

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.

Classified according to EU Directive 1999/45/EC
For further information see our "Material Safety Data Sheets".

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The latest revised edition of this brochure is the English version, which is always published on our web site www.uddeholm.com



SS-EN ISO 9001
SS-EN ISO 14001

Critical tool steel properties

For good tool performance

- Correct hardness for the application
- High wear resistance
- Good toughness to prevent premature failure due to chipping/crack formation

High wear resistance is often associated with low toughness and vice-versa. However, in many cases both high wear resistance and toughness are essential for optimal tooling performance.

Uddeholm Toughtec SF is a spray formed tool steel offering a combination of excellent wear resistance and toughness.

For tool making

- Machinability
- Grindability
- Heat treatment
- Dimensional stability in heat treatment
- Surface treatment

Uddeholm Toughtec SF has a high wear resistance and this means that it is particularly important to use suitable cutting tools and cutting conditions. Similarly, suitable grinding wheels and grinding conditions should be used.

Due to the carefully balanced alloying Uddeholm Toughtec SF has a similar heat treatment procedure to the steel AISI D2.

One big advantage with Uddeholm Toughtec SF is that the dimensional stability after hardening is better than for the conventional produced cold work steels. This also means that Uddeholm Toughtec SF is a tool steel which is very suitable for various surface coating techniques.

Applications

Uddeholm Toughtec SF is suitable for medium run to long run tooling of work materials where mixed (abrasive-adhesive) or abrasive wear and/or chipping/cracking and/or plastic deformation are dominating failure mechanisms.

Examples:

- Screws and barrels for plastic processing
- Cold and hot forming rolls
- Hot shearing knives
- Circular slitting knives

- Hot forging trimming dies
- Wear parts
- Engineering applications

General

Uddeholm Toughtec SF is a chromium-molybdenum-vanadium alloyed tool steel which is characterized by:

- Very high wear resistance
- Very good toughness
- Good compressive strength
- Good dimensional stability at heat treatment and in service
- Very good through-hardening properties
- Very good resistance to tempering back
- Good WEDM properties
- Good surface treatment properties

Typical analysis %	C 1,6	Si 0,4	Mn 0,5	Cr 5,0	Mo 2,3	V 7,2
Standard specification	None					
Delivery condition	Soft annealed to approx. 215 HB					
Colour code	Green/brown					

Properties

Physical data

Hardened and tempered to 53 HRC

Temperature	20°C (70°F)	200°C (390°F)	400°C (750°F)
Density, kg/m ³ lbs/in ³	7 580 0,273	– –	– –
Modulus of elasticity MPa psi	212 000 30,8 × 10 ⁶	204 000 29,5 × 10 ⁶	193 000 28,0 × 10 ⁶
Coefficient of thermal expansion per °C from 20°C °F from 68°F	–	10,7 × 10 ⁻⁶ 5,9 × 10 ⁻⁶	11,5 × 10 ⁻⁶ 6,4 × 10 ⁻⁶
Thermal conductivity W/m°C Btu in (ft ² h°F)	–	23 160	26 180
Specific heat, J/kg °C Btu /lb °F	460 0,11	–	–

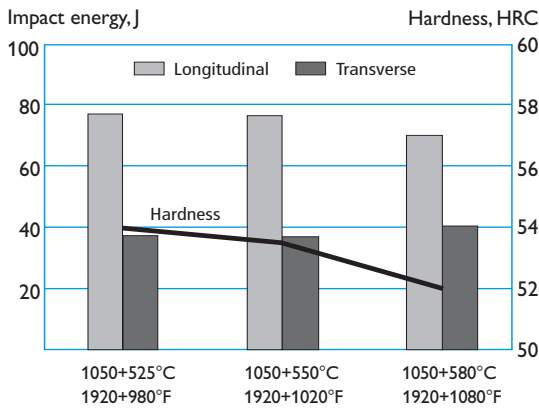
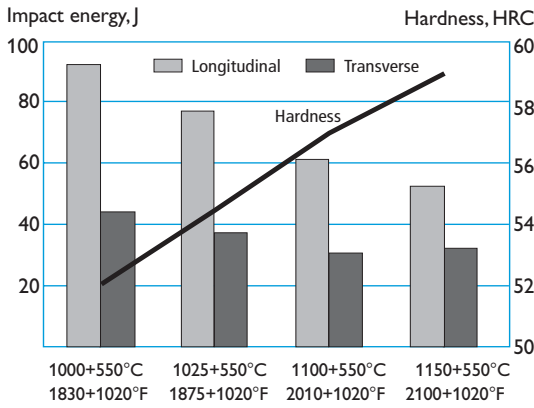
Compressive strength

