

CAST ALUMINIUM PROFILE DATA SHEET

LM6 ALUMINIUM CASTING ALLOY

(Al - Si2) This alloy conforms to British Standards 1490 LM6

CHEMICAL COMPOSITION %

Copper	0.1 max.
Magnesium	0.10 max.
Silicon	10.0-13.0
Iron	0.6 max.
Manganese	0.5 max.
Nickel	0.1 max.
Zinc	0.1 max.
Lead	0.1 max.
Tin	0.05 max.
Titanium	0.2 max.
Aluminium	Remainder

MECHANICAL PROPERTIES

	SAND CAST	CHILL CAST
0.2% Proof Stress (N/mm2)*	60-70	70-80
Tensile Stress (N/mm2) *	160-190	190-230
Elongation (%)*	5-10	7-15
Impact Resistance, Izod (Nm)	6.0	9.0
Brinell Hardness Number	50-55	55-60
Endurance Limit (5 X 10 ⁷ cycles N/mm2)	51	68
Modulus of Elasticity (X 10 ³ N/mm2)	71	71
Shear Strength N/mm2	120	

* The values shown are typical ranges for sand and chill cast test bars produced to the requirements of B.S. 1490 and for 6 mm diameter die cast bars; those in heavier type are minimum specification values.

STRENGTH AT ELEVATED TEMPERATURES

Tensile strength and hardness decrease fairly regularly with increasing temperature and become relatively poor at temperatures of the order of 250oC.

PHYSICAL PROPERTIES

Coefficient of Thermal Expansion (per oC at 20-100oC)	0.00020
Thermal Conductivity (cal/cm2/cm/oC/ at 25oC) *	0.34
Electrical Conductivity (% copper standard at 20oC *	37
Solidification Shrinkage (approx. %)	3.7
Specific Gravity	2.65
Freezing Range (oC) approx.	575-565

MACHINABILITY

Alloys of this and similar compositions are rather difficult to machine. This is due firstly to their tendency to drag and secondly to the rapid tool wear caused by the high silicon content. Carbide tipped tools with large rake angles and relatively low cutting speeds give comparatively good results. A cutting lubricant and coolant should be employed.

CORROSION RESISTANCE

LM6 exhibits excellent resistance to corrosion under both ordinary atmospheric and marine conditions. For the severest conditions this property can be further enhanced by anodic treatment.

ANODISING

LM6 can be anodised by any of the common processes, the resulting protective film ranging in colour from grey to dark brown.

CASTING CHARACTERISTICS

Fluidity Can be cast into thinner and more intricate sections than any of the other types of casting alloys.

Pressure Tightness Especially suitable for leak tight castings.

Hot Tearing Castings in sand or chill moulds exhibit complete freedom for hot tearing.

Typical Pouring Temperature A typical temperature for sand and chill castings is 725oC but in practice it may range considerably above or below this value according to the dimensions of the casting. Pouring Temperatures for die castings depend very largely on the particular casting and the machine and vary too widely for a typical temperature to provide useful guidance. The melt should not, however, be allowed to stand at temperatures only a little above the freezing range or the bottom of the melt may become enriched in such elements as iron and manganese.

Notes

For sand castings and medium and heavy section chill castings the alloy must be modified before pouring (by treatment with sodium or sodium salts. If the maximum mechanical properties are to be realised. An alternative modifying process is the treatment of the melt with strontium as an aluminium-silicon-strontium hardener. A more persistent state of modification is achieved by this method.

HEAT TREATMENT

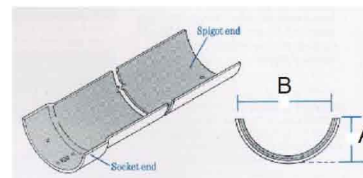
Ductility can be improved slightly by heating at 250-300oC, but apart from stress relieving, the heat treatment of LM6 is of little industrial interest.

APPLICATION AND GENERAL NOTES

Suitable for Marine 'on deck' castings, water-cooled manifolds and jackets, motor car and road transport fittings; thin section and intricate castings such as housing, meter cases and switchboxes; for very large castings, e.g. cast doors and panels where ease of casting is essential; for chemical and dye industry castings, e.g. pump parts; for paint industry and food and domestic castings. The general use where marine atmospheres or service conditions make corrosion resistance a matter of major importance. Especially suitable for castings that are to be welded. The ductility of LM6 alloy enable castings easily to be rectified or even modified in shape, e.g. simple components may be cast straight and later bent to the required contour. Equally adaptable for sand and permanent mould castings.

The aluminium silicon alloys possess exceptional casting characteristics, which enable them to be used to produce intricate castings of thick and thin sections. Fluidity and freedom from hot tearing increase with silicon content and are excellent throughout the range. Their resistance to corrosion is very good, but special care is required in machining. In general, the binary alloys are not heat treated; at elevated temperatures their strength falls rapidly. Although of medium strength their hardness and elastic limit are low but they possess excellent ductility.

Product specification data sheet: Half Round Cast Aluminium Gutters



HALF ROUND GUTTER 6FT LENGTH

Ref.	Effective Length	A	B
ACC4/-	1.8mtrs	47	108
ACC5/-	1.8mtrs	56	133
ACC6/-	1.8mtrs	63	154

Aluminium profiles are cast from the commercial grade of aluminium alloy LM6 complying with:

BS1474 - BS EN 12020-2:2001 / BS EN 755-9:2001

Paint finishes (Polyester Powder Coatings):

Aluminium profiles can be dual colour polyester powder coated to BS6496. AMS offers in house painting with the following paint suppliers:

Azko Nobel Interpon D,

Du Pont Alesia,

Beckers Powder

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Product specification data sheet: Half round cast aluminium gutters

MANUFACTURER:

ALU-CAST ENTREPRISES LTD
Unit 2 - Corbally Industrial Estate, Kanturk, Co. Cork
tel: 029-50234/0872550340
fax: 029-51226
email: info@alucast.
web: www.alucast.ie

PRODUCT:

Half round cast aluminium gutter (1.8mtr length)

PRODUCT CODE:

ACC4/- , ACC5/- , ACC6/-

MATERIAL:

Aluminium profiles cast from the commercial grade of aluminium alloy LM6

GAUGE:

4.0mm wall thickness

CAPACITY:

4" =0.78 litres/sec, 5" =1.10 litres/sec, 6" =1.37 litres/sec (The flow capacity of ALU-CAST gutters are based on a rainfall rate of 75mm/hr, the gutter being laid nominally level. Our figures are based on an end outlet position.)

FINISH:

Mill Finish or Polyester Powder Coated (BS EN12206-1: 2004) to selected RAL colour

FIXING METHOD:

Fascia Brackets at maximum 1.0m centres.
2 no fixings(No.5x50mm twin threaded stainless screw) per bracket
Wet sealed and bolted joinings held with bolt,washer,nut
Easy installation with spigot head

ACCESSORIES:

Angles, Outlets, Stop Ends to be supplied by same Manufacturer.

*Materials to be installed strictly in accordance with manufacturer's instructions