PROCESS SPECIFICATION
DELPHI SAGINAW STEERING SYSTEMS

TITLE Tool Material Heat Treatment – A6 NUMBER E-2626
ISSUED BY C. R. Martin DATE 4/30/96 APPROVED BY
REVISION C REV. DATE 08JL2003 SHEET 1 OF 1

A. Material to be heat treated: **A6**

B. Heat treat as specified: (Heat slowly)
1. Preheat slowly at 1000 to 1200°F.
2. High heat at 1525 to 1600°F.
3. Air quench as evenly as possible to 120 to 150°F.
   Optional: interrupted salt quench, followed by air cooling.
4. Double temper immediately at 300 to 800°F.
5. Allow to cool to room temperature between tempers.

C. Stress relieve, if specified, after final machining at a temperature which is 50 to 100 degrees lower than the tempering temperature used. The stress relieving temperature should not, in any way, affect the hardness of the material.

D. Using heat treatment shown above will give a hardness range of 54 to 60 Rockwell C. Required hardness will be noted on print. Heat treat accordingly.

E. No carburization or decarburization allowed.

F. Tooling must have holes cleaned of all salt.

G. Heat treatment certification, when requested, shall include:
1. Heat treat shop number
2. Purchase Order number accompanying job
3. Type of material heat treated
4. Size and quantity of tooling batch heat treated
5. Resulting hardness
6. Xerox copy of material tracking chart containing furnace times and temperatures.
7. Date when hardness tester last calibrated.

H. Heat treatment per this specification is to be carried out only by approved sources as listed in specification E-2600.

Revision	Revision Description	By	Date
A	Distribution list updated.	CRM	5/16/96
B	Distribution list revised. Format updated.	DN	1/24/01
C	Distribution note removed. Approved source note added.	DN	08JL2003

http://www.delphisuppliers.com/vendor_documents/delphi-s/index.html