



Designation: **B632/B632M—08 B632/B632M – 15**

Standard Specification for Aluminum-Alloy Rolled Tread Plate¹

This standard is issued under the fixed designation B632/B632M; 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.

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

1. Scope*

1.1 This specification covers aluminum-alloy rolled flat tread plate, mill-finish, with a raised pattern on one side, in the alloy, tempers, and thicknesses shown in **Table 1** and **Table 2** [**Table 3**].

1.2 Alloy and temper designation are in accordance with ANSI H35.1/H35.1M. The equivalent Unified Numbering System alloy designation are those of **Table 1** preceded by A9, which is A96061 for alloy 6061 and A93003 for Alloy 3003 in accordance with Practice **E527**.

1.3 For acceptance criteria for inclusion of new aluminum and aluminum alloys in this specification, see **Annex A2**.

1.4 The values stated in either inch-pound or SI units are to be regarded separately as standard. The SI units are shown either in brackets or in separate tables. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems will result in nonconformance with the specification.

2. Referenced Documents

2.1 The following documents of the issue in effect on the date of material purchase 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 Aluminum- and Magnesium-Alloy Products

B557M Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products (Metric)

B660 Practices for Packaging/Packing of Aluminum and Magnesium Products

B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products

B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products

B985 Practice for Sampling Aluminum Ingots, Billets, Castings and Finished or Semi-Finished Wrought Aluminum Products for **Compositional Analysis**

B918 Practice for Heat Treatment of Wrought Aluminum Alloys

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E34 Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys

~~**E55** Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition~~

E290 Test Methods for Bend Testing of Material for Ductility

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

E607 Test Method for Atomic Emission Spectrometric Analysis Aluminum Alloys by the Point to Plane Technique Nitrogen Atmosphere (Withdrawn 2011)³

E716 Practices for Sampling and Sample Preparation of Aluminum and Aluminum Alloys for Determination of Chemical Composition by Spectrochemical Analysis

E1251 Test Method for Analysis of Aluminum and Aluminum Alloys by Spark Atomic Emission Spectrometry

¹ This specification is under the jurisdiction of ASTM Committee **B07** on Light Metals and Alloys and is the direct responsibility of Subcommittee **B07.03** on Aluminum Alloy Wrought Products.

Current edition approved ~~March 1, 2008~~ Oct. 1, 2015. Published ~~March 2008~~ October 2015. Originally approved in 1978. Last previous edition approved in ~~2002~~ 2008 as **B632/B632M/B632M – 08, –02**. DOI: ~~10.1520/B0632_B0632M-08~~ 10.1520/B0632_B0632M-15.

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.

³ The last approved version of this historical standard is referenced on www.astm.org.

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

TABLE 1 Chemical Composition Limits^{A,B,C,F}

Alloy	Silicon	Iron	Copper	Manganese	Magnesium	Chromium	Zinc	Titanium	Other Elements ^D		Aluminum
									Each	Total ^E	
3003	0.6	0.7	0.05-0.20	1.0-1.5	---	---	0.10	---	0.05	0.15	Remainder
6061	0.40-0.8	0.7	0.15-0.40	0.15	0.8-1.2	0.04-0.35	0.25	0.15	0.05	0.15	Remainder

^A Limits in weight percent maximum unless shown as a range or minimum

^B Analysis shall be made for the elements for which limits are shown in this table.

^C For purposes of determining conformance to these limits, an observed value or a calculated value obtained from analysis shall 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 off method of Practice E29.

^D *Others* includes listed elements for which no specific limit is shown as well as unlisted metallic elements. The producer may analyze samples for trace elements not specified in the specification. However, such analysis is not required and may not cover all metallic *Others* elements. Should any analysis by the producer or purchaser establish that an *Others* element exceed the limit of Each or that the aggregate of several *Others* elements exceeds the limit of Total, the material shall be considered non-conforming.

^E Other Elements—Total shall be the sum of unspecified metallic elements 0.010 % or more, rounded to the second decimal before determining the sum.

^F In case there is a discrepancy in the values listed in Table 1 with those listed in the "International Alloy Designations and Chemical Composition Limits for Wrought Aluminum and Wrought Aluminum Alloys" (known as the "Teal Sheets"), the composition limits registered with the Aluminum Association and published in the "Teal Sheets" shall be considered the controlling composition. The "Teal Sheets" are available at <http://www.aluminum.org/tealsheets>.

