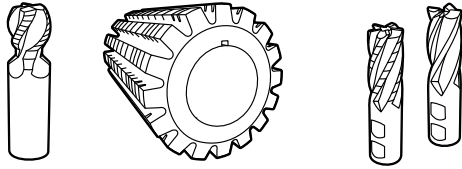


TOOLING ALLOYS

DATA SHEET Z-T15 PM™



CERTIFIED TO ISO 9001



CHEMICAL COMPOSITION

Carbon	1.60 %
Chromium	4.00 %
Vanadium	4.90 %
Tungsten	12.00 %
Cobalt	5.00 %
Manganese	0.30 %
Silicon	0.30 %

DESCRIPTION

Z- T15 PM™ is a tungsten-vanadium-cobalt high speed steel produced by powder metallurgy methods that can be heat treated to a maximum attainable hardness of HRC 66-68. It offers high levels of both wear resistance and red hardness which make it suitable for use in various heavy duty cutting tool applications involving difficult to machine materials. It can be effective in select cold work applications when under hardened to optimize toughness. The particle metallurgy processing also provides improved machinability, grindability, heat treat response, and dimensional stability when compared to similar grades produced by conventional methods.

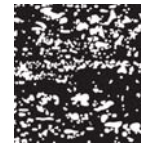
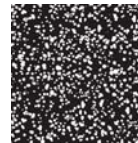
TYPICAL APPLICATIONS

- _ form tools
- _ broaches
- _ gear tools
- _ milling cutters
- _ end mills
- _ taps
- _ spade blades
- _ roll forming tools
- _ punches and dies

PHYSICAL PROPERTIES

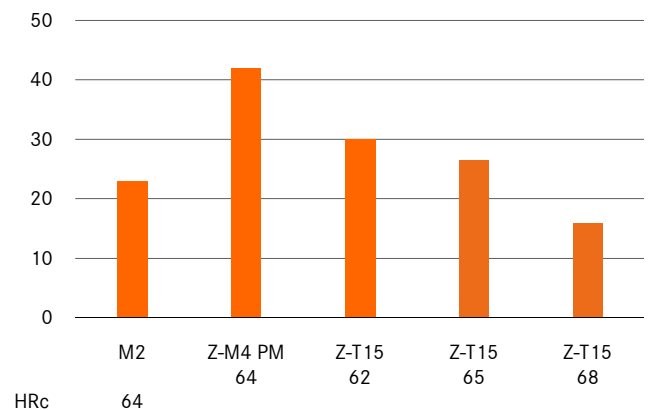
Modulus of elasticity E [psi x 10 ⁶]	30
Density [lb/in ³]	0.296
Thermal conductivity at 72 °F [BTU/hr-ft-°F]	10.94
Coefficient of thermal expansion over temperature range of 100 - 1000 °F [in/in/ °F]	6.4 x 10 ⁻⁶

POWDER METALLURGICAL AND CONVENTIONAL MICROSTRUCTURE

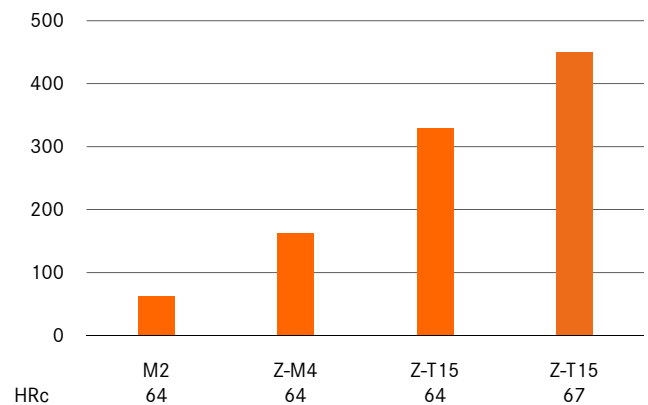


The uniform distribution of carbides in the powder-metallurgical structure compared to conventional tool steels with big carbides and carbide clusters.

TOUGHNESS



WEAR RESISTANCE



THERMAL PROCESSING

ANNEALING

Heat uniformly in a protective atmosphere (or vacuum) to 1600°F (870°C) and soak for 2 hours. Slow cool 30°F (15°C) per hour until 1000°F (540°C). Parts can then be cooled in air or furnace as desired. Hardness expected is BHN 245-275.

STRESS RELIEVING (SOFT)

Heat uniformly to 1100-1300°F (595-700°C), soak for 2 hours, and cool in air or furnace.

HARDENING

Vacuum, salt, or protective atmosphere methods are generally used. Care must be taken to prevent decarburization.

Preheat: Heat to 1550-1600°F (845-870°C) until temperature is equalized. Additional preheat steps including 1250-1300°F (680-700°C) and 1850-1900°F (1010-1040°C) are suggested when using programmed control during vacuum processing.

Austenitizing: Temperatures in the range of 2100°F (1180°C) to 2250°F (1235°C) are commonly used with the specific temperature and soak time determined by the hardness required. Higher hardening temperatures will provide maximum wear resistance and hardness while temperatures lower in the range will provide increased toughness. Refer to chart for further information.

Quenching: Methods include use of high pressure gas (minimum 5 bar preferred), salt bath, or oil. Quench rate through the temperature range of 1900°F (1040°C) to 1300°F (700°C) is critical to the development of optimum structure and properties. Part temperature can then be equalized at 1000-1100°F (540-595°C) after which cooling can continue to below 150°F (66°C) or “hand warm”. Step quenching in this manner will help to minimize distortion in larger section sizes.

