

Where a part design does not allow the production of a pressure-tight die casting through control of porosity by gate and overflow die design, the location of ejector pins, and the reconfiguration of hard-to-cast features, impregnation of aluminum die castings can be used. Systems employing anaerobics and methacrylates are employed to produce sealed, pressure-tight castings with smooth surfaces.

A detailed discussion of finishing methods for aluminum die castings can be found in *Product Design For Die Casting*.

Table A-3-1 Chemical Composition: Al Alloys

All single values are maximum composition percentages unless otherwise stated.

Aluminum Die Casting Alloys (A)(E)											
Commercial: ANSI/AA	360 360.0	A360 A360.0	380 (B) 380.0	A380 (B) A380.0	383 383.0	384 (B) 384.0	390* B390.0	13 413.0	A13 A413.0	43 C443.0	218 518.0
Nominal Comp:	Mg 0.5 Si 9.0	Mg 0.5 Si 9.5	Cu 3.5 Si 8.5	Cu 3.5 Si 8.5	Cu 2.5 Si 10.5	Cu 3.8 Si 11.0	Cu 4.5 Si 17.0	Si 12.0	Si 12.0	Si 5.0	Mg 8.0
Detailed Composition											
Silicon Si	9.0-10.0	9.0-10.0	7.5-9.5	7.5-9.5	9.5-11.5	10.5-12.0	16.0-18.0	11.0-13.0	11.0-13.0	4.5-6.0	0.35
Iron Fe	2.0	1.3	2.0	1.3	1.3	1.3	1.3	2.0	1.3	2.0	1.8
Copper Cu	0.6	0.6	3.0-4.0	3.0-4.0	2.0-3.0	3.0-4.5	4.0-5.0	1.0	1.0	0.6	0.25
Magnesium Mg	0.4-0.6	0.4-0.6	0.30 (F)	0.30 (F)	0.10	0.10	0.45-0.65	0.10	0.10	0.10	7.5-8.5
Manganese Mn	0.35	0.35	0.50	0.50	0.50	0.50	0.50	0.35	0.35	0.35	0.35
Nickel Ni	0.50	0.50	0.50	0.5	0.30	0.50	0.10	0.50	0.50	0.50	0.15
Zinc Zn	0.50	0.50	3.0	3.0	3.0	3.0	1.5	0.50	0.50	0.50	0.15
Tin Sn	0.15	0.15	0.35	0.35	0.15	0.35	—	0.15	0.15	0.15	0.15
Titanium Ti	—	—	—	—	—	—	0.10	—	—	—	—
Others Each	—	—	—	—	—	—	0.10	—	—	—	—
Total Others (C)	0.25	0.25	0.50	0.50	0.50	0.50	0.20	0.25	0.25	0.25	0.25
Aluminum Al	Balance	Balance	Balance	Balance	Balance	Balance	Balance	Balance	Balance	Balance	Balance

(A) Analysis shall ordinarily be made only for the elements mentioned in this table. If, however, the presence of other elements is suspected, or indicated in the course of routine analysis, further analysis shall be made to determine that the total of these other elements are not present in excess of specified limits. (B) With respect to mechanical properties, alloys A380.0, 383.0 and 384.0 are substantially interchangeable. (C) For RoHS (the European Union's Directive on Restriction of Hazardous Substances) compliance, certification of chemical analysis is required to ensure that the "total others" category does not exceed the following weight percent limits: 0.01% cadmium, 0.4% lead, and 0.1% mercury. Hexavalent chromium does not exist in the alloys and therefore meets the 0.1% limit. (D) Notched Charpy. Sources: ASTM B85-92a; ASM; SAE; Wabash Alloys. (E) Registration for REACH (the European Union's Directive on Registration, Evaluation, and Authorization of Chemicals) is not required for die castings, even if coated, since die castings are considered articles. Notification may be required if some contained substances in the die casting or coating exceed the 0.1% total weight of the article level and are listed as SVHC (substances of very high concern). (F) NADCA allows 0.30 maximum magnesium as opposed to 0.10. A380 with 0.30 magnesium has been registered with the Aluminum Association as E380 and 383 with 0.30 magnesium as B383.

*Two other aluminum alloys, 361 & 369, are being utilized in limited applications where vibration and wear are of concern. There are also other heat treatable specialty alloys available for structural applications, such as the Silafonts and AA365, and high ductility, high strength alloys such as Mercalloy and K-Alloy. Contact your alloy producer for more information. Sources: ASTM B85-92a; Aluminum Association.