TABLE 2 Tensile Properties, Inch-Pound Units^{A,B}

Alloy and Temper	Specified Thickness ^C , in.	Tensile Strength, ksi		Yield Strength (0.2 % Offset), ksi		Elongation in 2 in. or 4 ^D min, %
		min	max	min	max	
3003-H231	0.100-0.113	19.0	...	15.0	...	5
	0.114-0.161	19.0	...	15.0	...	6
	0.162-0.188	19.0	...	15.0	...	7
6061-O	0.100-0.128	...	22.0	...	12.0	16
	0.129-0.499	...	22.0	...	12.0	18
	0.500-0.625	...	22.0	18
6061-T4	0.100-0.249	30.0	...	16.0	...	14
	0.250-0.625	30.0	...	16.0	...	16
6061-T42 ^E	0.100-0.249	30.0	...	14.0	...	14
	0.250-0.625	30.0	...	14.0	...	16
6061-T6 and T62 ^E	0.100-0.188	42.0	...	35.0	...	6
	0.189-0.249	42.0	...	35.0	...	8
	0.250-0.499	42.0	...	35.0	...	10
6061-F	0.500-0.625	42.0	...	35.0	...	9
	0.100-0.625	no requirements				

^A To determine conformance to this specification, each value for tensile strength and for yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation to the nearest 0.5 %, both in accordance with the rounding-off method of Practice E29.

^B See Annex A1 for the basis for establishment of mechanical property limits.

^C For sheet and plate under 1/2 in. in thickness, the standard 1/2 in. wide rectangular tension test specimen shall be used.

^D The specimen diameter is represented by D.

^E This temper is not available from the material producer.

2.3 ANSI Standards:⁴

[H35.1/H35.1M Alloy and Temper Designation Systems for Aluminum](#)

[H35.2 Dimensional Tolerances for Aluminum Mill Products](#)

[H35.2M Dimensional Tolerances for Aluminum Mill Products \[Metric\]](#)

2.4 Other Standards

[CEN EN 14242 Aluminum and Aluminum Alloys. Chemical Analysis. Inductively Coupled Plasma Optical Emission Spectral Analysis⁵](#)

3. Terminology

3.1 *Definitions*: Refer to Terminology B881 for definitions of product terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *capable of*—The term *capable of* as used in this specification means that the tests need not be performed. However, should testing by the purchaser establish that the material does not meet these requirements, the material shall be subject to rejection.

⁴ Available from Aluminum Association, Inc., 1525 Wilson Blvd., Suite 600, 1400 Crystal Drive, Suite 430 Arlington, VA 22209, <http://www.aluminum.org> 22202 (<http://www.aluminum.org>).

⁵ Available from European Committee for Standardization, Central Secretariat (CEN), Rue de Stassart 36, B1050 Brussels, Belgium (<http://www.cen.eu/research>).

TABLE 3 Tensile Properties [SI Units]^{A,B}

Alloy and Temper	Specified Thickness, ^C mm		Tensile Strength, MPa		Yield Strength (0.2 % Offset), MPa		Elongation, min, %	
	Over	Through	min	max	min	max	in 50 mm	5D ^D
3003-H231	2.50	3.20	130	...	105	...	5	...
	3.20	4.00	130	...	105	...	6	...
	4.00	5.00	130	...	105	...	7	...
6061-O	2.49	3.20	...	150	...	85	16	...
	3.20	12.50	...	150	...	85	18	...
	12.50	16.00	...	150	16
6061-T4	2.49	6.30	205	...	110	...	14	...
	6.30	12.50	205	...	110	...	16	...
	12.50	16.00	205	...	110	14
6061-T42 ^E	2.49	6.30	205	...	95	...	14	...
	6.30	12.50	205	...	95	...	16	...
	12.50	16.00	205	...	95	14
6061-T6 and T62 ^E	2.49	5.00	290	...	240	...	6	...
	5.00	6.30	290	...	240	...	8	...
	6.30	12.50	290	...	240	...	10	...
6061-F	12.50	16.00	290	...	240	8
	2.49	16.00	no requirements					

^A To determine conformance to this specification, each value for tensile strength and for yield strength shall be rounded to the nearest 1 MPa and each value for elongation to the nearest 0.5 %, both in accordance with the rounding-off method of Practice E29.