TEMPERING

Tempering should be performed immediately after quenching. Temperatures in the range of 1000°F (540°C) to 1100°F (595°C) are generally used depending on the hardness required. Heat uniformly to the selected temperature and soak for 2 hours. Triple tempering is required. Tempering temperatures of less than 1000°F (540°C) should not be used, and care must be taken to cool parts fully to room temperature between each temper.

STRESS RELIEVING (HARD)

Heat to 25°F (15°C) less than the temperature of the last temper and soak for 1 hour.

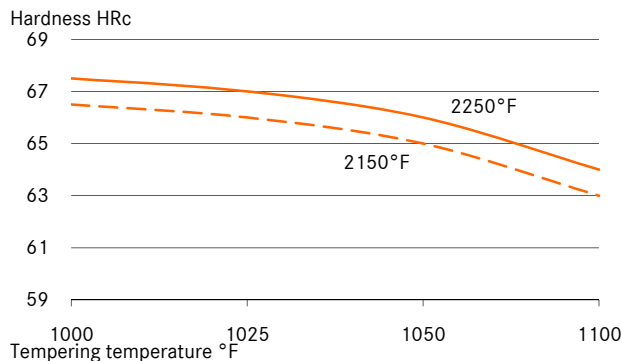
CRITICAL TEMPERATURE

1550°F (845°C).

SIZE CHANGE DURING HARDENING

+.0020in/in (at HRc 66)

TEMPERING DIAGRAM



HEAT TREATMENT INSTRUCTIONS

1st preheating	1250-1300 °F
2nd preheating	1550-1600 °F
Hardening	as specified in table
Tempering	2+2+2 hours at 1000°F minimum

Required hardness HRc ± 1	Austenitizing soak temp [°F]	Austenitizing soak time [min]*	Tempering temperature [°F]**
60-62	2100	10	1075
62-64	2100	10	1050
63-65	2150	10	1050
64-66	2200	5	1050
65-67	2200	5	1025
66-68	2225	5	1000

* Process variation and part section size can affect results. Soak times should be based on actual part temperatures. Use of load thermocouples is highly recommended during batch processing.

** An increase in tempering temperature by 25°F can be used to reduce hardness 1 to 2 points HRc. Tempering temperatures less than 1000°F should not be used.

STRAIGHTENING

Should be done warm (or during quench) using temperatures in the range of 400°F (200°C) to 800°F (430°C).

SURFACE TREATMENT

This grade is an excellent substrate material for use with the various commercially available PVD coating processes. Conventional nitriding (.001” maximum depth) and steam tempering can also be used. Coating vendors should be consulted to select the optimum process for a given application.

Care must be exercised during CVD and other surface treatment processes that can alter the original heat treatment of the tool.

MACHINING DATA

TURNING

Cutting parameter	Turning with cemented carbide		HSS
	medium turning	finish turning	
Cutting speed (V _c) m/min.	60-90	90-110	6-10
Feed (f) mm/U	0.2-0.4	0.05-0.2	0.05-0.3
Cutting depth (a _p) mm	2-4	0.05-2	0.5-3
Tools according ISO	P 10-P 20*	P 10*	-

* Use wear resistant coated cemented carbide, e. g. Coromant 4015 or Seco TP 100.

MILLING

FACE- AND EDGEMILLING

Cutting parameter	Milling with cemented carbide		HSS
	medium turning	finish turning	
Cutting speed (V _c) m/min.	40-60	60-80	15
Feed (f) mm/U	0.2-0.3	0.1-0.2	0.1
Cutting depth (a _p) mm	2-4	1-2	1-2
Tools according ISO	K 15*	K 15*	-

* Use a wear resistant coated cemented carbide, e. g. Coromant 4015 or Seco TP 100.

END MILLING

Cutting parameter	Solid carbide	Milling cutter w. indexable tips	
		Coated HSS	
Cutting speed (V _c) m/min.	20-35	50-70	12*
Feed (f) mm/U	0.01-0.20**	0.06-0.20**	0.01-0.30**
Tools according ISO	K 20	P 25***	-

* for TiCN-coated end mills made of HSS V_c ~ 25-30 m/min.

** depends on radial depth of cut and on milling cutter - diameter

*** Use wear resistant coated cemented carbide, e. g. Coromant 3015 or SECO T15M.

DRILLING

SPIRAL DRILL MADE OF HSS

Driller-φ mm	Cutting speed (V _c) m/min.	Feed (f) mm/U
0 - 5	10-14*	0.05-0.15
5 - 10	10-14*	0.15-0.25
10 - 15	10-14*	0.25-0.35
15 - 20	10-14*	0.35-0.40

* for TiCN-coated end mills made of HSS V_c ~ 25-30 m/min.

CARBIDE METAL DRILLER

Cutting parameter	Drill type		Coolant bore driller with carbide tip*
	insert drill	Solid carbide tip	
Cutting speed (V _c) m/min.	70-90	40-60	35
Feed (f) mm/U	0.08-0.14**	0.10-0.15**	0.10-0.20**

* driller with coolant bores and a soldered on carbide tip

** depends on driller-diameter

GRINDING

Grinding method	soft annealed	hardened
	Surface grinding, straight grinding wheels	A 13 HV
Surface grinding	A 24 GV	3SG 36 HVS**
Cylindrical grinding	A 60JV	B 126 R75 B3* 3SG 60 KVS** A 60 IV
Internal grinding	A 46 JV	B 126 R75 B3* 3SG 80 KVS** A 60 HV
Profile grinding	A 100 LV	B 126 R100 B6* 5SG 80 KVS** A 120 JV

* for these applications we recommend CBN-wheels

** grinding wheel from the company Norton Co.

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