



AEROSPACE MATERIAL SPECIFICATION	AMS2771™	REV. F
	Issued	1987-10
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Superseding AMS2771E		
Heat Treatment of Aluminum Alloy Castings		

RATIONALE

AMS2771F results from limited scope ballots with changes to refrigeration equipment (3.1.5), solution treatment batch furnace interruption (3.2.6.1), quenchant temperature rise (3.2.9.4.1), refrigeration processing (3.2.10.2), solution treatment (Table 1) for A201 and A206, and adding A206-T71 precipitation treatment (Table 2).

1. SCOPE

1.1 Purpose

This specification covers the engineering requirements for heat treatment of aluminum alloy castings and for parts machined from castings.

1.2 Application

This specification is applicable to castings of the following aluminum alloy and modifications (see 8.2.8):

201.0	328.0	520.0
203.0	333.0	705.0
206.0	336.0	707.0
222.0	354.0	712.0
242.0	355.0	713.0
243.0	356.0	850.0
295.0	357.0	851.0
296.0	358.0	852.0
319.0	359.0	

1.3 When AMS2771 is specified and specific heat treat processing instructions are included in the material specification, the equipment and control requirements of AMS2771 shall apply. For alloys not specifically covered, the provisions of this specification shall be applicable, but temperatures, times, and quenching procedures shall be as specified by the purchaser.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

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2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AMS2750	Pyrometry
AMS3025	Polyalkylene Glycol Heat Treat Quenchant
ARP1917	Clarification of Terms Used in Aerospace Metals Specifications
ARP1962	Training and Approval of Heat-Treating Personnel

2.2 ANSI Accredited Publications

Copies of these documents are available online at <http://webstore.ansi.org/>.

ANSI H35.1/H35.1M Standard Alloy and Temper Designation System For Aluminum

3. TECHNICAL REQUIREMENTS

3.1 Equipment

Equipment used for thermal processing shall conform to the requirements of this specification and AMS2750, except (1) requirements for working zone controls, instruments and sensors shall apply to all heating zones of continuous and semi-continuous furnaces and (2) recordings from instruments may be stored on magnetic or optical media providing a hard copy is available on request.

3.1.1 Pyrometry

Shall meet the requirements of AMS2750.

3.1.2 Furnaces

3.1.2.1 Heating Media

Shall be air, protective atmosphere, combustible gases, molten salt bath, oil bath, or fluidized bed. Electrical heating elements and radiant tubes shall be shielded to prevent direct radiation from striking any part. The products of combustion in the furnace, and the composition and maintenance of salt baths and fluidized beds shall be such as to prevent attack or contamination of the castings. Ammonium fluoroborate, or equivalent, may be used in air furnaces as necessary. Nitrate salt baths shall not be used to heat heat 520.0 alloy due to a potential explosion safety hazard.

3.1.2.1.1 Salt Entrapment

Castings that will entrap salt shall not be heated in a molten salt bath.

3.1.2.2 Temperature Uniformity Survey Requirements

Temperature uniformity surveys shall be performed as defined in AMS2750.

3.1.2.2.1 Solution Heat Treating and Aging Furnaces shall be Class 2 minimum as defined in AMS2750.

3.1.2.2.2 Annealing Furnaces shall be Class 5 minimum as defined in AMS2750.

3.1.3 Quenching

Unless otherwise approved by the cognizant engineering organization, the following provisions apply. Equipment shall be provided for quenching in water, air blast, oil, or in polymer quenchant and for measuring quenchant temperature. Provisions shall be made for mechanical, hydraulic, or air agitation of the quenching medium or agitation of the castings or both and for heating and cooling of the quenchant, as required. Air agitation shall be allowed provided the air doesn't come in contact with the castings being quenched. The volume of quenching medium for immersion quenching shall be sufficient so that its temperature rise due to quenching meets the requirements of 3.2.9.4.1.

3.1.3.1 Polymer Quenchants

Polyalkylene glycol shall meet the requirements of AMS3025. Other synthetics may be used provided that they are not detrimental to the material and that the parts meet the required specified properties in the final heat treated condition. Polymer concentration shall be established for the particular casting configuration prior to use.

3.1.3.2 Salt Contamination of Polymer Quenchants

Shall not exceed 6% by weight.

3.1.4 Cleaning

Equipment shall be provided to clean castings, as necessary for heat treatment, and to remove residual quenchant after solution heat treatment. Examples include: water rinse to remove polymer quenchant residue, detergent and rinse to remove oil quenchant residue, and fresh water overflow to remove salt quenchant residue.

3.1.5 Refrigeration

Refrigeration or liquid baths shall be provided for cold storage of castings when prevention of natural aging is necessary to produce required properties or is used at the discretion of the producer to facilitate straightening.

3.2 Procedures

3.2.1 General

Cast parts that require heat treatment to a T4X, T6X, or T7X temper (refer to ANSI H35.1/H35.1M) shall be solution heat treated (including quenching), refrigerated after quenching, when necessary, and aged, when required, as specified herein. Castings in the T5X condition shall be refrigerated after casting, when necessary, and aged as specified herein. Heat treatment shall be performed only on entire castings, never on a portion of a part.

3.2.2 Racking and Spacing

Product shall be supported or hung and spaced to permit flow of the heating and cooling media over all surfaces to ensure that the castings will meet the specified requirements. Alternate racking methods are acceptable if tests have been performed to demonstrate that all castings so racked will meet specified requirements. Written instructions, drawings, photographs, etc., shall be used to ensure proper spacing.

3.2.2.1 Small castings, as defined in 8.2.4 may be heated and soaked in baskets or continuous furnaces. Care must be used to provide access for heating and quench media and to prevent damage during loading and quenching. Arrangement in baskets may be either orderly or random provided that the castings meet the required specified properties in the final heat treated condition.

3.2.2.2 Water Entrapment

Racks and fixtures used for solution heat treatment shall be constructed to preclude entrapment of water.

3.2.3 Loading

The temperature of the furnace during part loading shall not exceed the solution treating temperature of the castings being heat treated.