^B See Annex A1 for the basis for establishment of mechanical property limits.

^C For sheet and plate through 12.50 mm in thickness, the standard 12.50-mm wide tension rectangular test specimen shall be used.

^D The specimen diameter is represented by *D*.

^E This temper is not available from the material producer.

iTeh Standards

(<https://standards.iteh.ai>)

4. Ordering Information

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

4.1.1 This specification designation (which includes the number, the year, and the revision letter, if applicable),

NOTE 1—For inch-pound orders, specify Specification B632; for metric orders, specify Specification B632M. Do not mix units.

4.1.2 Quantity in pieces or pounds [kilograms], [ASTM B632/B632M-15](https://standards.iteh.ai/catalog/standards/sist/ae2da62f-b305-4d56-a130-dc484d8173c0/astm-b632-b632m-15)

4.1.3 Alloy (7.1), <https://standards.iteh.ai/catalog/standards/sist/ae2da62f-b305-4d56-a130-dc484d8173c0/astm-b632-b632m-15>

4.1.4 Temper (9.1),

4.1.5 Dimensions (thickness, width, and length),

4.2 Additionally, orders for material to this specification shall include the following information when required by the purchaser:

4.2.1 Whether tension test specimens that retain the pattern are unacceptable (Table 2, footnote C).

4.2.2 Whether bend tests are required (10.1),

4.2.3 Whether inspection or witness of inspection and tests by the purchaser's representative is required prior to material shipment (13.1),

4.2.4 Whether certification of the material by the producer or supplier is required (17.1),

4.2.5 Whether marking is required (15.1), and

4.2.6 Whether Practices B660 applies and, if so, the levels of preservation, packaging, and packing required (16.3).

5. Responsibility for Quality Assurance

5.1 *Responsibility for Inspection and Tests*—Unless otherwise specified in the contract or purchase order, the producer is responsible for the performance of all inspection and test requirements specified herein. The producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser in the order or at the time of contract signing. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to assure that material conforms to prescribed requirements.

5.2 *Lot Definition*—An inspection lot shall be defined as follows:

5.2.1 For heat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and thickness traceable to a heat-treat lot or lots, and subjected to inspection at one time.

5.2.2 For non-heat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and thickness subjected to inspection at one time.



6. General Quality

6.1 Unless otherwise specified, all tread plate shall be supplied in the mill finish and shall be uniform as defined by the requirements of this specification and shall be commercially sound. Any requirement not so covered is subject to negotiation between the producer and the purchaser.

6.2 Each piece shall be examined to determine conformance to this specification with respect to general quality and identification marking. On approval of the purchaser, however, a system of statistical quality control may be used for such examinations.

7. Chemical Composition

7.1 *Limits*—The tread plate shall conform to the chemical composition limits specified in **Table 1**. Conformance shall be determined by ~~analyzing samples taken at the time the producer by taking samples in accordance with Practices E716 ingots are cast, when the ingots are poured and analyzing those samples in accordance with Test Methods E34, E607, E1251 or samples taken from the finished or semifinished product. If the chemical composition of the material has been determined during the course of manufacture, additional sampling and analysis of the finished product, or EN14242. At least one sample shall be taken for each group of ingots poured simultaneously from the same source of molten metal. If the producer has determined the chemical composition during pouring of the ingots, they shall not be necessary.~~ required to sample and analyze the finished product.

NOTE 2—It is standard practice in the United States aluminum industry to determine conformance to the chemical composition limits prior to further processing of ingots into wrought products. Due to the continuous nature of the process, it is not practical to keep a specific ingot analysis identified with a specific quantity of finished material.

7.2 *Number of Samples*—The number of samples taken for the determination of chemical composition shall be as follows:

7.2.1 When samples are taken at the time the ingots are cast, at least one sample shall be taken for each group of ingots cast simultaneously from the same source of molten metal.

7.2.2 When samples are taken from the finished or semifinished product, a sample shall be taken to represent each 4000 lb [2000 kg] or fraction thereof, of material in the lot, except that not more than one sample shall be required per piece.

7.3 *Methods of Sampling*—Samples for determination of chemical composition shall be taken in accordance with one of the following methods:

7.3.1 Samples for chemical analysis shall be taken by drilling, sawing, milling, turning, or clipping a representative piece or pieces to obtain a prepared sample of not less than 75 g. Sampling shall be in accordance with Practice E55.