Hardness, HRC	Compressive strength, Rc0,2 (MPa)
50	1 650
52	1 750
54	1 850
56	1 950
58	2 050
60	2 150

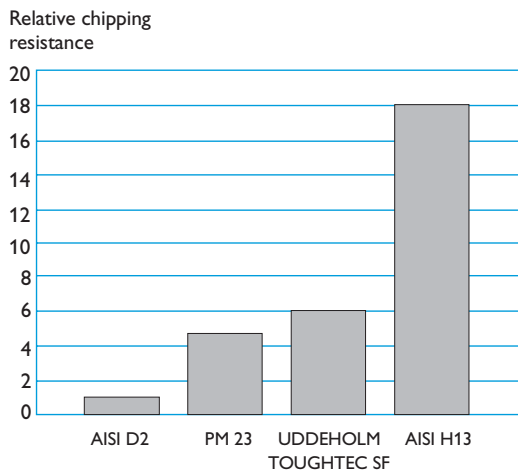
Impact strength

Approximate room temperature impact strength at different tempering temperatures. Specimen size: 7 x 10 x 55 mm (0,27 x 0,4 x 2,2") unnotched.

Hardened for 30 minutes, except at 1150°C (2100°F) where 10 minutes is used. Quenched in air. Tempered 2 x 2h.

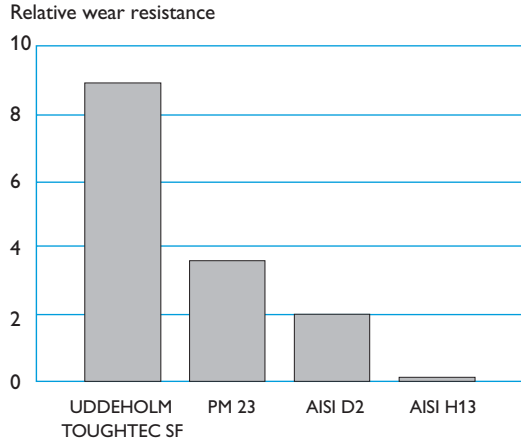


Relative chipping resistance for AISI D2, PM 23, Uddeholm Toughtec SF at 58 HR and AISI H13 at 52 HRC. High value indicates good ductility. High temperature tempered condition.



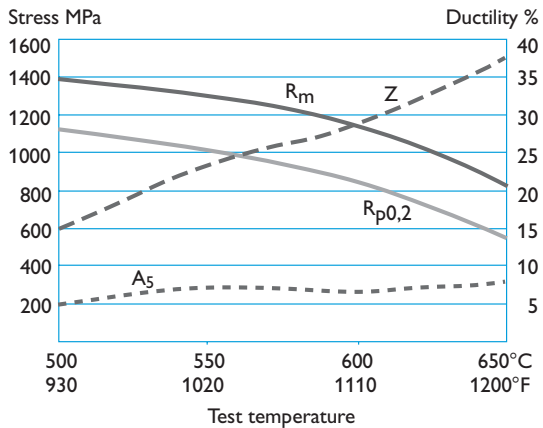
Wear resistance

Relative abrasive wear resistance for AISI D2, PM 23, Uddeholm Toughtec SF at 58 HRC and AISI H13 at 52 HRC. High value indicates good wear resistance. High temperature tempered condition.



