HARTMETALL ESTECH AG presents

Cemented Carbide EDM Preforms for Wire-cut and Die Sinking Electrical Discharge Machining

with Corrosion Inhibitor

EXPRESS LINE OF 6 DAYS





> Dimensions L x B x H and Ø x H - exactly to customer need

> EXPRESS LINE IN 6 DAYS

for sintered blocks and cylinders, raw sintered, without starting holes.

These preforms can also be manufactured with starting holes according to your drawings, and/or flat grinded on one or more faces. Delivery +2 to +4 work days according execution.

Material specification		Cemented carbide grades		
/		RCR17	RCR24	RCR30
WC grain size	broad	2.5 μm	2.5 μm	3.5 µm
WC content %w/w		90.5	87.0	84.0
Cobalt content %w/w		8.5	12.0	15.0
Other constituents % w/w		1.0	1.0	1.0
Hardness HV30		1550	1380	1260
Fracture toughness N/mm².m¹/²		10.0	13.0	17.5
Transverse rupture s	3700	3900	4100	

> Besides these three special EDM grades, we can also deliver other cemented carbide grades which contain anti-corrosive constituents and are well suitable for EDM processes.

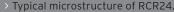
Below you find a table with recommendations of cemented carbide grades for cutting and punching dies, depending on the tensile strength / toughness and the thickness of the metal sheets to be worked.

Please contact us if you need any further information and advice.

Cemented carbide grades

Thickness of metal sheet mm	Tensile strength	n Tensile strength 500-900 N/mm²	Tensile strength 900-1400 N/mm²	Tensile strength > 1400 N/mm²
>2.0	RCR24	RCR24 / RCR30	RCR30	RCR30 / RB30
1.5 - 2.0	RCR24	RCR24 / RCR30	RCR30	RCR30
0.8 - 1.5	RCR17 / RCR24	RCR24	RCR24 / RCR30	RCR24 / RCR30
0.5 - 0.8	RCR17	RCR17	RCR24	RCR24
0.1 - 0.5	RX10 /	RX12-UF /	RX15 /	RCR24
	RX12-UF	RX10	RCR17	
<0.1	RX7 /	RX12-UF /	RX12-UF /	RX15 /
	RX8-UF	RX10	RX10	RCR17

> Tensile strength/toughness of the sheet





> Typical microstructure of RCR24