TOOLING ALLOYS
DATA SHEET LC 200 N

ZAPP IS CERTIFIED TO ISO 9001

CHEMICAL COMPOSITION*

Carbon	0.3 %
Chromium	15.0 %
Nitrogen	0.5 %
Molybdenum	1.0 %
Nickel	0.5 %
Manganese	1.0 %

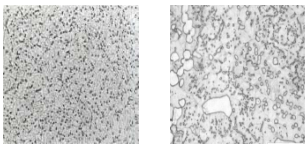
LC 200 N
is a high nitrogen alloyed tool steel which exhibits superior corrosion resistance combined with high toughness even at hardness up to 60 HRc. Combining PESR-Process (Pressurized Electric Slag Remelting) with Smart Forging Technology. This process offers an amazing increase in cleanliness and fine structure, which means a very fine and homogenious microstructure can be achieved. Primary advantage is excellent machinability and excellent polishability as well as a high dimensional stability after heat treatment. For this reason LC 200 N is a solution for tools facing high static and dynamical load under a high corrosive environment at higher temperatures. Compared to standard tool steels like 1.2316, 1.4112 and 1.4125, LC 200 N exhibits higher corrosion resistance and toughness as well as a higher tempering resistance up to 500 °C at an operating hardness of 58-60 HRc.

TYPICAL APPLICATIONS
_Food industry, blades, portioner and filling units
_Pump components, spindles, extrusion- and proportioner units for chemical and pharmaceutical industry
_Tablet tooling
_Mirror-polished dies for plastics industry
_Shredder knives, granulations and pelletizers for recycling industry

PHYSICAL PROPERTIES

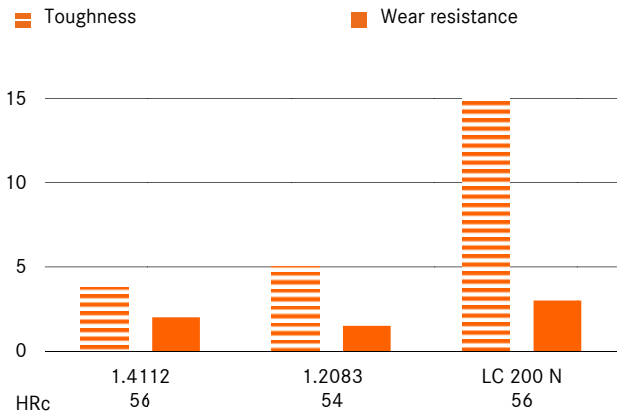
Modulus of Elasticity E [MPa]	214,276
Spezific Weight [kg/dm³]	7.72
Thermal Conductivity 20°C [W/m*K]	14

STRUCTURE OF LC 200 N COMPARED TO 1.4112

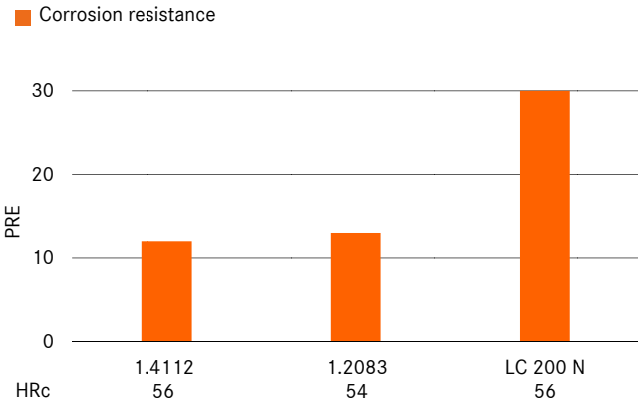


(magnification 1000 x etched)

WEAR RESISTANCE / TOUGHNESS



CORROSION RESISTANCE



HEAT TREATMENT

SOFT-ANNEALING

Heat LC200N uniformly to 780 – 820 °C in controlled atmosphere furnaces or with suitable protective media. Hold at temperature for approximately two to four hours and cool slowly in the furnace. The annealed hardness is lower than 300 HB.

STRESS RELIEVING

After rough machining, stress relief annealing is recommended by heating uniformly to 600 – 650 °C. Target temperature should be hold for approx. two hours followed by a subsequent furnace cooling to <350°C. Then further cooling in air is possible.

HARDENING

Professional heating to austenitizing temperature with common holding steps is recommended. Holding time varies from 20 to 40 minutes after complete homogenization.
Generally, an all-around grinding tolerance of approximately 0.2 mm needs to be considered in order to take care of any possibility of decarburization, denitrization or oxidation. Additionally, it is desirable to use a controlled atmosphere furnace or vacuum furnace with controlled chamber pressure typically used for high chromium alloyed materials.