7.3.2 Sampling for spectrochemical analysis shall be in accordance with Practices E716. Samples for other methods of analysis shall be suitable for the form of material being analyzed and the type of analytical method used.

7.2 *Methods of Analysis*—The determination of chemical composition shall be made in accordance with suitable chemical (Test Methods ~~E34~~) or spectrochemical (Test Methods E607 and E1251) methods. Other methods may be used only when no published ASTM method is available. In case of dispute, the method/methods of sampling and methods of analysis shall be agreed upon between the producer and purchaser as provided in the following:

7.2.1 *Methods of Sampling*—Samples for chemical analysis shall be taken in accordance with Practice B985.

7.2.2 *Methods of Analysis*—Analysis shall be performed in accordance with Test Methods E34, E607, E1251, or EN14242.

8. Heat Treatment

8.1 Producer or supplier heat treatment for the applicable tempers of alloy 6061 in **Table 2** [**Table 3**] shall be in accordance with Practice B918.

9. Tensile Properties of Materials as Supplied

9.1 *Limits*—The tread plate shall conform to the tensile properties specified in **Table 2** [**Table 3**].

9.2 *Number of Specimens*—One specimen shall be taken from a randomly selected piece representing the following quantities of tread plate in a lot:

Thickness, in. [mm]	Quantity
0.100–0.249 [over 2.49 through 6.30]	2000 lb or less [1000 kg]
0.250–0.625 [over 6.30 through 16.00]	4000 lb or less [2000 kg]

Other procedures for selecting samples may be employed if approved by the purchaser.

9.3 *Test Specimens*—Geometry of test specimens and the location in the product from which they are taken shall be as specified in Test Methods B557 [**B557M**]. Unless specified by agreement between the producer and purchaser, the producer may test specimens without the removal of the raised pattern or after the raised figures of the pattern are machined off.

9.4 *Test Methods*—The tension test shall be made in accordance with Test Methods B557 [**B557M**].



10. Bend Properties

10.1 Limits—Tread plate shall be capable of being bent cold through an angle of 180° around a pin having a diameter equal to N times the thickness of the sheet or plate without cracking, the value of N being as prescribed in Table 4 for the specified tempers and thicknesses. The test need not be conducted unless specified on the purchaser order.

10.2 Number of Specimens—The number of specimens from each lot of material to be tested shall be as specified in 9.2.

10.3 Test Specimens—When bend tests are made, the specimens shall be the full thickness of the material, approximately 3/4 in. [20 m] in width, and when practical, at least 6 in. [150 m] in length. Such specimens may be taken in any direction and their edges may be rounded to a radius of approximately 1/16 in. [2 m] if desired. The pattern side of the product shall be on the outside of the bend.

10.4 Test Methods—The bend tests shall be made in accordance with Test Method E290 except as stated otherwise in 10.3.

11. Producer Confirmation of Heat-Treat Response for 6061

11.1 In addition to the requirements of 9.1 and 10.1, mill-produced 6061 material in the O or F temper (without the subsequent imposition of cold work or forming operations) shall be capable, upon proper solution heat treatment and natural aging at room temperature, of developing the properties specified in Table 2 [Table 3] and Table 4 for T42 temper material. The natural aging period at room temperature shall be not less than 4 days, but samples of material may be tested prior to 4 days aging, and if the material fails to conform to the requirements of T42 temper material, the tests may be repeated without prejudice after completion of 4 days aging.

11.2 Alloy 6061 material in the T4 and T42 tempers shall, after proper precipitation heat treatment, be capable of attaining the properties specified in Table 2 [Table 3] and Table 4 for the T6 and T62 tempers respectively.

11.3 Number of Specimens—The number of specimens from each lot of O temper material and F temper material to be tested to verify conformance with H.11.1 and 11.2 and H.2 shall be as specified in 9.2.

12. Tolerances

12.1 Weight [Mass]—The allowable deviation from nominal weight as shown in Table 5 [Table 6] shall not exceed 8 %. The minimum weight [mass] is controlled by thickness tolerance and minimum pattern height.

