

Datasheet: EN CuZn40Pb2 / CW617N Brass with Lead Rods for free machining purposes Alumeco ApS 06-05-2025				Internal alloy name: CW617N Metal: Brass Chemical Symbol: CuZn40Pb2 EN: EN CuZn40Pb2 UNS: C38000 SIS: SS 5168 GB: - JIS: C3561 Also known as: - Alloy type: Brass with lead				
Main usage: • Sanitary, heating and industrial fixtures • Machined parts, screws, gears, nuts and bolts • Components for watches, glass hinges, bike valves • Furniture fittings				Important norms and literature: General Standards EN 12164:2024: Copper and copper alloys – Rod for free machining purposes Geometric Tolerance EN 12164:2024: Copper and copper alloys – Rod for free machining purposes EN 12165:2024: Copper and copper alloys – Wrought and unwrought forging stock				
Main properties: • Excellent machinability • Great hot formability properties • Lower lead content compared to CW614N • Contact with drinking water								
Chemical composition in %: EN 12164:2024								
Cu	Al	As	Fe	Ni	Pb	Sn	Zn	Others
57,0 – 59,0	Max. 0,05	-	Max. 0,3	Max. 0,3	1,6 – 2,5	Max. 0,3	Remaining	Max. 0,2
Mechanical properties: EN 12164/12165								
Material Condition	Diameter / Bar thickness	Width across flats	Tensile Strength Rm	0,2% Proof Strength Rp _{0,2}	Elongation		Hardness HBW	Tolerance Class
	mm	mm	MPa	MPa	A _{11,3} % Min.	A % Min.		
≤ 80 mm Rods: EN 12164								
R360	6 – 80	5 – 60	360	Max. 350	15	20	-	B
H090	6 – 80	5 – 60	-	-	-	-	90 – 125	
R430	2 – 60	2 – 40	430	Min. 220	10	10	-	
H110	2 – 60	2 – 40	-	-	-	-	110 – 160	
R500	2 - 14	2 - 10	500	Min. 350	5	5	-	
H135	2 - 14	2 - 10	-	-	-	-	Min. 135	
> 80 mm Rods: EN 12165								
M	80 < D	-	-	-	-	-	-	A
* Information values only;								
Physical properties:								
Density (20 °C)	Solidification range	Electrical conductivity	Thermal conductivity (20 °C)	Thermal expansion (20 - 300 °C)	Annealing temperature	E – modulus (20 °C)		
g/cm ³	°C	%IACS	W/m K	µm m ⁻¹ K ⁻¹	°C	N / mm ²		
8,44	880	28	123	21,4	450 - 600	97000		
Properties and information's (3 Excellent; 2 Good; 1 Poor/not recommendable)								
Machinability (Zerspanbarkeitsindex): 95* *(CuZn39Pb3 = 100)			Joining Methods: Soldering: 3 Brazing: 2 Oxy-acetylene welding: 1 Gas-shielded arc welding: 1 TIG welding: 1 MIG welding: 1 Gluing/adhesion: 1-2			Surface Treatment: Polishing: Mechanical: 2-3 Electrolytic/chemical: 1 Galvanizing: 2-3 Hot Dipping: 2-3		
Forming Methods: Hot Formability: 2 Cold Formability: 1								
Corrosion resistance: Atmosphere: 2 Waters and alkaline: 1-2 Acids, Ammonia, Seawater etc.: 1								

Tolerances for Rods of CW617N

Dimensions: EN 12164:2024*		Dimensions in millimetres
Tolerances on diameter of round rod		
Nominal diameter	Tolerances Class B	
$2 \leq D \leq 3$	0	- 0,025
$3 < D \leq 6$	0	- 0,030
$6 < D \leq 10$	0	- 0,036
$10 < D \leq 18$	0	- 0,043
$18 < D \leq 30$	0	- 0,052
$30 < D \leq 50$	-	
$50 < D \leq 80$	-	

* Values are referred from Table 16 of EN 12164:2024

Dimensions: EN 12164:2024*		Dimensions in millimetres
Tolerances on width across-flats of regular polygonal rod		
Nominal width across-flats	Tolerances	
$2 \leq W \leq 3$	0	- 0,06
$3 < W \leq 6$	0	- 0,08
$6 < W \leq 10$	0	- 0,09
$10 < W \leq 18$	0	- 0,11
$18 < W \leq 30$	0	- 0,13
$30 < W \leq 50$	0	- 0,16
$50 < W \leq 60$	0	- 0,19

* Values are referred from Table 17 of EN 12164:2024

Dimensions: EN 12164:2024*		Dimensions in millimetres
Tolerances on straightness of rod		
Nominal diameter	Maximum deviation from straightness (See Figure 1 in EN 12164:2024)	
	h_2 depth of arch in any length l_2 of 400 mm	h_1 depth of arch in any length l_1 of 1000 mm
$10 \leq D \leq 50$	0,4	1,0

* Values are referred from Table 18 of EN 12164:2024

Dimensions: EN 12164:2024*		Dimensions in millimetres
Corner radii for square and polygonal rod		
Nominal diameter or width across-flats	Preferred lengths	Tolerance on length
$2 \leq w \leq 30$	3000 or 4000	± 50
$30 < w \leq 50$	3000 or 4000	± 100
$50 < w \leq 80$	3000	± 100

* Values are referred from Table 19 of EN 12164:2024

Dimensions: EN 12164:2024*		Dimensions in millimetres
Corner radii for square, hexagonal and octagonal rod		
Nominal width across-flats	Radii for sharp and rounded corners	
	Sharp max.	Rounded range
$2 \leq w \leq 3$	0,2	0,2 – 0,3
$3 < w \leq 6$	0,3	0,3 – 0,5
$6 < w \leq 10$	0,4	0,4 – 0,8
$10 < w \leq 18$	0,5	0,5 – 1,2
$18 < w \leq 30$	0,6	0,6 – 1,8
$30 < w \leq 50$	0,7	0,7 – 2,8
$50 < w \leq 80$	0,8	0,8 – 4,0

* Values are referred from Table 20 of EN 12164:2024

Dimensions: EN 12164:2024* Maximum twist of square, hexagonal and octagonal rod		Dimensions in millimetres
Nominal width across-flats W	Maximum permitted twist V in any 1 m length of rod (mm)	
$10 \leq W \leq 18$	1,0	
$18 < W \leq 30$	2,0	
$30 < W \leq 60$	3,0	

* Values are referred from Table 21 of EN 12164:2024

Dimensions: EN 12164:2024* Sampling rate	
Nominal diameter or width across-flats w (mm)	Mass of inspection lot for one test sample kg
$D/W \leq 25$	≤ 1000
$25 < D/W$	≤ 2000

* Values are referred from Table 22 of EN 12164:2024

Dimensions: EN 12165:2024* Tolerances on diameter of round forging stock		Dimensions in millimetres
Nominal diameter	Tolerances Class A	
$80 < D \leq 120$	± 2	
$120 < D \leq 160$	$\pm 2,5$	

* Values are referred from Table 10 of EN 12165:2024

Dimensions: EN 12165:2024* Tolerances on straightness of round forging stock			Dimensions in millimetres
Nominal diameter	Maximum deviation from straightness (See Figure 1 in EN 12164:2024)		
	h_2 depth of arch in any length l_2 of 400 mm	h_1 depth of arch in any length l_1 of 1000 mm	
Straightness tolerances for rods over 60 mm diameter shall be agreed between the involved parties			