

Suffix letters indicate the condition of castings:-

BRITISH	AMERICAN	FRENCH		
		SAND	DIE	
M	F	Y20	Y30	As Cast
TE	T51			Precipitation treated
TB	T4	Y24	Y34	Solution treated
TB7	T7	Y26	Y36	Solution treated, stabilized
TF	T6	Y23	Y33	Solution and precipitation treated
TF7				Fully heat treated and stabilized
TS	O	Y25	Y35	Stress Relieved
		Y29	Y39	

HEAT TREATMENT TIMES AND TEMPERATURES					
B.S 1490 SPECIFICATION	SOLUTION TREATMENT				
	PRECIPITATION				
	TIME <sup>1</sup> (h)	TEMP (C)	QUENCH <sup>2</sup>	TIME <sup>2</sup> (h)	TEMP (C)
LM4 (TF)	6-16	505-520	HOT WATER	6-18	150-170
LM13 (TE)	-	-	-	4-16	160-180
LM16 (TF)	12	520-530	HOT WATER	8-10	160-170
LM22 (TB)	6-9	515-530	HOT WATER	-	-
LM25 (TE)	-	-	-	8-12	155-175
LM25 (TB7)	4-12	525-545	HOT WATER	2-4	250
LM25 (TF)	4-12	525-545	HOT WATER	8-12	155-175
A356 (T6)	4-12	540	HOT WATER	3-5	155
A357 (T61)	10-12	540	HOT WATER	10-12	155