



Designation: ~~B595–95 (Reapproved 2006)~~ Designation: B595 – 11

Standard Specification for Sintered Aluminum Structural Parts¹

This standard is issued under the fixed designation B595; 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 sintered aluminum structural parts made primarily from aluminum powders to which controlled amounts of master alloys or elemental copper, magnesium, and silicon have been added by blending.*~~

1.1 This specification covers sintered aluminum structural parts made primarily from aluminum powders to which controlled amounts of master alloys or elemental copper, magnesium, and silicon have been added by mixing.

1.2 This specification covers the following variables:

1.2.1 *Composition*—Depending upon levels of copper, magnesium, and silicon content, two grades, and

1.2.2 *Density*—Type.

1.3 Parts ordered to this specification will be in one of the following conditions:

1.3.1 As-sintered,

1.3.2 As-repressed for additional density, or

1.3.3 All other conditions plus heat treated.

~~1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.~~

1.4 With the exception of the values for density, for which the use of the gram per cubic centimeter unit is long-standing industry practice, the values stated in SI units are to be regarded as the standard.

2. Referenced Documents

2.1 *ASTM Standards*:²

B243 *Terminology of Powder Metallurgy*

~~B328 Test Method for Density, Oil Content, and Interconnected Porosity of Sintered Metal Structural Parts and Oil-Impregnated Bearings—962 Test Methods for Density of Compacted or Sintered Powder Metallurgy (PM) Products Using Archimedes' Principle~~

B963 Test Methods for Oil Content, Oil-Impregnation Efficiency, and Interconnected Porosity of Sintered Powder Metallurgy (PM) Products Using Archimedes' Principle

E8 Test Methods for Tension Testing of Metallic Materials

3. Terminology

3.1 *Definitions*—Definitions of powder metallurgy terms can be found in Terminology B243. Additional descriptive information is available in the Related Material Section of Volume 02.05 of the *Annual Book of ASTM Standards*.

4. Ordering Information

4.1 Orders for material to this specification shall include the following information:

4.1.1 Dimensions (see 9.1),

4.1.2 Chemical composition (see 6.1),

4.1.3 Density (see 7.1),

4.1.4 State of heat treatment,

4.1.5 Mechanical property requirements (see 8.1), and

4.1.6 Certification (see 14.1).

¹ This specification is under the jurisdiction of ASTM Committee B09 on Metal Powders and Metal Powder Products and is the direct responsibility of Subcommittee B09.05 on Structural Parts.

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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.

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

5. Materials and Manufacture

5.1 Structural parts shall be made by ~~molding~~compacting and sintering metal powders to produce finished parts conforming to the requirements of this specification.

6. Chemical Composition

6.1 The material shall conform to the requirements of Table 1.

6.2 The chemical analysis shall be made in accordance with the methods prescribed in the latest edition of the *Annual Book of ASTM Standards*, Vol 03.05, or any other approved method agreed upon between the manufacturer and the purchaser.

7. Density

7.1 The parts shall conform to the density range prescribed in Table 2.

7.2 The density shall be measured in accordance with Test Method ~~B328~~B962.

7.3 If the density does not vary more than 0.1 g/cm³ from one section of the structural part to any other section, the overall density shall fall within the limits prescribed in Table 2.

7.4 If the density varies more than 0.1 g/cm³ from one section of the structural part to any other section, the manufacturer and the purchaser shall agree upon a critical section of the part where the stresses are the highest. The density of this critical section rather than the average density shall fall within the limits prescribed in Table 2.

8. Mechanical Properties

8.1 The manufacturer and the purchaser shall agree on qualification tests for the determination of mechanical properties.

8.2 These tests shall be performed on production parts.

8.3 These tests shall be determined after consideration of the function of the part.

8.4 The limits and sampling plan shall be agreed upon between the manufacturer and purchaser.

8.5 All shipments of parts subsequent to the establishment of testing conditions shall conform to the limits agreed upon.

NOTE 1—The mechanical properties in tension and compression that may be expected from standard specimens ~~molded~~compacted to size are given in Appendix X1 of this specification.

9. Dimensions and Tolerances

9.1 Permissible variations in dimensions shall be within the limits specified on the drawings describing the structural parts accompanying the order or shall be within the limits specified in the order.

10. Workmanship, Finish, and Appearance

10.1 Structural parts shall be uniform in composition.

10.2 When parts are cut or fractured, the exposed surface shall be of uniform appearance.

11. Sampling

~~11.1 Lot—Unless otherwise specified, a lot shall consist of parts of the same form and dimensions made from powders of the same composition molded and sintered under the same conditions and submitted for inspection at one time.~~

~~11.2~~

11.1 *Chemical Analysis*—If required by purchase agreement, at least one sample for chemical analysis shall be taken from each lot. A representative sample of chips may be obtained by dry milling, drilling or crushing at least two pieces with clean dry tools without lubrication. ~~In order to~~ To obtain oil-free chips, the parts selected for test shall have the oil extracted in accordance with Test Method ~~B328~~B963, if necessary.

~~11.3~~

11.2 *Mechanical Tests*—The manufacturer and purchaser shall agree on ~~a representative~~the number of specimens for mechanical tests.

TABLE 1 Chemical Requirements

Element	Composition, mass %	
	AXX-6061 ^A	ACXX-2014 ^A
Copper	0.5 max	3.5–5.0
Magnesium	0.4–1.2	0.2–0.8
Silicon	0.2–0.8	1.2 max
Aluminum, min	96.0	91.5
Total of other elements, determined by difference, max	1.5	1.5

^A An "XX" denotes position of thermal condition—see footnote to Table X1.1