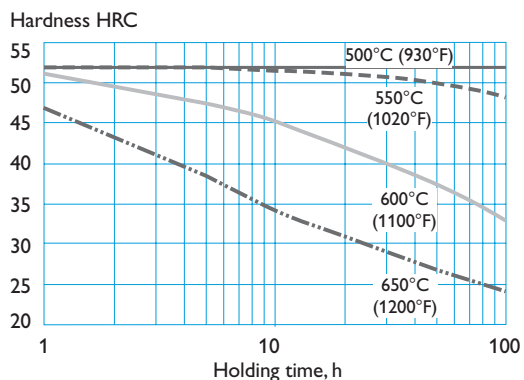
HOT STRENGTH

Hot strength in longitudinal direction. The specimens have been heat treated to 52 HRC, 1050°C (1920°F) + 580°C (1080°F), 2 x 2h.



EFFECT OF TIME AT HIGH TEMPERATURE ON HARDNESS

The softening at high temperatures and different holding times are shown below. The specimens have been heat treated to 52 HRC, 1050°C (1920°F) + 580°C (1080°F), 2 x 2h.



Heat treatment recommendations

Soft annealing

Protect the steel and heat through to 900°C (1650°F). Then cool in the furnace at 10°C (20°F) per hour to 650°C (1200°F), then freely in air.

Stress relieving

After rough machining the tool should be heated through to 650°C (1200°F), holding time 2 hours. Cool slowly to 500°C (930°F), then freely in air.

Hardening

Preheating in two stages: 600–650°C (1100–1200°F) and 900–950°C (1650–1740°F)
Austenitizing temperature: 1000–1150°C (1830–2100°F), normally 1050°C (1920°F).
Holding time: 30 min. for ≤1120°C (2050°F), 10 minutes for >1120°C (2050°F).

Protect the part against decarburization and oxidation during hardening.

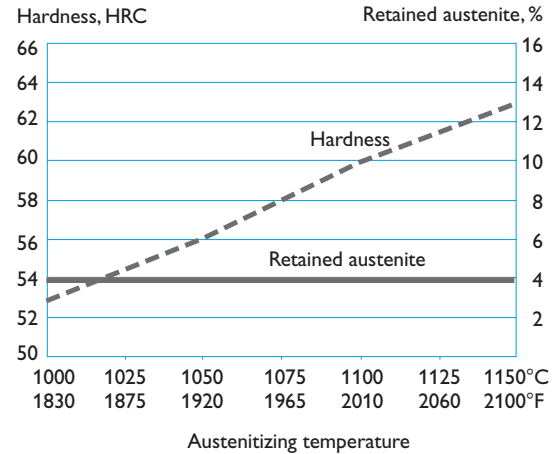
Quenching media

- High speed gas/circulating atmosphere
- Vacuum furnace (high speed gas with sufficient overpressure)
- Martempering bath or fluidized bed at 500–550°C (930–1020°F)
- Martempering bath or fluidized bed at approx. 200–350°C (390–660°F)

Note: Temper the tool as soon as its temperature reaches 50–70°C (120–160°F).

HARDNESS AND RETAINED AUSTENITE AS A FUNCTION OF AUSTENITIZING TEMPERATURE

10 minutes holding time at 1150°C (2100°F), else 30 minutes.



