	...	1.0
C99750	55.0–61.0	...	0.50–2.5	17.0–23.0	...	5.0	0.25–3.0	17.0–23.0	...	1.0 ^D

^A In determining copper min, copper may be determined as copper plus nickel.

^B Arsenic 0.05 max.

^C Magnesium 0.01 max.

^D Iron content above the nickel content may cause hard spots resulting in decreased machinability.

- 5.2.1 Inspection lot sampling (Section 8),
- 5.2.2 Chemical analysis of residual elements (Section 4),
- 5.2.3 Soundness requirements (Section 9),
- 5.2.4 Mechanical requirements (Section 5),
- 5.2.5 Special requirements (Section 9),
- 5.2.6 Certification (Specification B 824),
- 5.2.7 Foundry test report (Specification B 824),
- 5.2.8 Witness inspection (Specification B 824),
- 5.2.9 Product marking (Specification B 824), and
- 5.2.10 Packaging requirements (Section 12).

6. Chemical Composition

6.1 The castings shall conform to the requirements for major elements as shown in Table 1.

6.2 These specification composition limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements agreed upon between the manufacturer or supplier and the purchaser. Copper or zinc may be given as remainder and may be taken as the difference between the sum of all elements analyzed and 100 %. When all named elements in Table 1 are analyzed, their sum shall be as specified in Table 2.

6.3 It is recognized that residual elements may be present in cast copper-base alloys. Analysis shall be made for residual elements only when specified in the purchase order.

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

7. Mechanical Property Requirements

7.1 Unless specified in the purchase order, acceptance of die castings under this specification shall not depend on mechani-

cal properties determined by tension or impact tests. Table X1.1 shows typical mechanical properties.

7.2 When minimum mechanical properties are specified in the purchase order the mechanical properties shall be agreed upon between the manufacturer or supplier and the purchaser.

8. Dimensions, Mass, and Permissible Variations

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

8.1.1 Any dimensions for which a tolerance is not specified shall be in accord with ADCI Product Standard Series E 1 to E 16 inclusive.

9. Sampling

9.1 An inspection lot shall consist of the production from each die or compound die on each machine for each 24 h during the first week of normal operation and the production for each 48 h thereafter of normal operation. Any significant change in the machine, composition, die or continuity of operation shall be considered as the start of a new lot. Die castings inspected by this method shall be so marked or handled during the finishing operations as not to lose their identity.

9.2 Each die casting of a randomly selected sample shall be examined to determine conformance to the requirements with respect to general quality, dimensions and identification marking. The producer or supplier may use a system of statistical quality control for such examinations.

9.3 *Sampling for Chemical Analysis*—Refer to the Sampling section of Specification B 824 and Practice E 255 for sampling methodology.

10. Special Requirements

10.1 *Internal Soundness*—When specified, the soundness of die castings shall conform to standards or requirements agreed upon between the producer or supplier and the purchaser. The number and extent of imperfections shall not exceed those specified by the purchaser. The standards or requirements may consist of radiographs, photographs or sectioned die castings.

TABLE 2 Sum of All Named Elements Analyzed

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C85700	98.7
C85800	98.7
C86500	99.0
C87800	99.5
C99700	99.7
C99750	99.7