

Molex® #8

Air Hardening, Wear Resisting, Tool Steel

Molex #8 is an excellent grade of air hardening tool steel for general purpose usage in the tool room. **Molex #8** shows low distortion in heat treatment due to its chemical make-up. Typical problems associated with oil and water quenching methods are not issues when utilizing air hardening tool steels.

Molex #8 should be considered as an upgrade when your drawings call for A-2 tool steel.

(Past Protected Trade Name of Ludlow Steel Company – Atmos™)

Advantages

- 100% Decarb Free (Pre-Machined)
- Excellent Machinability
- High Compressive Strength
- Abrasion Resistant

Typical Surface Condition* (Pre-Machined)

Ground Top and Bottom (+.015"/+.035" oversize)
Sides Saw Cut (+1/8" oversize)
Length Saw Cut (+1/4" oversize)

Typical Applications

Blanking Dies	Trimmer Dies	Punches
Forming Dies	Gages	Bending Dies
Thread Rollers	Punches	Cutters

Thermal Treatment Summary*

Annealing – Generally furnished annealed. Raise to 1550°F slowly, not to exceed 400°F/hour. Hold at temperature one hour per inch of greatest cross section (2 hour min.) Cool slowly in furnace. Do not exceed a cooling rate of 50°F/hour to 1000°F. Cool to room temperature in furnace or air; 235 BHN max.

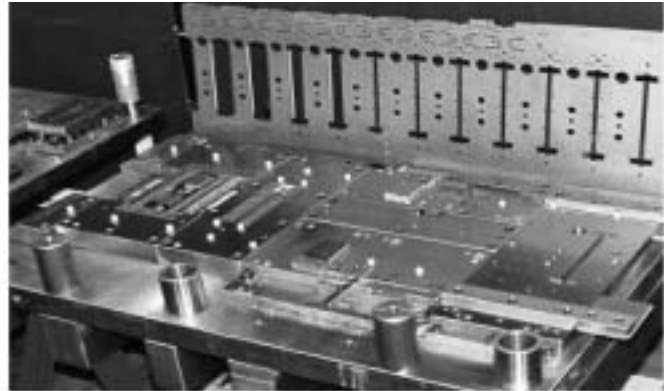
Forging – Pre-heat at 1250°F, then to 2000°F stop at 1700°F, cool slowly.

Hardening – 1725°F/1775°F, air quench to 150°F.

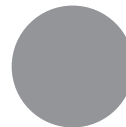
Preheating – 1150°F /1250°F, raise to temperature slowly, not to exceed 400°F/hour, then to 1300°F/1400°F.

Tempering – Temper immediately. Hold one hour per inch of greatest cross section (2 hour minimum).
– 350°F expected hardness Rockwell 62 “C”.
– 900°F expected hardness Rockwell 48 “C”.

*Above values are typical and are not guaranteed.



Sizes Available*



Rounds
1/4" to 10"



Squares
1/2" to 5"



Flats
1/4" to 8" thick
1" x 12" wide

Please call for all METRIC requirements.

Lengths Available

Custom Cut To Lengths
10 Ft to 12 Ft Random Lengths

