

HIGH SPEED STEELS

Available Product Variants

Long Products

Plates

Product Description

BÖHLER S393 MICROCLEAN – "Standardized"

This grade complies with the ASTM A600 AISI T15 material standard. With MICROCLEAN technology, this material shows excellent reliability in many cutting and cold-work applications.

Process Melting

Powder metallurgy

Properties

- > Toughness & Ductility : high
- > Wear Resistance : high
- > Compressive strength : very high
- > Edge Stability : very high
- > Grindability : high
- > Hot Hardness (red hardness) : very high

Applications

- > Broaches and Reamers
- > Fine Blanking, Stamping, Blanking
- > Rolling
- > Twist Drills and Taps
- > Cold Forming / Coining
- > Gear Cutting, Shaving and Shaping Tools
- > Shearing / Machine Knives
- > End Mills
- > Powder Pressing
- > Wear parts

Technical data

Material designation		Standards	
AISI: T15	AISI	A600	ASTM

Chemical composition (wt. %)

C	Cr	V	W	Co
1.65	4.0	4.90	12.40	5.0

Material characteristics

	Compressive strength	Grindability	Red hardness	Toughness	Wear resistance	Edge Stability
	★★★★★	★	★★★★	★★	★★★★★	★★★★
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	★★★	★★★	★★	★★★★	★★	★★★
	★★★	★★★	★★★★	★★★	★★★	★★★

Delivery condition

Annealed

Hardness (HB)	max. 300 drawn execution max. 320 HB
Tensile Strength (N/mm ² ksi)	max. 1,080 157

Heat treatment

Annealing

Temperature	870 to 900 °C 1,598 to 1,652 °F	4 h controlled slow cooling in furnace (10 - 20°C / (50 - 68°F) to 550°C / 2 h (1022°F / 2 h) cooling in furnace.
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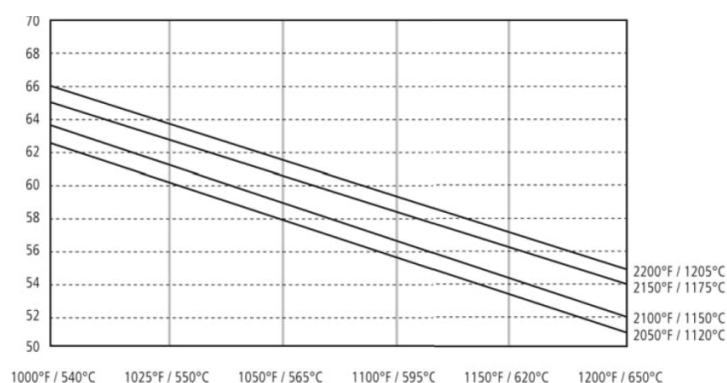
Stress relieving

Temperature	600 to 650 °C 1,112 to 1,202 °F	Slow cooling furnace. To relieve stresses set up by extensive machining or in tools of intricate shape. After through heating, hold in neutral atmosphere for 1 to 2 hours.
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Hardening and Tempering

Temperature	1,180 to 1,240 °C 2,156 to 2,264 °F	Salt bath, vacuum Preheating: 1st stage ~ 500 °C, 2nd stage ~ 850 °C, 3rd stage ~1050 °C Austenitising: 1180 - 1240 °C, holding time after complete heating 80 seconds, maximum 150 seconds, to avoid material damage due to overheating. Quenching: oil, warm bath (500 - 550 °C), gas
Temperature	540 to 570 °C 1,004 to 1,058 °F	Slow heating to tempering temperature immediately after austenitising. Dwell time in the furnace 1 hour per 20 mm material thickness (at least 1 hour) Slow cooling to room temperature between each tempering step 3 tempering cycles recommended Hardness see tempering chart

Tempering Chart



Physical Properties

Temperature (°C °F)	20 68
Density (kg/dm ³ lb/in ³)	8.19 0.3
Thermal conductivity (W/(m.K) BTU/ft h °F)	-
Specific heat (kJ/kg K BTU/lb °F)	-
Spec. electrical resistance (Ohm.mm ² /m 10 ⁻⁴ Ohm.inch ² /ft)	-
Modulus of elasticity (10 ³ N/mm ² 10 ³ ksi)	218 31.62

The data contained in this brochure is merely for general information and therefore shall not be binding on the company. We may be bound only through a contract explicitly stipulating such data as binding. Measurement data are laboratory values and can deviate from practical analyses. The manufacture of our products does not involve the use of substances detrimental to health or to the ozone layer.