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Aluminum Sand & Permanent Mold Castings Recommended Heat Treatments

Alloy	Temper	Product	Solution Heat Treatment		Aging Treatment	
			Metal Temps ± 10° F	Time (hours)	Metal Temps ± 10° F	Time (hours)
319	T5	S	-	-	400	8
319	T6	S	940	12	310	4-6
319	T7	P	940	4-12	310	1-8
355	T71	S or P	-	-	440	7-9
355	T6	S	980	12	310	3-5
355	T62	S	980	12	440	3-5
355	T7	S	980	12	475	4-6
355	T71	P	980	4-12	310	2-5
355	T6	P	980	4-12	340	14-18
355	T61	P	980	4-12	440	3-9
355	T51	P	980	4-12	475	3-6
C355	T6	S	980	12	310	3-5
C355	T61	P	980	6-12	Room Temp then 310	8 minimum 10-12
356	T51	S or P	-	-	440	7-9
356	T6	S	1000	12	310	3-5
356	T7	S	1000	12	400	3-5
356	T71	S	1000	10-12	475	3
356	T6	P	1000	4-12	310	2-5
356	T7	P	1000	4-12	440	7-9
356	T71	P	1000	4-12	475	3-6
A356	T6	S	1000	12	310	3-5
A3560	T61	P	1000	6-12	Room Temp then 310	8 minimum 6-12
357	T6	P	1000	8		
713	T5	Sand Cast	-	-	315 Room Temp	6-8 21 days