

Standards:

Werkstoff	ASTM
1.2210	L2

Typical Analysis:

C	Cr	V
1.00%	0.55	0.10

Characteristics:

A hard, tough steel which will withstand great pressure and which will harden to a great depth.

Typical Applications:

- Cutting Dies
- Hammer Face and Blocks
- Stamping and Blanking Dies
- Drawing and Rivet Dies
- Pressing Dies
- Coining Dies

Stock Range:

Diameters	Metric: 2mm – 50mm Imperial: 3/32" – 1"
Length	333mm, 1000mm and 2000mm

HEAT TREATMENT

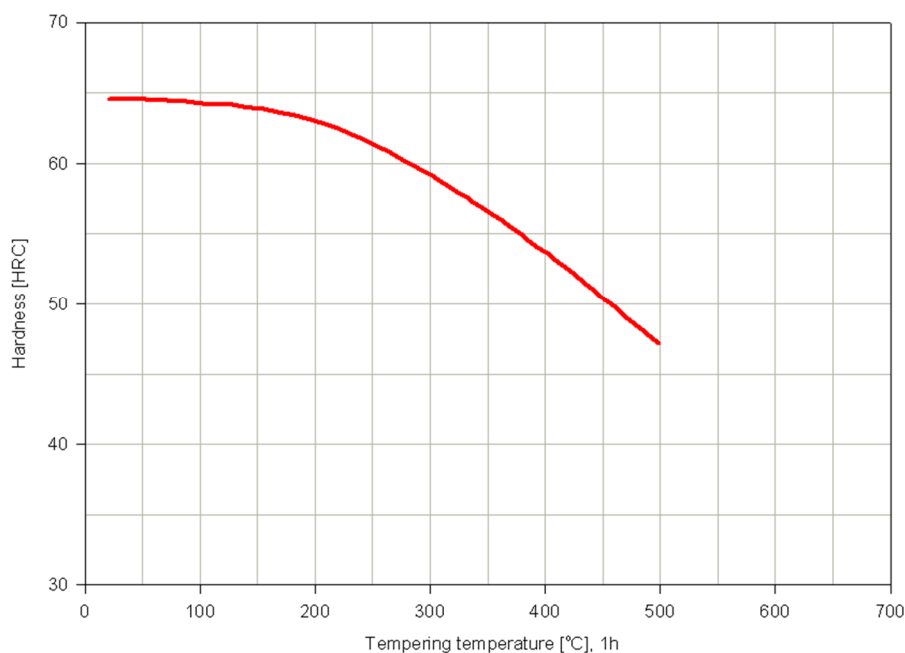
Forging. Heat slowly and thoroughly to 950/1050 degrees centigrade. Do not let heat fall below 800 degrees centigrade and reheat if necessary to finish work at the correct temperature.

Annealing. Heat slowly and evenly to 780/800 degrees centigrade for a period of four hours, and cool down slowly with furnace.

Stress Relieving. Heat carefully to 650/680 degrees centigrade, soak well and allow to cool carefully

Hardening. Heat uniformly to 780/790 degrees centigrade and quench in water. Where the shape and design of the die is an intricate one, oil quench at 820/850 degrees centigrade.

Tempering. Immediately after hardening temper according to the requirements of the job, and by reference to the tempering curve.



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