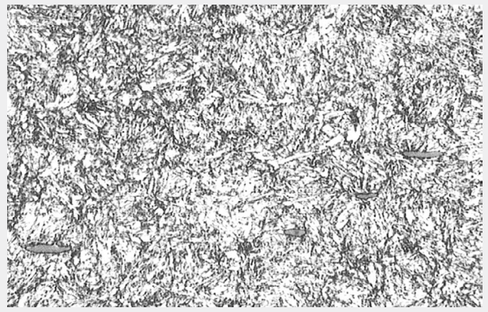
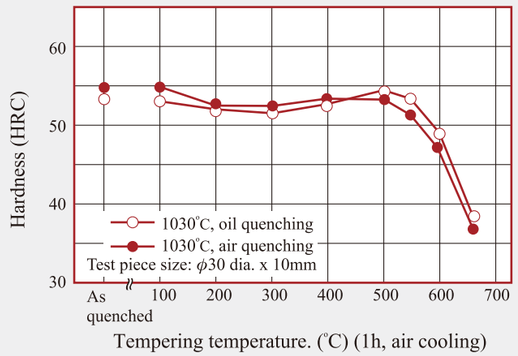
【 Microstructure 】



(x 400)

Quenching: 1030°C, air quenching
Tempering: 630°C x 1h
Hardness: 40HRC

【 Tempering curve 】



(The material as delivered does not require heat treating
This data is presented merely for reference.)

Chemical composition

Daido Brand	Chemical composition (%)						
	C	Si	Mn	Cr	Mo	V	Free-machining elements
DH2F	0.38	0.6	0.6	5.0	1.2	0.6	Added

Impurities: P ≦ 0.030%, Cu ≦ 0.25%, Ni ≦ 0.25%

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SC1814P(DDD)

DH2F

Modified SKD61 (H13) Prehardened to 40 HRC level
Free-machining Hot-forming Tool Steel

Features

1. Prehardened at 37-41 HRC. Without additional heat treating, HD2F is well suited for complex high-precision dies and parts susceptible to deformation.
2. Can be easily cut and milled because of good machinability.
3. Cuts die-making costs by reducing man-hours required for fabrication.
4. Surface treating gives DH2F enhanced abrasion and corrosion resistance.

Applications

Diecasting dies for aluminum and zinc, Diecast die parts, Plunger tips, sprue bushings,

Dies for plastics, Dies for aluminum extrusions, Press Dies, Dieplate strippers, Machine parts

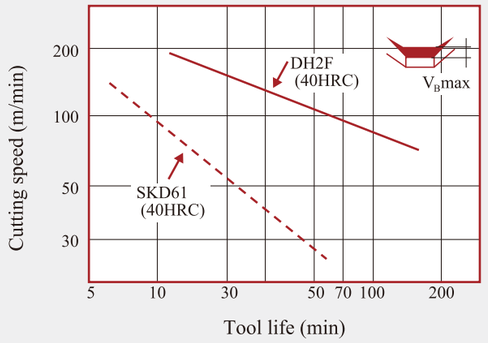
DAIDO STEEL

Quality characteristics

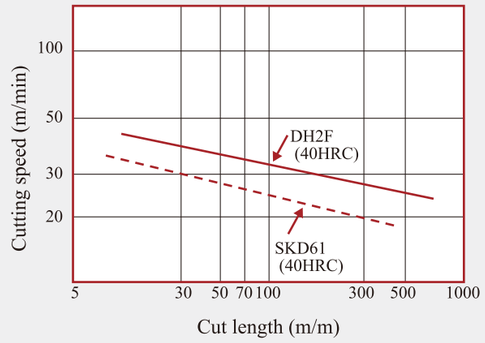
【 Machinability 】

● Good machinability raises productivity

● An example of tool life of face milling cutter



● An example of tool life of HSS drill bit



● Cutting parameters

Parameters / Tool	Tool material	Tool shape	Cutting fluid	Feed	Cut	Cutting speed (m/min)	Test piece size (mm)	Hardness (HRC)	Tool life and point
Face milling cutter	M20	NP-100R	None	0.075mm tooth	1.5mm	66~165	80^{W}x 50^{T}x 200^{l}	40	$V_B$max=0.3mm
Drill bit	SKH51	10mm dia. Tapered-shank drill $\alpha = 118^{o}$	None	0.1mm/rev	30mm deep hole	20~40	80^{W}x 50^{T}x 200^{l}	40	Tool erosion

【 Shape of chips 】

● DH2F (Modified SKD61 (H13) Prehardened)

● SKD61 (H13)

Cutting parameters:
Tool : SKH51, 10mm dia., tapered-shank drill $\alpha = 118^{o}$
Feed : 0.10mm/rev
Hele depth : 30mm
Cutting speed : 25m/min
Test piece hardness : 40HRC
Test piece size : 100 x 200 x 300mm

【 Wear resistance 】

● DH2F has better wear resistance than that of SKD61

Friction velocity (m/sec)	Wear amount (x $10^{-5}mm^3/J$)	
	DH2F	SKD61
0.20	3.84	3.57
0.51	5.34	5.67
0.94	3.57	5.34
1.63	3.60	5.34
1.97	4.12	5.34
2.38	4.12	5.34

Test machine : Ohgoshi method abrasion test apparatus
Friction distance : 200m
Final load : 3.3kg
Mating material (disk) : SKD11, 57HRC
Friction velocity : 0.2 to 2.4m/sec
Test piece hardness : 42HRC

【 Erosion resistance 】

Grade	Weight before test piece (g)	Weight after test piece (g)	Erosion loss	
			(g)	(%)
DH2F	27.33	23.18	4.15	15.2
SKD61	27.12	23.39	3.73	13.9

Erosion testing: An annealed 15mm dia. x 20mm sample is weighed before and after soaking in an aluminum bath at 700°C for 30 hours.

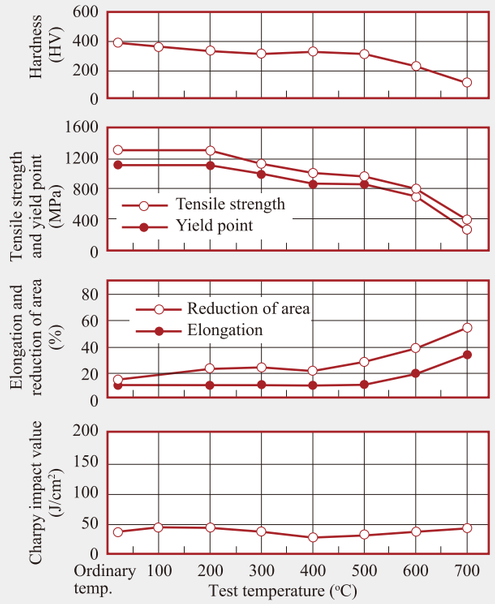
【 Coefficient of thermal expansion 】

● Average coefficient of thermal expansion for DH2F and SKD61

(x 10^{-6}/K)

Grade	20~100°C	20~200°C	20~300°C	20~400°	20~500°C	20~600°C	20~700°C
DH2F	8.9	10.8	11.9	12.6	13.1	13.7	13.9
SKD61	8.6	10.1	11.4	12.2	12.8	13.3	13.6

【 Mechanical properties 】



Test piece size
Tension test : 8mm dia. x 90mm
Charpy impact test : 2U Notched, rolling direction
Heat treatment
1030°C, air quenching
650°C, air cooling
40.5HRC