

DHA-HS1™

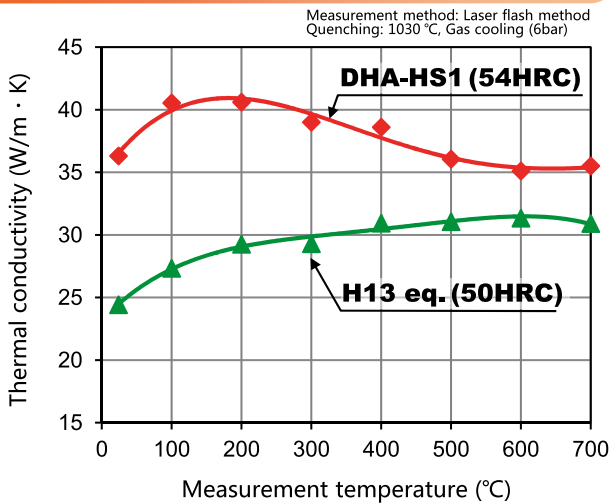
High thermal conductivity, High softening resistance
Hot Stamping Die Steel

Features

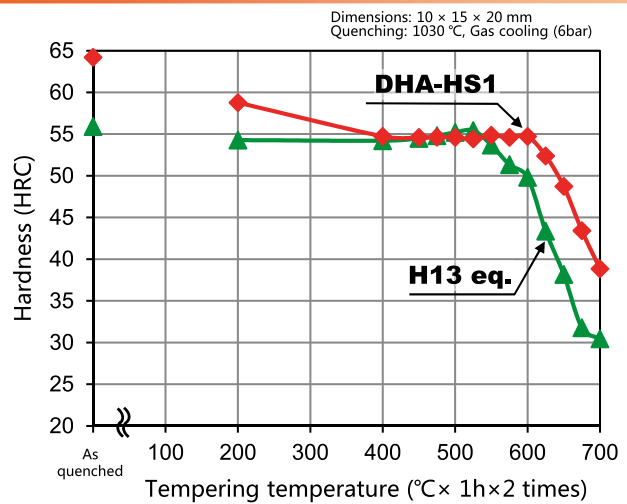
DHA-HS1 is “Hot stamping die steel”, which offers high thermal conductivity as well as excellent abrasion resistance at high temperatures. It contributes to increasing productivity and improving die life.

- ◆ **High thermal conductivity** : With high thermal conductivity of approx. **36(W/m·K)** at room temperature, DHA-HS1 helps reduce cooling time of dies and steel sheets.
- ◆ **High hardness** : Practical hardness of up to **54 HRC** is obtained at a wide range of tempering temperatures. Surface treatment also can be applied.
- ◆ **High softening resistance** : DHA-HS1 retains high hardness at elevated temperatures when in contact with hot steel sheets.

Thermal conductivity

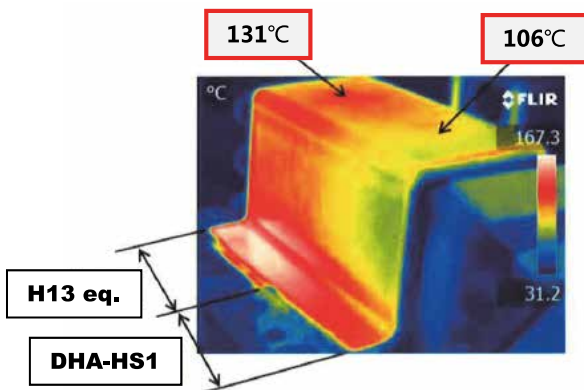


Quenching and tempering hardness

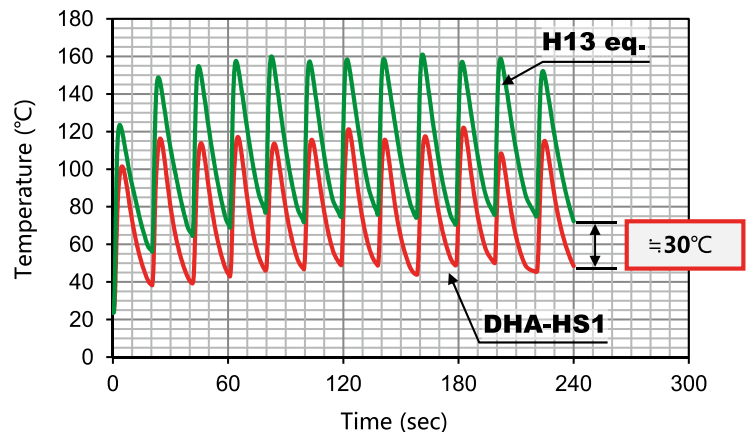


Test results by an actual hot stamping equipment

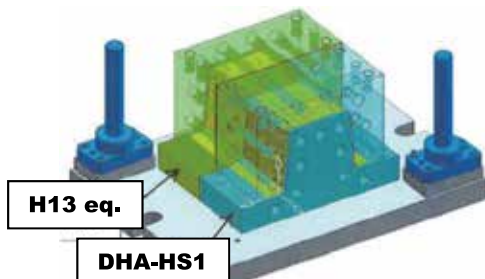
Panel temperature after the final shot



Die temperature during forming (Lower die)



Hot stamping test conditions



| | | |
|-------------|---|---|
| Forming | Forming cycle | 3.0 spm |
| | Holding time at the bottom dead center | 6.0 sec. |
| Heating | Temperature of steel sheet when forming process started | 850 °C |
| Quenching | Cooling water temperature | 18 °C |
| | Water line position | 10 mm from the die surface |
| Measurement | Thermocouple position | 5 mm from the die surface (Surface of lower die) |
| | | 5 mm from the water line |



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