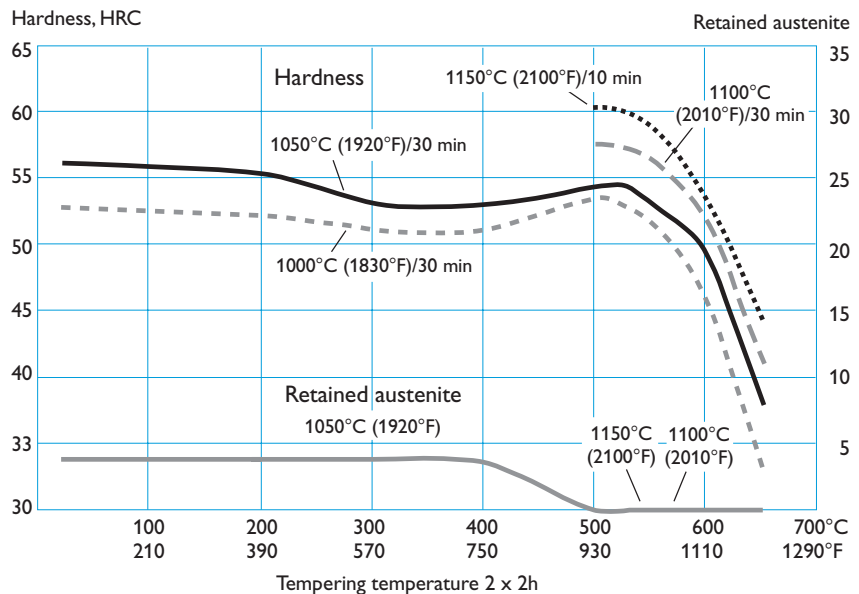
Tempering

Choose the tempering temperature according to the hardness required by reference to the tempering graph below.

Temper at least twice with intermediate cooling to room temperature. The lowest tempering temperature which should be used without deep cooling is 525°C (980°F) and with sub-zero treatment 500°C (930°F).

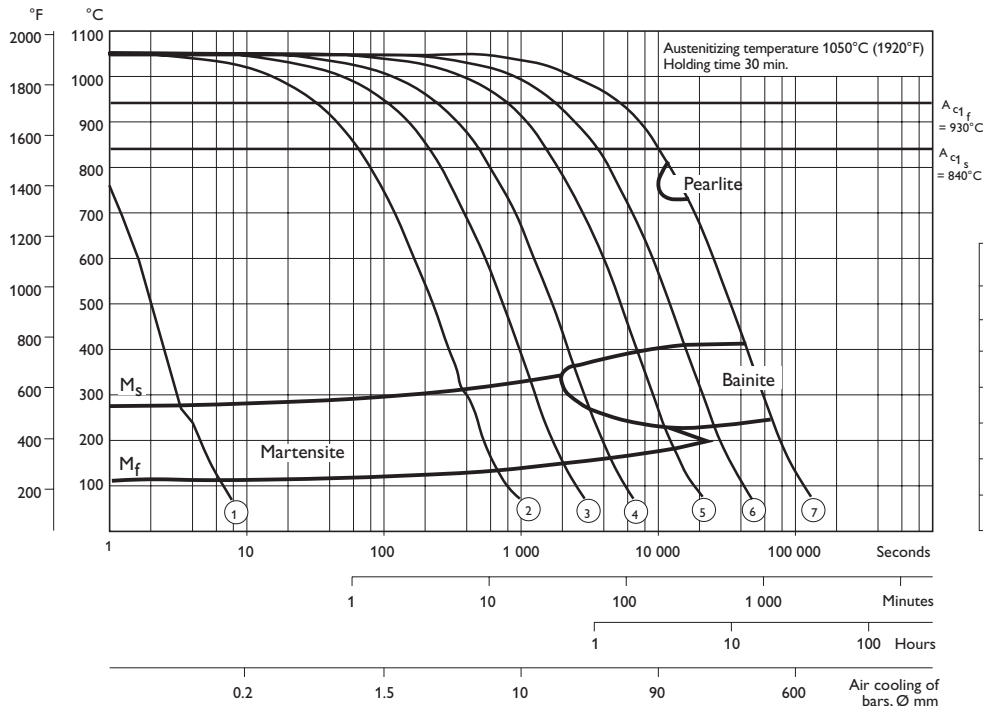
The minimum holding time at temperature is 2 hours.