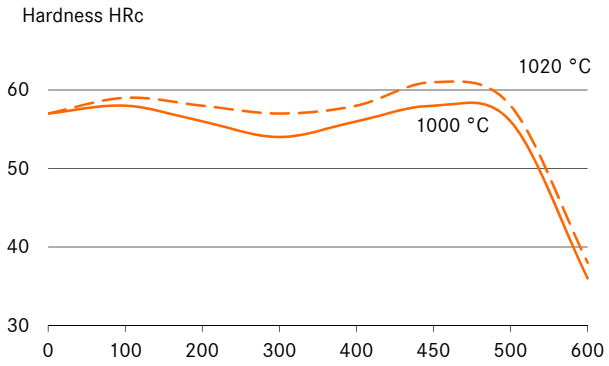
QUENCHING

Quenching can be done with aircool bath or interrupted oil quench. When air is used, minimum overpressure of 5 bar is necessary.

TEMPERING

Subzero treatment with minimum -80°C and a holding time of minimum 60 minutes is recommended as soon as the tools can be held comfortably in bare hands. For Austenizing temperatures of 1000°C or higher, subzero treatment is mandatory. Alternatively, subzero treatment at -196 °C (liquid nitrogen) for 30 minimum can be performed. Subsequently material needs to be tempered for 2 times for 2 hours at suited temperature to achieve target properties.

TEMPERING DIAGRAM



Tempering Temperature °C after subzero quenching

INSTRUCTIONS FOR HEAT TREATMENT

Preheating	750–780 °C
Austenizing	See chart below
Cooling	Quenching in oil, salt bath or air (min. 5 bar overpressure) to 550°C.
Tempering	2 x 2 hours (see chart below)

Hardness HRc ± 1	Austeniz-ing Temp. °C	Tempering °C	Corrosion resistance	Toughness
>58	1030*	160-180	++	0
55 - 58	1030*	220-300	++	++
>58	1030*	460-475	+	+
30 - 40	1000	550-620	+	+++

* Subzero quenching, -80 °C, 60 min, air

Heat treatment parameters need to be selected on basis of the aimed target combination of hardness, toughness and corrosion resistance.

MACHINING DATA

TURNING

With carbide metal			
Cutting depth [mm]	0.5 – 1.0	1.0 – 4.0	4.0 – 8.0
Feed [mm/U]	0.1 – 0.2	0.2 – 0.4	0.6 – 0.6
Tools according ISO	P10, P20, M10	P20, M10, M20	P30, M20, K10
Cutting speed			
Cutting inserts	260 – 200	200 – 150	150 - 110
Soldered carbide metal	210 – 170	170 – 130	140 - 90
Coated cutting inserts			
ISO P25	Up to 240	Up to 210	Up to 160
ISO P35	Up to 210	Up to 160	Up to 140
Edge angle for soldered carbide metals			
Relief angle	6° - 8°	6° - 8°	6° - 8°
Chip angle	12° - 15°	12° - 15°	12° - 15°
Inclination angle	0°	0°	- 4°

HARDTURNING

Cutting material	cBN 3
Cutting plate geometry	SNGN 090308 T 02020
Cutting speed Vc[m/min]	125
Feed [mm/U]	0.1
Cutting depth [mm]	0.2
Setting angle	75°
Chip angle	- 6°
Relief angle	6°
Inclination angle	- 4°

TURNING

With high speed steel			
Cutting depth [mm]	0.5	3	6
Feed [mm/U]	0.1	0.5	1.0
Din-grade	**DIN S 10-4-3-10**		
Cutting speed [m/min.]	55 - 45	45 – 35	35 - 25
Relief angle	8° - 10°	8° - 10°	8° - 10°
Chip angle	14° - 18°	14° - 18°	14° - 18°
Inclination angle	0°	0°	- 4°

MILLING

With milling heads		
Feed [mm/tooth]	Up to 0.2	0.2 – 0.3
ISO P25	160 - 100	110 - 60
ISO P40	100 - 60	70 - 40
ISO P35	140 - 110	

DRILLING

With carbide metal			
Drilling diameter [mm]	3 - 8	8 – 20	20 - 40
Feed [mm/U]	0.02 – 0.05	0.05 – 0.12	0.12 – 0.18
Carbide metal	K10	K10	K10
Point angle	115° - 120°	115° - 120°	115° - 120°
Relief angle	5°	5°	5°

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