



Technical Information: M50

M50 IS A GENERAL PURPOSE HIGH SPEED STEEL
M50 HAS A GOOD BALANCE OF TOUGHNESS, WEAR RESISTANCE, AND RED HARDNESS
M50 IS USED FOR METAL CUTTING, WOOD AND PLASTICS CUTTING AND COLD WORK TOOLING

TYPICAL CHEMICAL COMPOSITION

CARBON	0.80%	CHROMIUM	4.00%
MOLYBDENUM	4.25%	SILICON	0.20%
VANADIUM	1.00%	MANGANESE	0.30%

SBSM TOOL STEEL PROPERTIES COMPARISON



PHYSICAL PROPERTIES

MODULUS OF ELASTICITY.....29.5 PSI X 10⁶(207 GPa)
 DENSITY..... 0.283 LB/IN³
 ANNEALED HARDNESS.....215-255 BRINELL HARDNESS (BHN)
 MACHINABILITY.....SIMILAR TO M2 TOOL STEEL



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HEAT TREATMENT

ANNEALING

HEAT TO 1600°F, HOLD TWO HOURS
SLOW COOL 20°F/HOUR TO 600°F
THEN AIR OR FURNACE COOL TO ROOM TEMPERATURE

STRESS RELIEVING

PERFORMED PRIOR OR AFTER MACHINING TO MINIMIZE DISTORTION IN HEAT TREATING
1100/1200°F, HOLD TWO HOURS
THEN AIR COOL TO ROOM TEMPERATURE

HARDENING

SALT BATH, PROTECTIVE ATMOSPHERE, OR VACUUM FURNACE EQUIPMENT PREFERRED.

HIGH HEAT (AUSTENITIZING)

2025/2075°F FOR 10-15 MINUTES AT HEAT.

QUENCH

SALT BATH QUENCH TO 1000-1100°F, EQUALIZE, THEN AIR COOL TO 150°F.
VACUUM OR ATMOSPHERE QUENCH RATE OF A MINIMUM 50 DEGREES F PER MINUTE DOWN TO 1200F IS
CRITICAL TO ACHIEVE BEST HEAT TREAT RESPONSE.

TEMPER IMMEDIATELY FOLLOWING QUENCH

TEMPERING

MINIMUM 1000°F TEMPERING TEMPERATURE REQUIRED.
DOUBLE TEMPERING IS REQUIRED, TRIPLE TEMPERING RECOMMENDED.
AIR COOL TO ROOM TEMPERATURE BETWEEN TEMPERS.

TYPICAL HEAT TREAT RESPONSE

TEMPERING TEMP °F	HARDENING TEMP 2075°F
As QUENCHED	58
1000	64
1025	64
1050	63
1075	63
1100	62

LONGITUDINAL SIZE CHANGE

APPROXIMATELY: PLUS 0.22%