TEMPERING GRAPH WITHOUT SUB-ZERO TREATMENT AFTER HARDENING



CCT-GRAPH

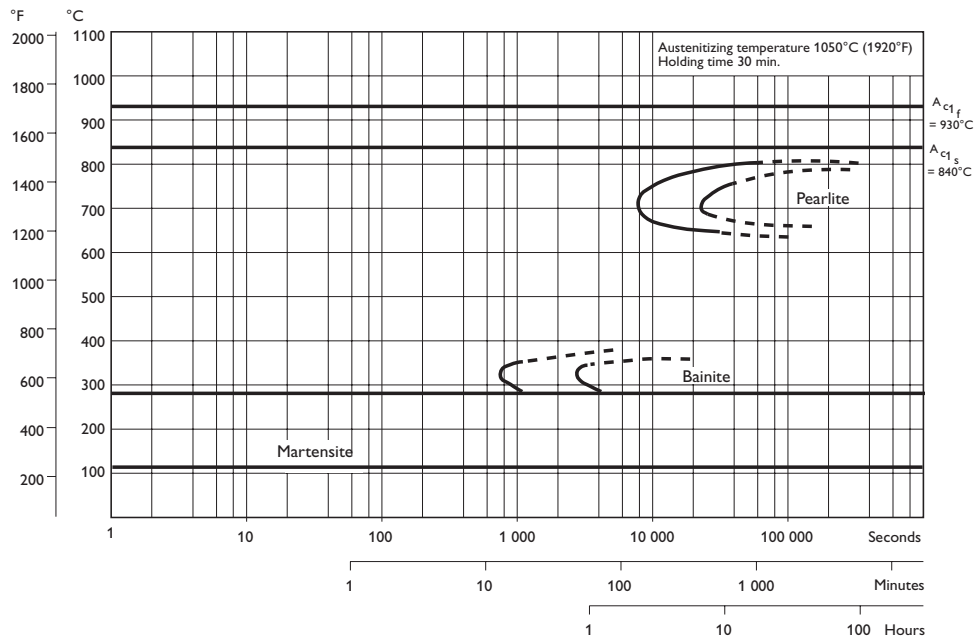
Austenitizing temperature 1050°C (1920°F). Holding time 30 minutes.



Cooling Curve No.	Hardness HV 10	T 800-500
1	681	1
2	634	140
3	592	450
4	572	1030
5	536	3205
6	514	7370
7	483	20800

TTT-GRAPH

Austenitizing temperature 1050°C (1920°F). Holding time 30 minutes.



Temp. °C	Time hours	Hardn. HV 10
800	23,0	488
750	23,0	193
700	7,0	266
650	23,4	433
425	15,5	707
375	14,9	681
350	1,5	743
325	15,1	585

Sub-zero treatment

Tools requiring maximum dimensional stability in service can be sub-zero treated as follows:

Immediately after quenching, the tool should be sub-zero treated to -70 to -80°C (-95 to -110°F), soaking time 1–3 hours, followed by tempering.

The sub-zero treatment leads to a reduction of retained austenite content. This, in turn, will result in a hardness increase of ~1 HRC in comparison to not sub-zero treated tools if low temperature tempering is used. For high temperature tempered tools there will be no hardness increase and when referencing the

normal tempering curves, a 25 to 50°C (45 to 90°F) lower tempering temperature should be chosen to achieve the required hardness.

Tools that are high temperature tempered, even without a sub-zero treatment, will have a low retained austenite content and in most cases, a sufficient dimensional stability.

However, for high demands on dimensional stability in service it is also recommended to use a sub-zero treatment in combination with high temperature tempering.

For the highest requirements on dimensional stability, sub-zero treatment in liquid nitrogen is recommended after quenching and after each tempering.

Dimensional changes

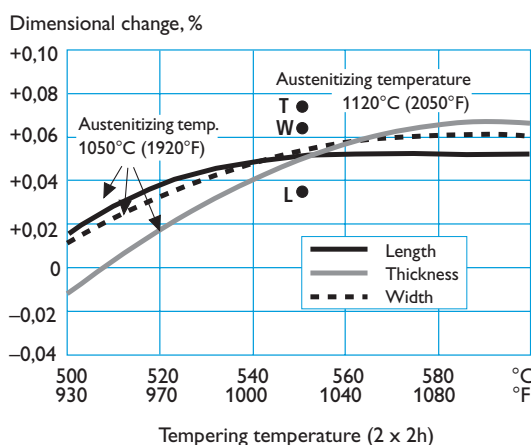
The dimensional changes have been measured after austenitizing and tempering.

