ASP®2060

Powder metallurgy HSS

zapp
TOOLING ALLOYS

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CHEMICAL COMPOSITION

C	Cr	Mo	W	Co	V
2.30	4.20	7.00	6.50	10.50	6.50

STANDARDS

- Europe: HS 6-7-6-10
- Germany: 1.3292

DELIVERY HARDNESS

Soft annealed max. 340 HB

DESCRIPTION

ASP®2060 is a very high alloyed grade for applications requiring both hot hardness and wear resistance.

APPLICATIONS

- Gear cutting tools
- Broaches
- Cold work tools
- Bearing & other Components
- Taps
- Drills
- End mills

FORM SUPPLIED

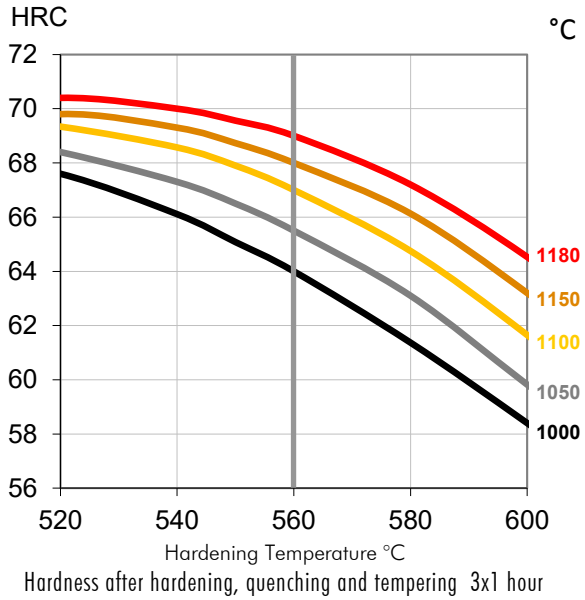
- Round bars
- Forged bars
- Flat & square bars
- Tool bit sections

Available surface conditions: drawn, ground, hot worked, peeled, rough machined.

HEAT TREATMENT

- Soft annealing in a protective atmosphere at 850-900°C for 3 hours, followed by slow cooling at 10°C/h down to 700°C, then air cooling.
- Stress-relieving at 600-700°C for approximately 2 hours, slow cooling down to 500°C.
- Hardening in a protective atmosphere at a temperature suitable for chosen working hardness. Pre-heating in 2 or 3 steps depending on tool dimension-design and austenetising temperature, last step 50°C below chosen austenitising temperature. Cooling down to 40-50°C.
- Tempering at 560°C three times for at least 1 hour each time. Cooling to room temperature (25°C) between temperings.

GUIDELINES FOR HARDENING



Hardness after hardening, quenching and tempering 3x1 hour

PROCESSING

ASP®2060 can be worked as follows:

- Machining (grinding, turning, milling)
- Polishing
- Plastic forming
- Electrical discharge machining
- Welding (special procedure including preheating and filler materials of base material composition).

GRINDING

During grinding, local heating of the surface, which may alter the temper, must be avoided. Grinding wheel manufacturers can furnish advice on the choice of grinding wheels.

SURFACE TREATMENT

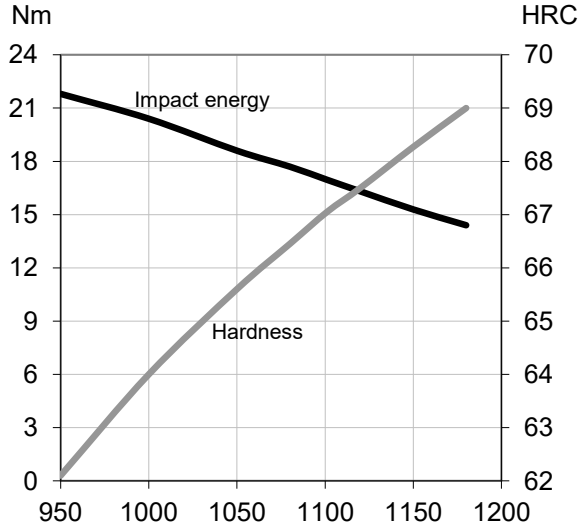
The steel grade is a good substrate material for PVD and CVD coating. If nitriding is requested a small zone of 2-15 µm is recommended. The steel grade can also be steam-tempered if so desired.

PHYSICAL PROPERTIES

Temperature	20°C	400°C	600°C
Density g /cm³ *(1)*	7.9	7.9	7.8
Modulus of elasticity kN/mm² *(2)*	250	222	200
Thermal expansion coefficient from 20°C per °C *(2)*	-	$10.6x10^{-6}$	$11.1x10^{-6}$
Thermal conductivity W/m°C *(2)*	24	28	27
Specific heat J/kg °C *(2)*	420	510	600

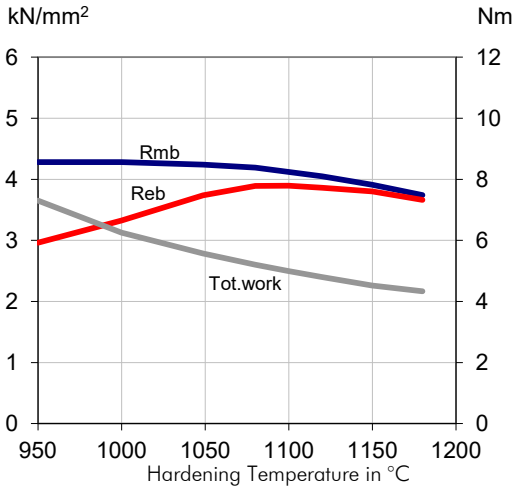
(1)=Soft annealed
(2)=Hardened 1180°C and tempered 560°C, 3x1 hour

IMPACT ENERGY



Original dimensions 9 x 12 mm
Tempering 3 x 1 hour at 560° C
Unnotched test piece 7 x 10 x 55 mm

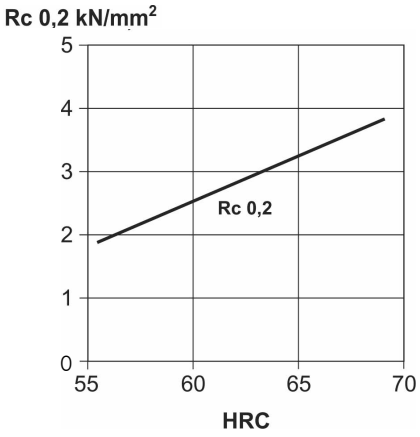
4-POINT BEND STRENGTH



Original dimensions Ø 6 mm
Tempering 3 x 1 hour at 560°C
Dimensions of test piece Ø 4.7 mm

Rmb = Ultimate bend strength in kN/mm²
Reb = Bend yield strength in kN/mm²
Tot. work = Total work in Nm

COMPRESSION YIELD STRESS



Test piece with 10 mm waist diameter

COMPARATIVE PROPERTIES