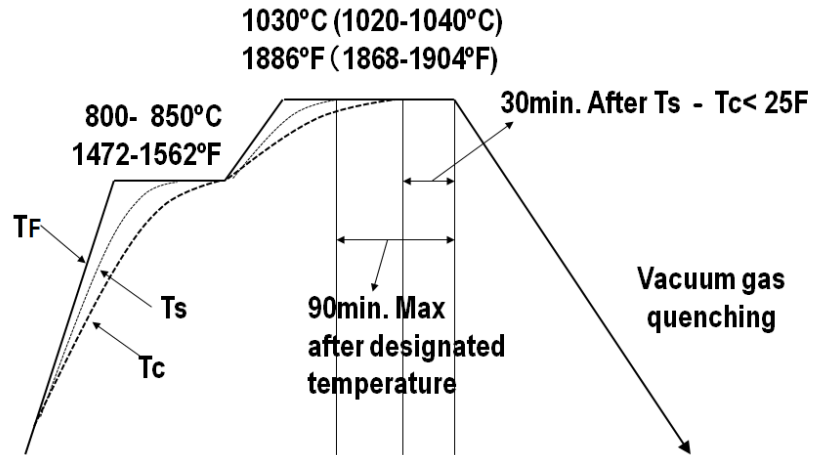


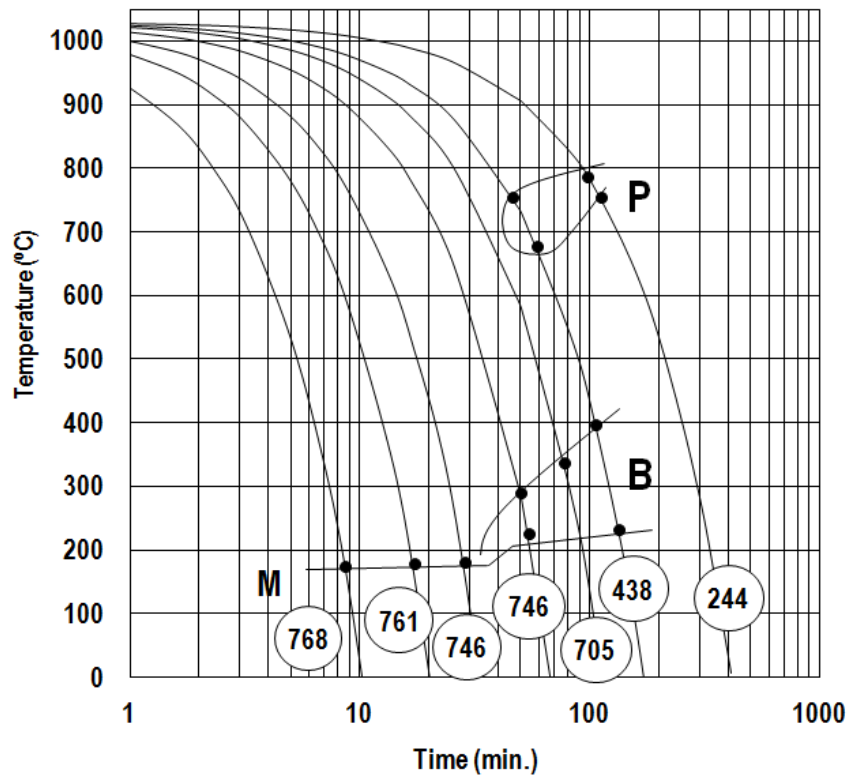
Heat treatment of DCMX

Quenching



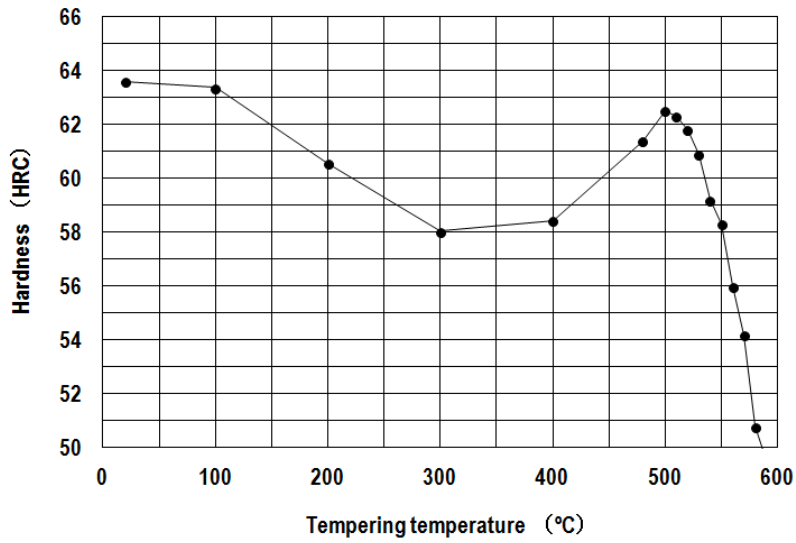
- Notes 1 Temperature for pre-heating and austenitizing is the same as that for D2.
- 2 Holding time shown here is general one. The standard for D2 is applicable for DCMX.
- 3 General gas quenching for D2 is applicable for DCMX as well by using 2 BAR quenching furnace. If the temperature measurement of actual dies is available, to cool down to 500°C (932°F) in 40min. is preferable.

CCT Curve



Tempering

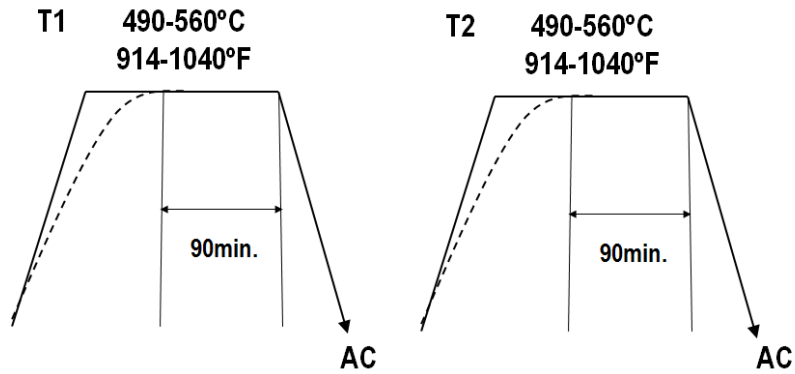
Tempering hardness curve



Double tempering at high temperature

Selection of tempering temperature

58/60 HRC	540°C (1004°F)
60/62 HRC	520°C (968°F)



Note. Holding time is decided by the type and the size of furnace used and the amount of the load of a batch. General holding time for D2 is applicable.

When dimensional change with time comes up as a problem, even if such small as 10–20 μm, additional tempering at 400°C (752°C) is recommended to prevent this problem.

