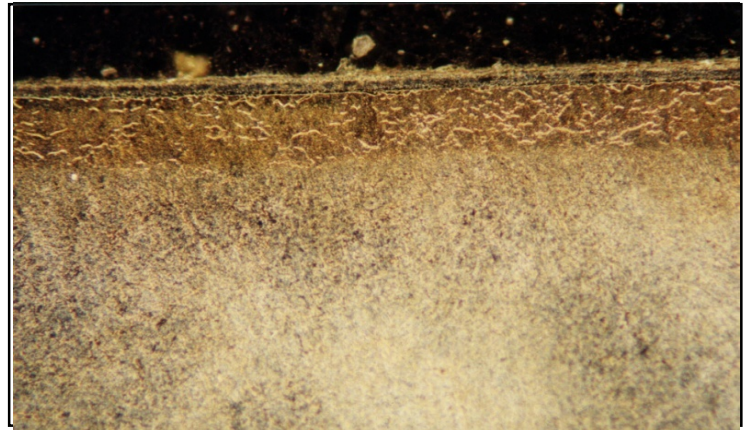


Material : DIN 1.2344 Hot Work Tool Steel

Method No. : A10

Results

In nitrited surface, the white layer and the diffusion zone underneath are clearly seen. Case depth is approx. 50 microns and the hardness is 110⁹ kg/mm². Low cutting force with lower feed is recommended. Edge roundness should be avoided.



DIN 1.2344 Nitrited Surface, Brightfield
 Magnification: 180X Etching: Picral
10%

Preparation Method:

Cutting: Abrasive Cut-off machine with Metlab Diamond Metal Bonded Wheel

Mounting: Mounting Press with Black Epoxy

Mechanical Preparation: Metpol-A

Steps	Surface	Abrasive	Lubricant	Force per Sample, (N)/(PSI)	Time min.	Disc Speed, rpm	Relative Rotation
1	S/C Paper Disc	180 Grit	Water	30/6	2 min. or until plane	300	Contra
2	S/C Paper Disc	400 Grit	Water	25/5	2	250	Contra
3	S/C Paper Disc	800 Grit	Water	25/5	2	250	Contra
4	Plan Cloth	6 μ Diamond Suspension	Blue Lube	15/3	3	150	Contra
5	Mol Cloth	1 μ Diamond Suspension	Blue Lube	15/3	4	150	Contra

FOR MORE DETAILED INFORMATION PLEASE REFER TO METLAB PRICE LIST