

# Rapidur 3207

HS10-4-3-10

C 1.23 Cr 4.10 Mo 3.50 V 3.30 W 9.50 Co 10.00

**Steel properties** High-speed steel of superlative performance combining optimal cutting-edge retention, high-temperature strength and toughness on account of its composition.

**Standards** **AISI** ~T42 **AFNOR** Z130WKCDV10-10-04-03

**Applications** Universally applicable for roughing and finishing where maximum tool life is required and for automatic lathes where wear is caused by large batch production. Also for all kinds of cutting tools and milling cutters exposed to exceedingly high stresses.

Heat treatment	Soft annealing °C	Cooling	Hardness HB			
	820 – 860	Furnace	max. 302			
	Stress-relief annealing °C	Cooling				
	630 – 650	Furnace				
	1st pre-heating °C	2nd and 3rd pre-heating °C	Hardening <sup>1</sup> °C	Quenching	Tempering °C	Hardness after tempering HRC
	up to approx. 400 in an air-circulating furnace	a) 850 b) 850 and 1050	1190 – 1230	a) Saltbath, 550 °C b) Oil c) Air	at least three times 540 – 570	65 – 67

<sup>1</sup> For cold-forming tools with a complex geometry, a hardening temperature at the lower end of the quoted range is recommended. The stated hardening temperatures apply to saltbath hardening only. For vacuum hardening, we suggest a reduction of 10 °C to 30 °C.