

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard



AMS 4113D

Issued
Revised

NOV 1968
MAR 1998

Superseding AMS 4113C

(R)

Aluminum Alloy, Extruded Profiles
1.0Mg - 0.60Si - 0.28Cu - 0.20Cr (6061-T6)
Solution and Precipitation Heat Treated

UNS A96061

1. SCOPE:

1.1 Form:

This specification covers an aluminum alloy in the form of extruded profiles such as angles, channels, tees, zees, I-beams, and H-beams.

1.2 Application:

These products have been used typically for parts requiring moderate strength, especially where such parts require brazing or welding during fabrication, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

- AMS 2355 Quality Assurance Sampling and Testing, Aluminum Alloys and Magnesium Alloys, Wrought Products, Except Forging Stock, and Rolled, Forged, or Flash Welded Rings
- MAM 2355 Quality Assurance Sampling and Testing, Aluminum Alloys and Magnesium Alloys, Wrought Products, Except Forging Stock, and Rolled, Forged, or Flash Welded Rings, Metric (SI) Units
- AMS 2772 Heat Treatment of Aluminum Alloy Raw Materials

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2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 666/B 666M Identification Marking of Aluminum Products

2.3 ANSI Publications:

Available from ANSI, 11 West 42nd Street, New York, NY 10036-8002.

ANSI H 35.2 Dimensional Tolerances for Aluminum Mill Products

ANSI H 35.2M Dimensional Tolerances for Aluminum Mill Products (Metric)

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined in accordance with AMS 2355 or MAM 2355.

TABLE 1 - Composition

Element	min	max
Magnesium	0.8	1.2
Silicon	0.40	0.8
Copper	0.15	0.40
Chromium	0.04	0.35
Iron	--	0.7
Zinc	--	0.25
Manganese	--	0.15
Titanium	--	0.15
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

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Manganese	--	0.15
Titanium	--	0.15
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

3.2 Condition:

Extruded and solution and precipitation heat treated to the T6 temper in accordance with AMS 2772.

- 3.2.1 Profiles shall be supplied with an as-extruded surface finish; light polishing to remove minor surface imperfections is permissible provided such imperfections can be removed within specified dimensional tolerances.

3.3 Properties:

Profiles shall conform to the following requirements, determined in accordance with AMS 2355 or MAM 2355:

- 3.3.1 Tensile Properties: Shall be as shown in Table 2.

TABLE 2A - Minimum Tensile Properties, Inch/Pound Units

Nominal Diameter or Least Thickness Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches or 4D %
Up to 0.250, excl	38.0	35.0	8
0.250 and over	38.0	35.0	10

TABLE 2B - Minimum Tensile Properties, SI Units

Nominal Diameter or Least Thickness Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm or 4D %
Up to 6.35, excl	262	241	8
6.35 and over	262	241	10

3.4 Quality:

Extruded profiles, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to usage of the profiles.

3.5 Tolerances:

Shall conform to all applicable requirements of ANSI H35.2 or ANSI H35.2M.

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Extruded and solution and precipitation heat treated to the T6 temper in accordance with AMS 2772.

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Shall conform to all applicable requirements of ANSI H35.2 or ANSI H35.2M.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of extruded profiles shall supply all samples for vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the extruded profiles conform to specified requirements.

4.2 Classification of Tests:

Composition (3.1), tensile properties (3.3.1), and tolerances (3.5) are acceptance tests and, except for composition, shall be performed on each inspection lot.

4.3 Sampling and Testing:

Shall be in accordance with AMS 2355 or MAM 2355.

4.4 Reports:

4.4.1 The vendor of extruded profiles shall furnish with each shipment a report stating that the extruded profiles conform to the chemical composition and tolerances and showing the numerical results of tests on each inspection lot to determine conformance to the tensile property requirements. This report shall include the purchase order number, inspection lot number, AMS 4113D, size or section identification number, and quantity.

4.5 Resampling and Retesting:

Shall be in accordance with AMS 2355 or MAM 2355.

5. PREPARATION FOR DELIVERY:

5.1 Identification:

Shall be in accordance with ASTM B 666/B 666M.

5.2 Packaging:

Extruded profiles shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the extruded profiles to ensure carrier acceptance and safe delivery.

6. ACKNOWLEDGMENT:

A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

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