Austenitizing: 1050°C (1920°F)/30 min or 1120°C (2050°F)/30 min, cooling in vacuum furnace at 1,1°C/s (1,8°F/s) between 800°C (1470°F) and 500°C (930°F)

Tempering: 2 x 2 h at various temperatures

Specimen size: 60 x 60 x 60 mm (2,4 x 2,4 x 2,4")

DIMENSIONAL CHANGES DURING HARDENING AND TEMPERING IN LENGTH, WIDTH AND THICKNESS DIRECTION



Surface treatments

Some tools are given a surface treatment in order to reduce friction and increase wear resistance. The most commonly used treatments are nitriding and surface coating with wear resistant layers produced via PVD or CVD.

The high hardness and toughness together with a good dimensional stability makes Uddeholm Toughtec SF ideal as a substrate steel for various surface coatings.

Nitriding

Nitriding gives a hard surface layer that is resistant to wear and erosion.

Uddeholm Toughtec SF is normally high temperature tempered at around 525°C (980°F). This means that the nitriding temperature used should not exceed 500–525°C (930–980°F).

Process	Time	Depth	
		mm	inch
Gas nitriding at 510°C (950°F)	10 h	0,15	0,0059
Plasma nitriding at 480°C (895°F)	10 h	0,10	0,0039
	30 h	0,20	0,0079

Ion nitriding at a temperature below the tempering temperature used is preferred.

The surface hardness after nitriding is approximately 1150 HV_{0,2kg}. The thickness of the layer should be chosen to suit the application in question.

PVD

Physical vapour deposition, PVD, is a method of applying a wear resistant coating at temperatures between 200–500°C (390–930°F).

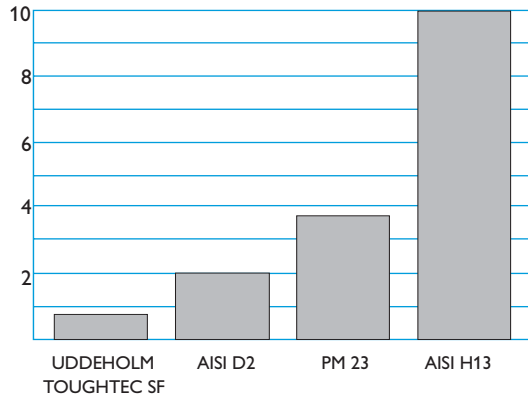
CVD

Chemical vapour deposition, CVD, is used for applying wear resistant surface coatings at a temperature approx. 1000°C (1830°F). It is recommended that the tools should be separately hardened and tempered in vacuum furnace after surface treatment.

Machinability

Relative machinability and grindability for Uddeholm Toughtec SF, AISI D2, PM 23 and AISI H13. High value indicates good machinability and grindability.

Relative machinability and grindability



Machining recommendations

The cutting data below are to be considered as guiding values which must be adapted to existing local conditions.

The cutting data recommendations, in following tables, are valid for Uddeholm Toughtec SF in soft annealed condition to approx 215 HB.

