

DATA SHEET

HOT WORK TOOL STEEL

FINKL H13

HEAT TREATMENT

ANNEALING

Temperature: 1500-1550°F (816-843°C)
Rate of cooling: 25°F (14°C max per hour Typical)
annealed hardness: 187-223 BHN

Key parameter of the NADCA recommended procedure for hardening dies for die casting service are:

HARDENING

Rate of heating: slow
Preheat Temperature: 1200-1300°F (650-705°C)
Hardening Temperature: 1875-1895°F (1025-1035°C)
Time at temperature: 30-45 minutes
Quenching to 300°F (150°C)

TEMPERING

Tempering Temperature: 1050°F (565°C minimum)

STRESS RELIEVING

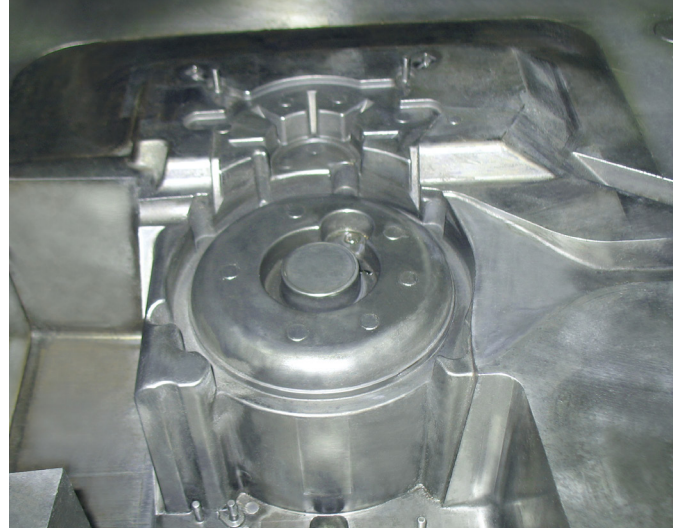
Temperature: 50-100°F (30-55°C below final tempering temperature and slow cool to 875°F (470°C, then air cool.

Note: Provided technical data and information in this data sheet are typical values. Normal variations in chemistry, size and conditions of heat treatment may cause deviations from these values. We suggest that information be verified at time of enquiry or order. For additional data or metallurgical assistance, please contact us.

SIZE

(L)Q(L)KHG/ approx.)

Max weight	16 330 kg	36 000 lbs
Max section	0.90 m ²	1 400 sq in
Max width	1 270 mm	50"
Max thickness	760 mm	30"



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