



Designation: B793 – 16 (Reapproved 2021)

Standard Specification for Zinc Casting Alloy Ingot for Sheet Metal Forming Dies and Plastic Injection Molds¹

This standard is issued under the fixed designation B793; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers commercial zinc alloys in ingot form for remelting for the manufacture of dies and molds from the alloys as shown in [Table 1](#).

1.2 This specification presents requirements for zinc alloys suitable for the production of sand cast or plaster cast forming dies for sheet metal stamping operations and plastic injection molding. Alloy A is intended for use in the fabrication of dies for sheet metal stamping under drop hammer and hydraulic pressure. Alloy B is a special purpose alloy of closely controlled composition and is primarily used in the manufacture of plastic injection molds.

1.3 This specification covers two zinc alloys which are specified and designated as follows:

UNS	ASTM	Traditional
Z35543	Alloy A	Kirkosite A
Z35542	Alloy B	Kirkosite B

1.4 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to become familiar with all hazards including those identified in the appropriate Safety Data Sheet (SDS) for this product/material as provided by the manufacturer, to establish appropriate safety, health, and environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.04 on Zinc and Cadmium.

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2. Referenced Documents

2.1 The following documents of the issue in effect on date of order acceptance form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*²

[B897 Specification for Configuration of Zinc and Zinc Alloy Jumbo, Block, Half Block, and Slab Ingot](#)

[B899 Terminology Relating to Non-ferrous Metals and Alloys](#)

[B908 Practice for the Use of Color Codes for Zinc Casting Alloy Ingot](#)

[B949 Specification for General Requirements for Zinc and Zinc Alloy Products](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

[E88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

[E536 Test Methods for Chemical Analysis of Zinc and Zinc Alloys](#)

2.3 *ISO Standards:*³

[ISO 3815-1 Zinc and zinc alloys—Part 1: Analysis of solid samples by optical emission spectrometry](#)

[ISO 3815-2 Zinc and zinc alloys—Part 2: Analysis by inductively coupled plasma optical emission spectrometry](#)

3. Terminology

3.1 Terms shall be defined in accordance with Terminology [B899](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *Kirkosite, n*—a common trade name for aluminum-copper-magnesium alloys, Kirkosite A and Kirkosite B, used to produce, among other things, sheet metal forming dies.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.