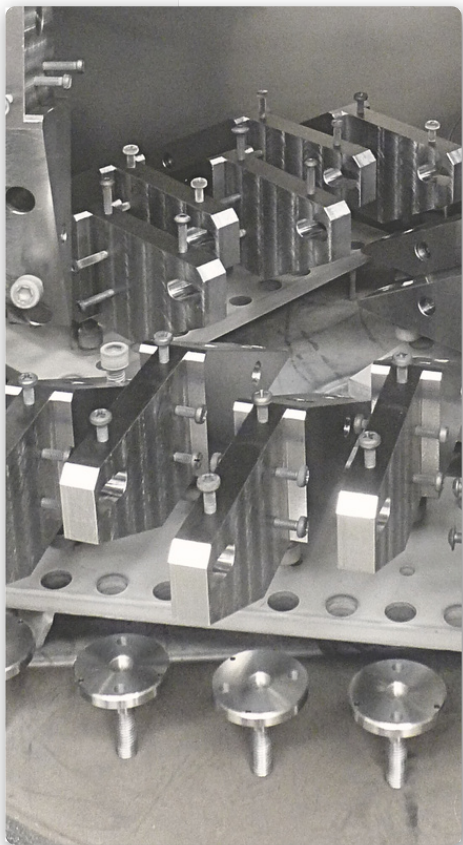


Stamping and Metalforming

Plasma (Ion) Nitriding in the Stamping and Metalforming Industry



Parts:

- **Stamping Dies** (punching, blanking, embossing, coining, bending, and flanging.)
- **Punches**

- **Bushings and guide pillars**

Transmission parts in mechanisms of the presses – see Transmissions and Drive Systems Industry

Requirements:

- For high **Hardness**
- For high **Wear resistance**
- For high **Fatigue strength**
- For **Plastic deformation resistance**

Ion Nitriding Solutions:

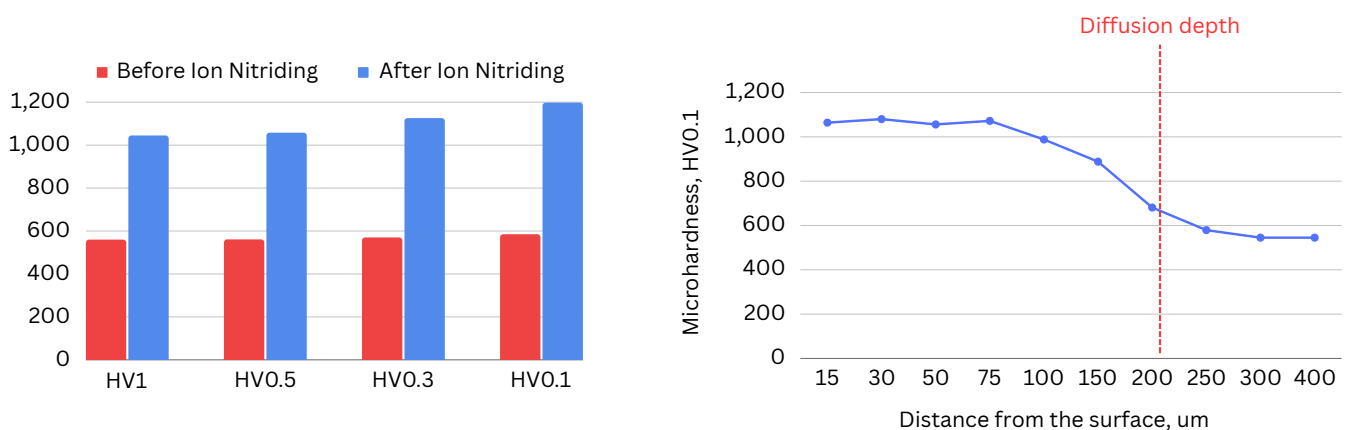
- **Significantly increasing the surface hardness, wear (abrasive and adhesive) resistance and fatigue life of the tools, improving their lifespan and performance.**
- **Reducing the friction coefficient** needed both for the tools and for the bushings and guide pillars.
- **Increasing the corrosion resistance** which is needed if the die sets are working in environments with moisture or corrosive substances.

Improving these parameters **will save from downtime and maintenance costs.**

Steel Grades Used:

Steel Grade	Surface Hardness, HV	Case Depth, um
H-13 / X40CrMoV5-1/ SKD61	900 - 1200	40 - 200
H-11 / X37CrMoV5-1	900 - 1200	40 - 200
H-10/ X32CrMoV12-28	900 - 1100	40 - 200
H-21/X30WCr-V3/ SKD5	850 - 1000	50 - 250
X38CrMoV5-1 / 1.2367	800 - 1000	50 - 200
A2 / X100CrMoV5 / SKD12	800 - 1000	50 - 200
D2 / X153CrMoV12 / SKD 11	900 - 1200	40 - 150
D3 / X210Cr12 / SKD 1	1000 - 1200	50 - 200
D6 / X210CrW12 / SKD 2	1000 - 1200	50 - 200
DC53	850 - 1100	50 - 250
S7 / 50CrMoV13-15	700 - 900	150 - 300
M2 / HS 6-5-2 / 1.3343	1000 - 1300	40 - 150
M42 / HS 2-9-1-8 / 1.3247	1000 - 1300	40 - 150
ASP-23 / S790	1000 - 1300	50 - 250

- Hardness and depth values are recommended for the industry and exact values will depend on the nitriding process parameters.
- This is not a full list of used steel grades



- Example of H13 tool steel after Ion Nitriding - surface hardness and diffusion depth



Equipment and Technology

Developed state of the art both Hot-Wall and Cold-Wall furnaces for Plasma (Ion) Nitriding.

Know-How and Expertise

We share our knowledge and expertise on nitriding different steel grades and parts, gathered for more than 45 years.

Support

We give full-time support.



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