Turning

Cutting data parameters	Turning with carbide	
	Rough turning	Fine turning
Cutting speed v_c m/min. f.p.m.	70–100 230–330	100–120 330–395
Feed, f mm/rev. i.p.r.	0,2–0,4 0,008–0,016	0,1–0,2 0,004–0,008
Depth of cut, a_p mm inch	2–4 0,08–0,16	1–2 0,04–0,08
Carbide designation ISO	K15–K20*	K15–K20*

* Use a wear resistant Al_2O_3 -coated carbide

Milling

FACE AND SQUARE SHOULDER MILLING

Cutting data parameters	Milling with carbide	
	Rough milling	Fine milling
Cutting speed, v_c m/min. f.p.m.	40–100 130–330	80–110 260–360
Feed, f_z mm/tooth inch/tooth	0,2–0,4 0,008–0,016	0,1–0,2 0,003–0,008
Depth of cut, a_p mm inch	2–4 0,08–0,16	–2 –0,08
Carbide designation ISO	K20, P20*	K15, P15*

* Use a wear resistant Al_2O_3 -coated carbide

END MILLING

Cutting data parameters	Type of mill		
	Solid carbide	Carbide indexable insert	High speed steel
Cutting speed v_c m/min f.p.m.	30–40 100–130	70–100 230–330	3–5 ³⁾ 10–16 ³⁾
Feed f_z mm/tooth inch/tooth	0,03–0,2 ¹⁾ 0,001–0,008 ¹⁾	0,08–0,2 ¹⁾ 0,003–0,008 ¹⁾	0,05–0,35 ¹⁾ 0,002–0,014 ¹⁾
Carbide designation ISO	–	K15–K20 ²⁾	–

¹⁾ Depending on radial depth of cut and cutter diameter.

²⁾ Use a wear resistant Al_2O_3 -coated carbide

³⁾ For coated HSS end mills $v_c = 10–14$ m/min (33–46 f.p.m.)

Drilling

HIGH SPEED STEEL TWIST DRILL

Drill diameter		Cutting speed, v_c		Feed, f	
mm	inch	m/min.	f.p.m.	mm/r	i.p.r.
– 5	–3/16	8–10*	26–33*	0,05–0,10	0,002–0,004
5–10	3/16–3/8	8–10*	26–33*	0,10–0,20	0,004–0,008
10–15	3/8–5/8	8–10*	26–33*	0,20–0,25	0,008–0,010
15–20	5/8–3/4	8–10*	26–33*	0,25–0,30	0,010–0,012

* For coated HSS drills $v_c = 12–16$ m/min (39–52 f.p.m.)

CARBIDE DRILL

Cutting data parameters	Type of drill		
	Indexable insert	Solid carbide	Brazed carbide ¹⁾
Cutting speed, v_c m/min f.p.m.	80–100 260–330	40–60 130–200	30–40 100–130
Feed, f mm/r i.p.r.	0,05–0,15 ²⁾ 0,002–0,006 ²⁾	0,10–0,25 ²⁾ 0,004–0,010 ²⁾	0,15–0,25 ²⁾ 0,006–0,010 ²⁾

¹⁾ Drill with internal cooling channels and brazed tip

²⁾ Depending on drill diameter

Band sawing

Sawing of Uddeholm Toughtec SF should be carried out in a rigid band saw. The tooth pitch should be coarse.

The cutting speed should be low (approx. 20 m/min.) but the down feed high. Try to keep a feed rate of about 3–5 µm/tooth. Both bi-metal and carbide tipped band can be used.

Grinding

General grinding wheel recommendation is given below. More information can be found in the Uddeholm publication “Grinding of Tool Steel”.

Type of grinding	Annealed condition	Hardened condition
Face grinding straight wheel	B151 R50 B3 ¹⁾ A 46 HV ²⁾	B151 R50 B3 ¹⁾ A 46 GV ²⁾
Face grinding segments	A 36 GV	A 46 GV
Cylindrical grinding	B151 R50 B3 ¹⁾ A 60 KV ²⁾	B151 R50 B3 ¹⁾ A 60 KV ²⁾
Internal grinding	B151 R75 B3 ¹⁾ A 60 JV	B151 R75 B3 ¹⁾ A 60 IV
Profile grinding	B126 R100 B6 ¹⁾ A 100 JV ²⁾	B126 R100 B6 ¹⁾ A 100 IV ²⁾

¹⁾ The first choice is a CBN-wheel for this operation

²⁾ Preferable a wheel type containing sintered Al₂O₃ (seeded gel)

Welding and induction hardening

Welding

Small repair welds can, if absolutely necessary, be made on Uddeholm Toughtec SF, but it is not recommended. The weldability of Uddeholm Toughtec SF is similar to that of Uddeholm Sverker 21.

