

## HABA ServizioPiastre s.r.l.

✉ Via Emilia, 27/29  
24052 Azzano S.Paolo (BG)

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## ACCIAIO DA LAVORAZIONE A FREDDO

### 1.2842 / 1.2510

### 90 Mn Cr V 8 / 100 Mn Cr W 4

L %	C	Si	Mn	Cr	W	V	S
<b>1.2842</b>	0.90	0.20	1.90	0.40		0.10	0.03
<b>1.2510</b>	0.95	0.20	1.20	0.60	0.60	0.10	0.03

Esecuzione disponibile	>	acciaio di precisione	prelavorato
tolleranze	>	spess.: +0,05 / 0 largh.: +0,2 / 0	spess.: +0,2 / 0 largh.: +0,4 / 0

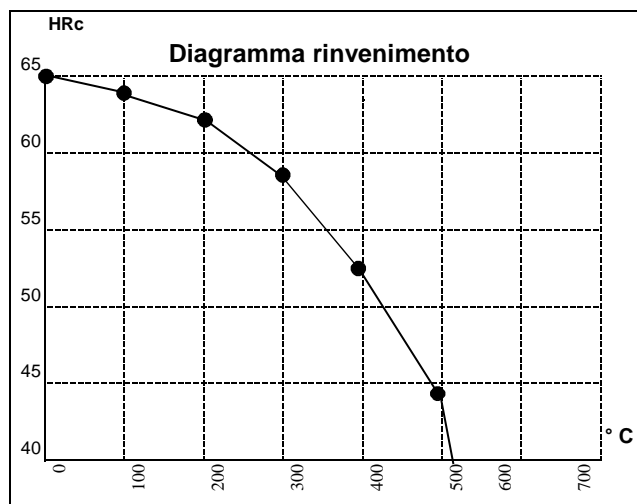
### Utilizzo per:

utensili da taglio / stampaggio / incisione  
lardoni, strumenti di misurazione  
matrici e punzoni  
utensili per la lavorazione del legno  
utensili per troncaggio / a filettare  
lame troncatrici  
stampi per gomma e plastica  
attrezzature, sagome (dime,calibri a sagoma)

### Caratteristiche:

acciaio temprabile in olio dall'impiego versatile  
buona resistenza all'usura  
buona precisione dimensionale, resilienza  
buona tenuta di taglio  
buona temprabilità / tempra a cuore  
asportazione trucioli: molto buona  
ricottura dolce ca. 220 HB  
alta durezza superficiale

I materiali 1.2842 e 1.2510 sono da considerarsi equivalenti per quanto riguarda le loro caratteristiche. Differenze sulla lavorazione e/o variazioni dimensionali dopo il trattamento di ricottura non sono riscontrati. Il materiale 1.2510 si compone di volframo, tramite il quale si raggiunge una maggiore rinvenibilità e resistenza all'usura.



### Trattamento termico

- ricottura dolce 710-760°C 2-3 ore raffreddam. forno
- ricottura bassa tens. 650-680°C 1-3 ore raffreddam. forno
- tempra 780-820 °C olio
- rinvenimento 180-400 °C 1-2 volte ogni ora

### Valori di tempra 840 °C rinvenuto 2 volte

100 °C	64	+ / - 1 HRC
200 °C	62	+ / - 1 HRC
300 °C	58	+ / - 1 HRC
400 °C	52	+ / - 1 HRC
500 °C	44	+ / - 1 HRC

Valori d'indurimento raggiungibili HRC 63 - 65





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**Disponibilità del magazzino****1.2842 / 1.2510**

90 Mn Cr V 8 / 100 Mn Cr W 4

**Acciaio di precisione DIN 59350**

**Tolleranze / esecuzione:**

- spessore: +0,05 / 0 mm rettificato
- larghezza: +0,2 / 0 mm rettificato / fresatura di precisione
- lunghezza: +5 / 0 mm tagliato di sega

**Lunghezza a magazzino  
1000 mm**

Largh. (mm)	Spessore (mm)													
	2	3	4	5	6	8	10	12	15	20	25	30	40	50
10	---	---	---	---	---	---	---	---	---	---	---	---	---	---
12	---	---	---	---	---	---	---	---	---	---	---	---	---	---
15	---	---	---	---	---	---	---	---	---	---	---	---	---	---
20	---	---	---	---	---	---	---	---	---	---	---	---	---	---
25	---	---	---	---	---	---	---	---	---	---	---	---	---	---
30	---	---	---	---	---	---	---	---	---	---	---	---	---	---
35	---	---	---	---	---	---	---	---	---	---	---	---	---	---
40	---	---	---	---	---	---	---	---	---	---	---	---	---	---
50	---	---	---	---	---	---	---	---	---	---	---	---	---	---
60	---	---	---	---	---	---	---	---	---	---	---	---	---	---
70	---	---	---	---	---	---	---	---	---	---	---	---	---	---
75	---	---	---	---	---	---	---	---	---	---	---	---	---	---
80	---	---	---	---	---	---	---	---	---	---	---	---	---	---
100	---	---	---	---	---	---	---	---	---	---	---	---	---	---
120	---	---	---	---	---	---	---	---	---	---	---	---	---	---
150	---	---	---	---	---	---	---	---	---	---	---	---	---	---
160	---	---	---	---	---	---	---	---	---	---	---	---	---	---
180	---	---	---	---	---	---	---	---	---	---	---	---	---	---
200	---	---	---	---	---	---	---	---	---	---	---	---	---	---
250	---	---	---	---	---	---	---	---	---	---	---	---	---	---
300	---	---	---	---	---	---	---	---	---	---	---	---	---	---

**Barre rettificate su 4 lati**

Tolleranze: +0,1/0 mm

**Lunghezza a magazzino  
500 e 1000 mm**

■ mm	4	5	6	7	8	10	12	15	16	18	20	23	25
L = 500	---	---	---	---	---	---	---	---	---	---	---	---	---
L = 1000	---	---	---	---	---	---	---	---	---	---	---	---	---

■ mm	30	35	40	45	50	60	80
L = 500	---	---	---	---	---	---	---
L = 1000	---	---	---	---	---	---	---