

PROCESS SPECIFICATION

DELPHI SAGINAW STEERING SYSTEMS

TITLE Tool Material Heat Treatment NUMBER E-2635
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: **M4**
- B. Heat treat as specified:
1. Preheat at 1500 to 1550°F. in neutral salt.
 2. High heat at 2150 to 2175°F. in neutral salt.
 3. Salt quench at 1000°F. to 1050°F.
 4. Air quench to 150°F, or below.
 5. Triple temper immediately, 3 hours minimum at 1025°F. minimum for each temper.
 6. Air cool to room temperature between tempers.
- C. Stress relieve after final machining at 900°F. if specified.
- D. Using heat treatment shown above will give a hardness range of 60 to 66 Rockwell C. Required hardness
will be noted on print. Heat treat accordingly.
- E. No carburization or decarburization allowed.
- F. Any tooling heat treated in salt, which contains holes, must have holes cleaned of all salt.
- G. Heat treatment certification, when requested, shall include:
1. Heat treat shop number
 2. P.O. 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

Note: The above specifications were developed without considering whether patents may or may not be involved.
In all cases, therefore, the supplier shall be required to assume patent liability.