

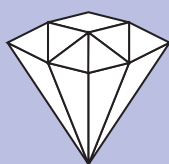
Hardening instruction for soft jaws

Material 16MnCr5 (1.7131)




- 1.** Preheat to 500 ° Celsius.
- 2.** Carburise at 930 ° Celsius.
Carburising depth is appr. 0,1 mm per hour.
- 3.** Harden at 850 ° Celsius and quench in oil at 100 ° Celsius.
- 4.** Wash and clean from oil.
- 5.** Temper at 150 - 180 ° Celsius according to requested hardness about 2 hours.
- 6.** Regrind the serration in case of distortion.

Material C45 (1.0503)



The carbon necessary for hardening is already in the material. Partial (such as clamping area) is possible by induction hardening. A distortion of the contact surface can be eliminated or reduced in most cases.

- 1.** Partial preheating to 870 - 930 ° Celsius (1 - 3 mm deep).
- 2.** Quench harden in emulsion.
- 3.** Temper at 150 - 180 ° Celsius according to requested hardness about 2 hours.

 Jaws from Material C45 must be inspected for cracks after induction hardening.