Induction hardening

Uddeholm Toughtec SF can be induction hardened.

Electrical-discharge machining—EDM

If EDM is performed in the hardened and tempered condition, finish with “fine-sparking”, i.e. low current, high frequency.

For optimal performance the EDM'd surface should be ground/polished and the tool re-tempered at approx. 25°C (50°F) lower than the original tempering temperature.

When EDM'ing larger sizes or complicated shapes Uddeholm Toughtec SF should be tempered at high temperatures, ≥525°C (980°F).

Relative comparison of Uddeholm tool steel

Material properties and resistance to failure mechanisms

Uddeholm grade	Hardness/ Resistance to plastic deformation	Machinability	Grindability	Dimension stability	Resistance to		Fatigue cracking resistance	
					Abrasive wear	Adhesive wear	Ductility/ resistance to chipping	Toughness/ gross cracking
TOUGHTEC SF	████	█	█	████	████	████	████	████
AISI D2	████	██	██	█	█	█	█	██
PM 23	████	████	████	████	██	████	████	██
PM 9%V	████	█	█	████	████	████	████	██

Further information

Please, contact your local Uddeholm office of further information on the selection, heat treatment, application and availability of Uddeholm tool steels.

The Sprayforming Metallurgy process

The sprayforming metallurgy process is a totally new and unique method for producing tool steel. In terms of the solidifying process, sprayforming is placed between powder metallurgy and ESR metallurgy.

In the sprayforming process melted steel is sprayed through a nozzle towards a rotating disc. The steel solidifies successively when the melt hits the rotating disc. The disc is slowly moved and a sprayformed ingot is built up. The ingot is forged and/or rolled by conventional methods to a finished steel bar.

The amount of steel melt that is successively solidified is larger than for powder metallurgy but significantly smaller than for ESR metallurgy. The structure in sprayformed tool steel is similar to that in powder metallurgy tool steel but with larger carbide size.

HEAT TREATMENT

Prior to delivery all of the different bar materials are subjected to a heat treatment operation, either as soft annealing or hardening and tempering. These operations provide the steel with the right balance between hardness and toughness.

MACHINING

Before the material is finished and put into stock, we also rough machine the bar profiles to required size and exact tolerances. In the lathe machining of large dimensions, the steel bar rotates against a stationary cutting tool. In peeling of smaller dimensions, the cutting tools revolve around the bar.

To safeguard our quality and guarantee the integrity of the tool steel we perform both surface- and ultrasonic inspections on all bars. We then remove the bar ends and any defects found during the inspection.



Network of excellence

Uddeholm is present on every continent. This ensures you high-quality Swedish tool steel and local support wherever you are. Assab is our wholly-owned subsidiary and exclusive sales channel, representing Uddeholm in various parts of the world. Together we secure our position as the world's leading supplier of tooling materials.

Uddeholm is the world's leading supplier of tooling materials. This is a position we have reached by improving our customers' everyday business. Long tradition combined with research and product development equips Uddeholm to solve any tooling problem that may arise. It is a challenging process, but the goal is clear – to be your number one partner and tool steel provider.

Our presence on every continent guarantees you the same high quality wherever you are. Assab is our wholly-owned subsidiary and exclusive sales channel, representing Uddeholm in various parts of the world. Together we secure our position as the world's leading supplier of tooling materials. We act worldwide, so there is always an Uddeholm or Assab representative close at hand to give local advice and support. For us it is all a matter of trust – in long-term partnerships as well as in developing new products. Trust is something you earn, every day.

For more information, please visit www.uddeholm.com or www.assab.com

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STRENGTH IN INNOVATION
KNOWLEDGE IN TOUGHNESS
RELIABILITY IN DURABILITY
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