

PROCESS SPECIFICATION

DELPHI SAGINAW STEERING SYSTEMS

TITLE Tool Material Heat Treatment NUMBER E-2652
ISSUED BY C. R. Martin DATE 5/16/96 APPROVED BY _____
REVISION C REV. DATE 08JL2003 SHEET 1 OF 1

- A. Material to be heat treated: **S2**
- B. Heat treat as specified:
1. High heat at 1550°F.
 2. Quench in brine.
 3. Double temper immediately at 300°F to 800°F, air cooling to room temperature between tempers. The first temper should be 50 to 100 °F lower than the final temper.
- 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 49 to 60 Rockwell C. Required hardness will be noted on print. Heat treat accordingly.
- E. No carburization or decarburization allowed.
- F. 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.
- G. 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 revised. Format updated. | DN | 1/24/00 |
| B | Double temper added | DN | 6/11/02 |
| 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.