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HPS6

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PROCESS SPECIFICATION
ON
Heat Treating & Stress Relieving of
Martensitic Stainless Steel
(400 Series Stainless Steel)

10/19/00	N	Rev per ECN 13148	EC	TOLERANCES... UNLESS OTHERWISE SPECIFIED	DRAWN CG 2/23/56	HEAT TREATING & STRESS RELIEVING
9/12/00	M	Rev per ECN13031	MP	FRACTIONAL ± 1/32	CHECKED MP 3/7/63	
5/26/99	L	Rev per ECN 11891	JDM	DECIMAL .XX ± .02	APPROVED LJS 3/5/63	TACTAIR FLUID CONTROLS INC. LIVERPOOL, NY 13088
3/19/96	K	Rev per ECN 8826	JDM	DECIMAL .XXX ± .010	SCALE	
9-8-95	J	Rev per ECN 8225	JDM	ANGULAR ± 1/4°	CODE IDENT. NO.	HPS6
4-21-94	H	Rev per ECN 7008	JDM	MATERIAL _____	70236	Page 1 of 6
DATE	LTR	CHANGE	APP'D.	TREATMENT _____		
				FINISH _____		

REVISIONS

REVISIONS	DATE	DESCRIPTION	APP. BY
-	2/23/56	Release	CG
A	8/20/56	HPS6 superseded by HPS6A; rewritten	
B	9/12/56	Revised note 5	CG
C	12/4/56	Revised para. 5, detail req.	
D	3/5/63	Revised & updated was HPS6C	LJS
-	11/2/65	Sheets renumbered, sheet 1 updated	
E	2/7/69	In para. 5.7 -120°F was -100°F	MC
F	3/7/69	Para. 5.2, Temp. was 1950°F Para. 5.3, Added oil temp. Para. 5.5, Stress relieve was 300°F Para. 5.7, Stress rlv was 300°F for one hour	MP
G	9/30/92	Company name change and re-sequencing of procedures	JM
H	4/21/94	Para. 5.6 Added sentence- " <i>Place part in</i> " Para. 5.8, Added words- " <i>cold and hot stabilization</i> "	JDM
J	9/8/95	Para. 2 Is: " <i>Reference Specifications</i> " Was: " <i>Applicable Specifications</i> " Para. 2.1 added sentence, " <i>The following</i> " Para. 3.3 Added: " <i>used for processing per para. 5.1, 5.2, and 5.3</i> " Para. 5.6 Revised wording	JDM
K	3/19/96	Reference specs updated Added para. 6.0 DETAIL REQUIREMENTS ECN 8826	JDM
L	5/26/99	Updated from MIL standards to AMS Para.7.1 Is: " <i>After magnetic particle examination</i> " Was: " <i>After magnaflux</i> " ECN 11891	
M	09/18/2000	Removed title " <i>DIMENSIONAL STABILIZATION OF STEELS: PROCESS FOR</i> ". Para. 1.1 Removed " <i>alloy and hardenable stainless steels, tool steels, cast irons, carburized steels, and nitriding steels</i> " and Replaced with " <i>hardenable martensitic stainless steels</i> ".	

