

DIN EN 12420:2024-12 (E)

Copper and copper alloys - Forgings

| Contents | | Page |
|-----------------|---|-------------|
| | European foreword | 4 |
| | Introduction | 6 |
| 1 | Scope | 7 |
| 2 | Normative references | 7 |
| 3 | Terms and definitions | 7 |
| 4 | Designations | 8 |
| 4.1 | Material | 8 |
| 4.1.1 | General | 8 |
| 4.1.2 | Symbol | 8 |
| 4.1.3 | Number | 8 |
| 4.2 | Material condition | 8 |
| 4.3 | Product | 9 |
| 5 | Ordering information | 10 |
| 6 | Requirements | 11 |
| 6.1 | Composition | 11 |
| 6.2 | Mechanical properties | 11 |
| 6.2.1 | Hardness properties | 11 |
| 6.2.2 | Tensile properties | 11 |
| 6.3 | Electrical properties | 11 |
| 6.4 | Resistance to dezincification | 11 |
| 6.5 | Residual stress level | 11 |
| 6.6 | Tolerances for die forgings | 12 |
| 6.6.1 | General | 12 |
| 6.6.2 | Tolerances for dimensions within the die cavity and for dimensions across the die parting line | 13 |
| 6.6.3 | Mismatch | 13 |
| 6.6.4 | Flash projection | 14 |
| 6.6.5 | Ejector marks | 15 |
| 6.6.6 | Flatness tolerances | 15 |
| 6.6.7 | Angular tolerances | 16 |
| 6.7 | Tolerances for cored forgings | 16 |
| 6.8 | Tolerances for hand forgings | 18 |
| 6.8.1 | General | 18 |
| 6.8.2 | Tolerances on dimensions | 18 |
| 6.8.3 | Flatness tolerance | 19 |
| 6.8.4 | Surface quality | 19 |
| 6.8.5 | Drawings | 19 |
| 7 | Sampling | 19 |
| 7.1 | General | 19 |
| 7.2 | Analysis | 19 |
| 7.3 | Hardness, stress corrosion resistance, dezincification resistance and electrical property tests | 20 |
| 8 | Test methods | 20 |

| | | |
|---|--|-----------|
| 8.1 | Analysis | 20 |
| 8.2 | Hardness test | 20 |
| 8.3 | Electrical conductivity test | 20 |
| 8.4 | Dezincification resistance test | 20 |
| 8.5 | Stress corrosion resistance test | 20 |
| 8.6 | Retests | 21 |
| 8.6.1 | Analysis, hardness, electrical conductivity and dezincification resistance tests | 21 |
| 8.6.2 | Stress corrosion resistance test | 21 |
| 8.7 | Rounding of results | 21 |
| 9 | Certificate of compliance and inspection documentation | 21 |
| 9.1 | Certificate of compliance | 21 |
| 9.2 | Inspection documentation | 21 |
| 10 | Marking, labelling, packaging | 22 |
| Annex A (informative) Recommended guidelines for design | | 41 |
| A.1 | Introduction | 41 |
| A.2 | General information | 41 |
| A.3 | Guidelines for die forgings | 42 |
| A.3.1 | Drafts | 42 |
| A.3.2 | Web thicknesses | 42 |
| A.3.3 | Side wall thicknesses | 43 |
| A.3.4 | Rib design | 44 |
| A.3.5 | Cores | 45 |
| A.3.6 | Flash | 46 |
| A.3.7 | Transition radii | 47 |
| A.3.8 | Clamping lengths and clamping areas for finish machining | 49 |
| A.3.9 | Design for cross-sectional shapes | 49 |
| A.3.10 | Recommended machining allowances and total allowances | 50 |
| A.4 | Guidelines for hand forgings | 52 |
| A.4.1 | General | 52 |
| A.4.2 | General information | 52 |
| A.4.3 | Section changes and transitions | 53 |
| A.4.4 | Recommended machining allowances | 53 |
| A.4.5 | Total allowances per side of forging | 54 |
| A.5 | Guidelines for marking | 55 |
| Annex B (informative) Tensile properties | | 56 |
| Annex ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2014/68/EU (Pressure equipment Directive) aimed to be covered | | 60 |
| Bibliography | | 61 |