

Powder metallurgy HSS ASP[®] 2052

CHEMICAL COMPOSITION

C	Cr	Mo	W	Co	V
1.60	4.8	2.0	10.5	8.0	5.0

STANDARDS

- Europe: HS 10-2-5-8

DELIVERY HARDNESS

Soft annealed max. 300 HB
Cold drawn max. 320 HB

DESCRIPTION

ASP 2052 is a high W-alloyed grade for high performance cutting tools.

APPLICATIONS

- End mills
- Shaper cutters
- Taps
- Hobs

FORM SUPPLIED

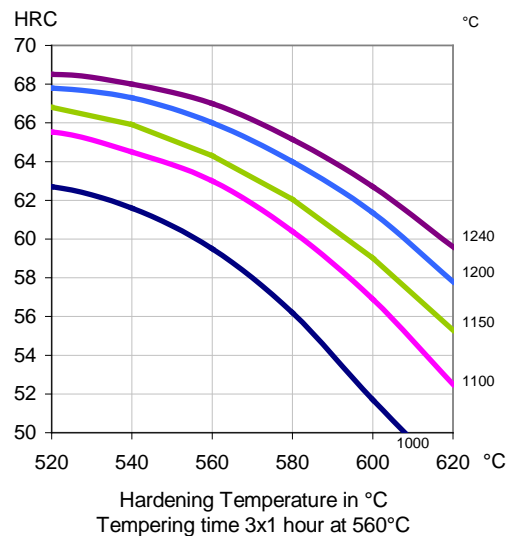
- Coils
- Round bars

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

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 with pre-heating in 2 steps at 450-500°C and 850-900°C and austenitising at a temperature suitable for chosen working hardness. 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



PROCESSING

ASP 2052 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.

PROPERTIES

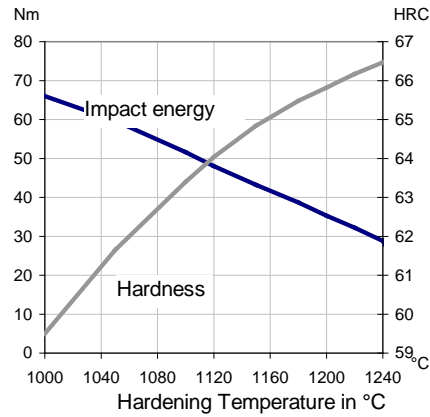
PHYSICAL PROPERTIES

	Temperature		
	20°C	400°C	600°C
Density g /cm ³ (1)	8.2	8.1	8.1
Modulus of elasticity kN/mm ² (2)	245	218	196
Thermal expansion ratio per °C (2)	-	11.2x10 ⁻⁶	11.7x10 ⁻⁶
Thermal conductivity W/m°C (2)	24	28	27
Specific heat J/kg °C (2)	420	510	600

(1)=Soft annealed

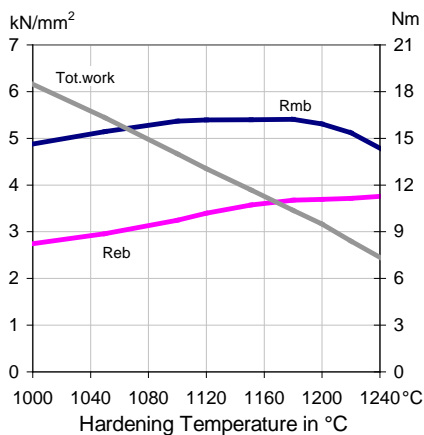
(2)=Hardened 1180°C and tempered 560°C, 3x1 hour

IMPACT STRENGTH



Original dimensions 70 x 15 mm
Tempering 3 x 1 hour at 560°C
Unnotched test piece 7 x 10 x 55 mm

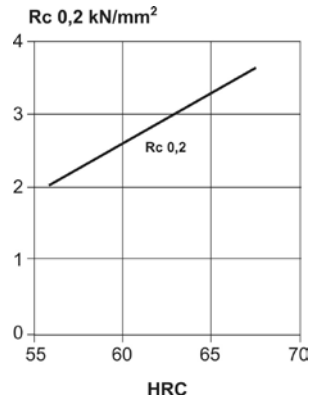
4-POINT BEND STRENGTH



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

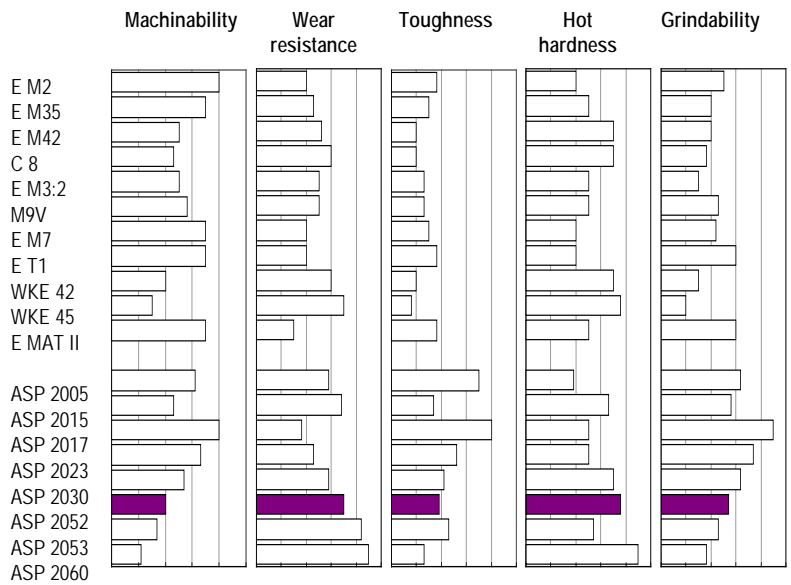
Rmb = Ultimate bend strength
in kN/mm²
 Reb = Bend yield strength
in kN/mm²
 Tot. work = Total work in Nm

COMPRESSION YIELD STRESS



Test piece : hour glass with 10 mm Ø waist

COMPARATIVE PROPERTIES



MATERIAL SAFETY DATA SHEET

MSDS: B