REVISIONS

REVISIONS	DATE	DESCRIPTION	APP. BY
M (Con't)	09/18/2000	<p>Para. 2.1 Removed <i>“are listed for reference only and are not a part of HPS6”</i> and Replaced with <i>“are used except as noted within this document.”</i>. Added specification <i>“AMS-2759 Heat Treatment of Steel Parts”</i> and <i>“AMS-2759/5 Heat Treatment Martensitic Corrosion Resistant Steel Parts”</i>.</p> <p>Para. 2.2 Removed Entire paragraph</p> <p>Para 3.1 Removed para and Replaced with <i>“All equipment used for processing parts shall meet the requirements of AMS-2759.”</i></p> <p>Para. 3.3 Removed paragraph’s</p> <p>Para. 3.4 Removed paragraph’s</p> <p>Para 4.1 Removed para and Replaced with <i>“All parts shall be cleaned to remove protective oils, dirt etc...prior to the heat treat process.”</i></p> <p>Para’s 4.2 thru 4.3 – Added paragraph’s.</p> <p>Para 5. Removed <i>“-Heat Treatment of 400 series steel”</i></p> <p>Para. 5.1 Removed <i>“supplements the requirements of AMS-H-6875”</i> and Replaced with <i>“is used”</i>. Added to end of para. <i>“(inert gas atmosphere and quench)”</i>.</p> <p>Para 5.2 Added <i>“All other 400 series material per AMS 2759/5.”</i></p> <p>Para. 5.3 Removed <i>“a furnace atmosphere as soon as possible after austenizing (bright hard).”</i> and Replaced with <i>“an inert gas atmosphere. The .25 inch cross sectional requirement and microhard/decarburization testing (Ref. AMS-2759/5) is not required.”</i>.</p> <p>Para 6.1 Added <i>“After the complete treatment only light grinding and honing is permitted for final sizing.”</i></p> <p>Para 6.2 Removed <i>“After the complete treatment only light grinding and honing is permitted for final sizing.”</i> And Replaced with <i>“Design Engineering shall specify if additional cold and hot stress relieving is required to stabilize for extreme tight fits of mating parts.”</i></p>	

1. Application

- 1.1 This process covers the minimum requirements for the treatment of hardenable martensitic stainless steels for the purpose of obtaining dimensional stabilization of parts for use in precision assemblies.

2. Reference Specifications

- 2.1 The following specifications are used except as noted within this document:

AMS-2759	Heat Treatment of Steel Parts
AMS-2759/5	Heat Treatment Martensitic Corrosion Resistant Steel Parts

3. Equipment

- 3.1 All equipment used for processing parts shall meet the requirements of AMS-2759.

4. General Requirements

- 4.1 All parts shall be cleaned to remove protective oils, dirt etc... prior to the heat treat process.
- 4.2 Part handling and racking is critical to protect parts from damage and distortion during the heat treat process.
- 4.3 All parts shall be protected from damage & corrosion during shipping and storage. Original or better packaging shall be used.

5. Detail Requirements

- 5.1 The following procedure is used to obtain structural and dimensional stability for mated slide fits and parts whose functional requirements depend on a high degree of dimensional stability. All heat treating of 400 series stainless shall be by bright hardening (quench in protective atmosphere per AMS2759/5, Class A).
- 5.2 Austenitize steel at temperatures indicated.

410 and 416	1750°F - 1850°F
440C	1850°F - 1950°F
All other 400 series material per AMS 2759/5	

- 5.3 Quench in protective atmosphere. The .25 inch cross sectional requirement and microhard/decarburization testing (Ref. AMS-2759/5) is not required.
- 5.4 Continue cooling from quench to cold stabilizing temperature of -100°F (minimum) for 20 minutes per inch of thickness.
- 5.5 Remove parts from cold chamber and bring to room temperature, then stress relieve at 300°F ± 25°F for one hour. Repeat cold stabilizing cycle as specified in Para. 5.4. Remove parts from cold chamber and bring to room temperature, then temper to required hardness as specified on drawing.

6. Detail Requirements- Stress Relieve

- 6.1 Parts that require the major portion of machining done after heat treating must be cold and hot stress relieved, prior to final grinding. After the complete treatment only light grinding and honing is permitted for final sizing. Place part in cold chamber and cool to -100°F (minimum) for 20 minutes per inch of thickness. Remove from cold chamber and bring to room temperature, then stress relieve at 300°F ± 25°F for one hour.
- 6.2 Design Engineering shall specify if additional cold and hot stress relieving is required to stabilize for extreme tight fits of mating parts.

7. Inspection

- 7.1 Parts treated per para. 5. and or 6. shall be given magnetic particle examination as noted on detail drawing prior to final sizing.

After magnetic particle examination parts must be completely demagnetized.

- 7.2 It shall be the responsibility of the Tactair Quality Control Department to assure that proper certification covers the requirements of the drawing.

NOTES:

1. All temperatures mentioned herein are metal temperatures.
2. Treatment in accordance with this process shall not alter physical properties specified on the drawing.
3. Deviations to any portions of the outlined process must be approved by Tactair Engineering.