



Designation: B595 – 11

Standard Specification for Sintered Aluminum Structural Parts¹

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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 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 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

B962 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

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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.

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**).

5. Materials and Manufacture

5.1 Structural parts shall be made by 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 **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**.

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

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 “XX” denotes thermal condition – see footnote to [Table X1.1](#)

TABLE 2 Density

Type	Dry Density, g/cm ³
I	2.30 to 2.45
II	2.45 to 2.60
III	2.60 min

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 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 *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. To obtain oil-free chips, the parts selected for test shall have the oil extracted in accordance with Test Method [B963](#), if necessary.

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

12. Inspection

12.1 Unless otherwise specified, inspection of parts supplied on contract shall be made by the purchaser.

13. Rejection and Rehearing

13.1 Parts that fail to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with test results, the producer or supplier may make claim for rehearing.

14. Certification

14.1 When specified in the purchase order or contract, a producer’s certification shall be furnished to the purchaser that the parts were manufactured, sampled, tested, and inspected in accordance with this specification and have been found to meet the requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

14.2 The purchase order shall specify whether or not the certification includes chemical composition.

14.3 Upon request of the purchaser in the contract or order, the certification of an independent third party indicating conformance to the requirements of this specification may be considered.

15. Keywords

15.1 as-repressed; as-sintered; density; interconnected porosity; oil-impregnated; powder metallurgy; sintered aluminum; structural parts; thermal condition