

# HIGH SPEED STEELS

## Application Segments

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Cutting Tools

Automotive

## Available Product Variants

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Long Products\*

Plates

\* Presented data refer exclusively to long products. Please observe the detailed explanations at the end of the data sheet (pdf).

## Product Description

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### **BÖHLER S690 MICROCLEAN – "The simple one"**

The tough high-speed steel for challenging machining and cold forming.

## Process Melting

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Powder metallurgy

## Properties

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- > Toughness & Ductility : very high
- > Wear Resistance : good
- > Compressive strength : good
- > Edge Stability : good
- > Grindability : high
- > Hot Hardness (red hardness) : good

## Applications

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- > Motorsport industry
- > End Mills
- > Special Cutting Tools
- > Broaches and Reamers
- > Fine Blanking, Stamping, Blanking
- > Cold Forming / Coining
- > Powder Pressing

## Technical data

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Material designation	
~HS6-5-4	EN
~M4	AISI

**Chemical composition (wt. %)**

C	Cr	Mo	V	W
1.44	4	5	4	5.5

**Material characteristics**

	Compressive strength	Grindability	Red hardness	Toughness	Wear resistance	Edge Stability
<b>BÖHLER S690 MICROCLEAN</b>	★★★	★★★	★★	★★★★★	★★★	★★
<b>BÖHLER S290 MICROCLEAN</b>	★★★★★	★	★★★★	★★	★★★★★	★★★★
<b>BÖHLER S390 MICROCLEAN</b>	★★★★	★★★	★★★★	★★★★	★★★★	★★★★
<b>BÖHLER S393 MICROCLEAN</b>	★★★★	★★★	★★★★	★★★★	★★★★	★★★★
<b>BÖHLER S590 MICROCLEAN</b>	★★★★	★★★	★★★★	★★★	★★★	★★★
<b>BÖHLER S790 MICROCLEAN</b>	★★★	★★★	★★	★★★★	★★	★★★
<b>BÖHLER S792 MICROCLEAN</b>	★★★	★★★	★★	★★★★	★★	★★★
<b>BÖHLER S793 MICROCLEAN</b>	★★★	★★★	★★★★	★★★	★★★	★★★

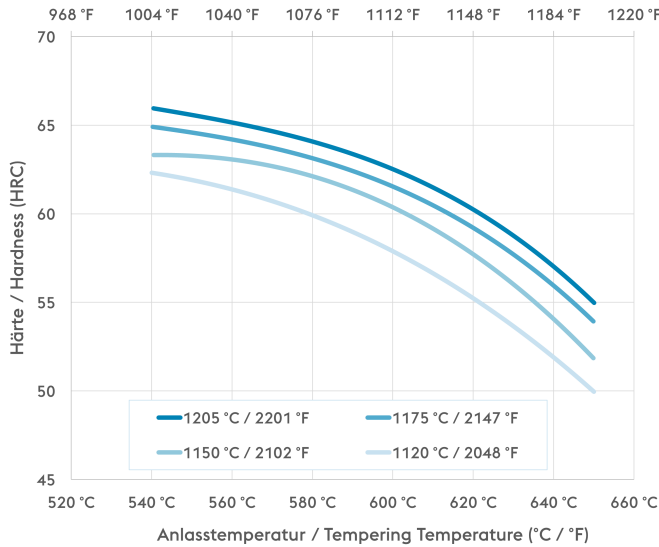
**Delivery condition**

<b>Annealed</b>	
Hardness (HB)	max. 280   drawn execution max. 300 HB
Tensile Strength (MPa)	max. 1,020

**Heat treatment**

<b>Annealing</b>		
Temperature	770 to 840 °C	Slow cooling in furnace.
<b>Stress relieving</b>		
Temperature	600 to 650 °C	Slow cooling furnace.    To relieve stresses set up by extensive machining or in tools of intricate shape.    After through heating, hold in neutral atmosphere for 1 to 2 hours.
<b>Hardening and Tempering</b>		
Temperature	1,100 to 1,200 °C	Salt bath, vacuum    Preheating: 1st stage ~ 500 °C (930 °F), 2nd stage ~ 850 °C (1560 °F), 3rd stage ~ 1050 °C (1920 °F)    Austenitising: 1100 - 1200 °C (2010 °F - 2230 °F), holding time after complete heating 80 seconds, maximum 150 seconds, to avoid material damage due to overheating.    Quenching: oil, warm bath (500 - 550 °C (930 °F - 1020 °F)), gas
Temperature	540 to 570 °C	Slow heating to tempering temperature immediately after austenitising.    Holding time in the furnace 1 hour per 20 mm material thickness (at least 1 hour)    Slow cooling to room temperature between each tempering step    3 tempering cycles recommended    Hardness see tempering chart

### Tempering Chart



Holding time 3 x 2 hours  
Specimen size: square 25 mm

### Tempering Chart

### Physical Properties

Temperature (°C)	20
Density (kg/dm <sup>3</sup> )	8.1
Thermal conductivity (W/(m.K))	20
Specific heat (kJ/kg K)	0.46
Spec. electrical resistance (Ohm.mm <sup>2</sup> /m)	0.53
Modulus of elasticity (10 <sup>3</sup> N/mm <sup>2</sup> )	217

### Thermal Expansions between 20°C | 68°F and ...

Temperature (°C)	100	200	300	400	500	600	700
Thermal expansion (10 <sup>-6</sup> m/(m.K))	11.5	11.7	12.2	12.4	12.7	13	12.9

If other available product variants are listed in addition to long products, please note that these may differ in terms of melting process, technical data, delivery and surface condition as well as available product dimensions. For mandatory technical specifications, other requirements and dimensions, please contact our regional voestalpine BÖHLER sales companies. The data contained in this brochure is merely for general information and therefore shall not be binding on the company. We may be bound only through a contract explicitly stipulating such data as binding. Measurement data are laboratory values and can deviate from practical analyses. The manufacture of our products does not involve the use of substances detrimental to health or to the ozone layer.

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ONE STEP AHEAD.