

GATEWAY CPM 10V

Powder Metal Tool Steel

Gateway CPM 10V powder metal tool steel, a versatile air-hardening tool and die steel, Tool Steel which provides extremely high wear resistance in combination with relatively high impact toughness. A very large volume of hard vanadium carbides provides the high wear resistance. The good impact toughness is the result of the fine grain size, small carbides and superior cleanliness of the powder metallurgy (PM) microstructure. CPM 10V offers substantially better wear resistance than the high-carbon, high-chromium die steels such as D2 and D7.

Typical Chemistry

Carbon	2.45		Chromium	5.25
Manganese	.50		Vanadium	9.80
Silicon	.90		Molybdenum	1.35

Applications

Gateway CPM 10V is suitable for use in cold work tooling applications requiring maximum wear resistance such as thread roll dies, punches, blanking dies, shears, nozzles, screw tips, barrel liners and powder compaction tooling.

Annealing

Annealing must be performed after hot working and before rehardening. Heat at a rate not exceeding 400 F per hour to 1600-1650 F, and hold at temperature for 1 hour per inch of maximum thickness; 2 hours minimum. Then cool slowly with the furnace at a rate not exceeding 50 F per hour to 1000 F. Continue cooling to ambient temperature in the furnace or in air.

Heat Treating

Preheat to 1500/1550 F, equalize. A second reheat at 1850/1900 F is recommended for vacuum hardening. Heat rapidly to the high heat from the preheat.

For optimum wear resistance	1. Soak 5 to 15 minutes
	2. Furnace or Salt Bath : 2150 F
For balance of wear & toughness	1. Soak 15 to 30 minutes
	2. Furnace or Salt Bath : 2050 F
For maximum toughness & minimum distortion	1. Soak 30 to 60 minutes
	2. Furnace : 1975 F
	3. Salt Bath : 1950 F

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Heat Treating (continued)

Quenching: Pressurized gas, warm oil, or salt. Sections less than 3" thick may be air cooled to maximum hardness. Sections 3" thick or more must be quenched at a faster rate, using one of the methods below, to obtain maximum hardness. For pressurized gas, the furnace should have a minimum quench pressure of 4 bars. The quench rate below 1000 F is critical to obtain the desired properties. For oil, quench until black, about 900 F, then cool in still air to 150/125 F. For salt maintained at 1000/1100 F equalize in the salt, then cool in still air to 150/125 F.

Tempering

Temper immediately after quenching. Typical temperature range is 1000/1100 F. Do not temper below 1000 F. Hold at temperature for 2 hours then air cool to ambient temperature. Double tempering is required. Triple tempering is required when austenitized at 2100 F or higher.

Note: See your Gateway Metals representative to obtain specific heat treatment information to obtain certain hardness readings for your specific application. The data presented herein are typical values, and do not warrant suitability for any specific application or use of this material. Normal variations in the chemical composition, the size of the product, and heat treatment parameters may result in different values for the various physical and mechanical properties.

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