12.2 Pattern—The minimum height of the raised pattern figures is 0.040 in. [1.00 mm]. (The pattern figure height is the difference in thickness between the maximum thickness reading to the top of the figure and the thickness of an adjacent nonfigured area.) The top of the raised figure may be rounded with sloping sides. A definite line of demarcation between the figure top and sides is not required. The pattern orientation shall conform to Fig. 1.

12.3 Width, Length, Pattern Line Camber, Lateral Bow, and Squareness—Tread plate shall not vary in width, length, pattern line camber, lateral bow, or squareness by more than the permissible variations prescribed in the following tables of ANSI H35.2 [H35.2M]:

Table No.	Title
7.38	Width
7.39	Length
7.41	Camber of Pattern Line
7.42	Lateral Bow
7.43	Squareness

12.4 Thickness—The thickness shall be that permitted by the respective tolerances shown in Table 7 [Table 8].

TABLE 4 Bend Diameter Factors^A

Thickness, in. [mm]	Factor, N			
	3003 Temper H231	6061 Temper O	6061 Tempers T4, T42	6061 Tempers T6, T62
0.100 [2.50]	2	2	4	7
0.125 [3.20]	2	2	4	7
0.156 [4.00]	2	2	4	7
0.188 [5.00]	2 ^B	2	4	7
0.250 [6.00]		4	5	8
... [8.00]		4	6	8
0.375 [10.00]		4	6	8
0.500 [12.00]		4	6	8
0.625 [16.00]		4	6	8

^A See 10.1.

^B The 3003-H231 product at this thickness is capable of the 2t bend but bending may produce an objectionable surface condition



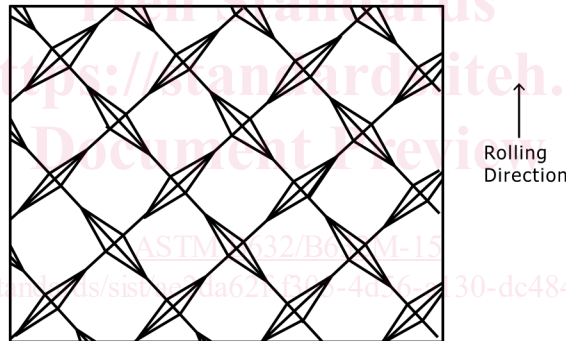
TABLE 5 Nominal Weights per Square Foot

Specified Thickness	Nominal Weight —lb/ft. ²	
	Inches	
	3003	6061
0.100	1.57	1.55
0.125	1.92	1.90
0.156	2.36	2.34
0.188	2.82	2.79
0.250	---	3.67
0.313	---	4.56
0.375	---	5.43
0.500	---	7.20
0.625	---	8.96

TABLE 6 Nominal Mass per Square Meter

NOTE 1—Length of diamond: 1 3/16 in. [31 mm] maximum. Width of diamond: 1 1/32 in. [9 mm] maximum.

Specified Thickness	Nominal Weight —kg/m ²	
	mm	
	3003	6061
2.50	7.4	7.4
3.20	9.3	9.3
4.00	11.5	11.5
5.00	14.2	14.2
6.00	---	16.9
8.00	---	22.3
10.00	---	27.7
12.00	---	33.1
16.00	---	43.9



NOTE 1—Length of diamond: 1 3/16 in. [31 mm] maximum. Width of diamond: 1 1/32 in. [9 mm] maximum.

FIG. 1 Pattern Orientation of Raised Figures (Previously Known as Pattern B)

TABLE 7 Thickness Tolerances

Specified Thickness ^A	3003 Tolerance		6061 Tolerance	
	Inches		Inches	
Inches	Plus	Minus	Plus ^B	Minus
0.100	0.006	0.006	0.008	0.012
0.125	0.009	0.009	0.010	0.015
0.156	0.010	0.010	0.011	0.019
0.188	0.010	0.010	0.013	0.023
0.250	---	---	0.018	0.030
0.313	---	---	---	---
0.375	---	---	0.025	0.045
0.500	---	---	0.035	0.060
0.625	---	---	0.044	0.075

^A Specified thickness does not include height of pattern.

^B In case of dispute, allowed plus tolerance shall be determined by weight.

12.5 Sampling for Inspection—Examination for dimensional conformance shall be made to ensure conformance to the tolerance specified. On approval of the purchaser, a system of statistical quality control for such sampling and examinations may be used.