

Hardening and Hardness Test Methods

Heat Treatment for Steel Materials

Name	Vickers Hardness (HV)	Hardening Depth (mm)	Strain	Applicable Material	Typical Material	Remarks
Through Hardening	750 or Less	Full Depth	Varies according to materials.	High Carbon Steel C > 0.45%	SKS3 SKS21 SUJ2 SKH51 SKS93 SK4 S45C	<ul style="list-style-type: none"> Operation of heating copper to an appropriate temperature over transformation point and quickly cooling it in an appropriate medium in order to increase hardness or improve strength. Not applicable to long or precision parts, such as spindles, etc.
Carburizing	750 or Less	Standard 0.5 Max. 2	Moderate	Low Carbon Steel C < 0.3%	SCM415 SNM220	<ul style="list-style-type: none"> Applicable to Partial Hardening Hardening depth should be specified on drawings. Applicable to precision parts.
Induction Hardening	500 or Less	1 ~ 2	High	Medium Carbon Steel C 0.3 ~ 0.5 %	S45C	<ul style="list-style-type: none"> A surface hardening method that uses high frequency induction current to quickly heat and cool the steel surface. Applicable to Partial Hardening. Expensive in small-volume lots. High fatigue resistance.
Nitriding	900~1000	0.1 ~ 0.2	Low	Nitriding steel	SACM645	<ul style="list-style-type: none"> A surface hardening method that forms hardening layer of hard nitride compounds on the steel surface Obtains highest degree of Hardness of All Hardening Techniques. Applicable to precision parts. Applicable to spindles for sliding bearing.
Tufftride	Carbon Steel 500 Stainless Steel 1000	0.01~0.02	Low	Steel Material	S45C SCM415 SK3 Stainless Steel	<ul style="list-style-type: none"> Tufftride is one of the soft nitriding methods. High fatigue resistance and abrasion resistance. Same corrosion resistance as zinc plating. Not applicable to precision parts because of incapability of polishing after heat treatment. Applicable to oil free bearings.
Bluing	—	—	—	Wire Rod	SWP-B	<ul style="list-style-type: none"> Low temperature annealing. Removes internal stress in forming to enhance elasticity.

Hardness Test Methods and Applicable Parts

Testing Method	Principle	Applicable Heat-Treated Parts	Features	Reference
Brinell Hardness	A (steel or superhard alloy) ball indenter is used to indent the test surface. Hardness is given as a quotient divided by the surface area of the indent, computed from the diameter.	<ul style="list-style-type: none"> Annealed parts Normalized parts Anchored materials 	<ul style="list-style-type: none"> Applicable to uneven materials and forged products because indent is large. Not applicable to small or thin specimens. 	JIS Z2243
Rockwell Hardness	This standard or test load is applied via a diamond or ball indenter. Hardness is read on a tester.	<ul style="list-style-type: none"> Hardened-Tempered Parts Carburized Surfaces Nitrided Parts Thin sheets such as copper, brass, bronze, etc. 	<ul style="list-style-type: none"> Hardness value obtained quickly. Applicable to Intermediate Testing of Actual Products. Caution is required as there are 30 types. 	JIS Z2245
Shore Hardness	The specimen is set on a table. A hammer is dropped from a uniform height. Hardness is based on how height the hammer bounces.	<ul style="list-style-type: none"> Hardened-Tempered Parts Nitrided Parts Large carburized parts, etc. 	<ul style="list-style-type: none"> Extremely easy to operate and data can be obtained quickly. Applicable to large parts. Indent is kept shallow, therefore is applicable to actual products. Portable, as being compact and light weight. 	JIS Z2246
Vickers Hardness	Uses a diamond 136° square pyramid indenter. Hardness value is obtained as the surface area of the indent, computed from the length of the diagonal lines of the indent. (Automatically calculated)	<ul style="list-style-type: none"> This hardened layers by induction hardening, carburizing, nitriding, electrolytic plating, ceramic coating, etc. Hardened layer depth in carburized and nitrided parts. 	<ul style="list-style-type: none"> Applicable to small and thin specimens. Applicable to all materials because of diamond indenter. 	JIS Z2244

Standard Material Sizes 1

General Steel Materials

Class	Material Code	Shapes	Unit	Standard Size
Rolled Steel for General Structure	SS400	Flat Bar	t	6,9,12,13,14,16,19,22,25,28,30,32,35,38,40,45,50,55,60,65,70,75,80,85,90,95,100,105
		Square Bar	□	9,13,16,19,22,25,32,38,44,50,65,75,90,100
Polished Steel Bar (Cold-Drawn)	SS400D	Flat and Square Steel Bar	t	Width W
			2	6,8,10,12,16,20
			3	6,8,9,10,12,13,16,19,22,25,32,38,50
			4	10,13,16,19,20,22,25,32
			4.5	11,13,16,19,22,25,32,38,50
			5	8,10,13,16,19,20,22,25,30,32,38,50
			6	9,10,13,16,19,20,22,25,32,38,44,50,60,65,75,90,100,125
			8	10,12,13,16,19,22,25,30,32,38
			9	12,13,16,19,22,25,32,38,44,50,60,65,75,90,100,125
			10	13,15,16,20,22,25,30,32,38,40,50,60,65,100
			12	16,19,22,32,38,44,45,50,60,65,75,90,100,125
			16	19,22,25,32,38,44,50,60,65,75,90,100,125
			19	22,25,32,38,44,50,60,65,75,90,100,125
			22	25,32,38,44,50,60,65,75,90,100,125
			25	32,38,44,50,60,65,75,90,100,125
			30	50,65,75,100,125
			32	50,65,75,100,125
			38	50,65,75,100,125
		Square Bar	□	2.5,3,4,4.5,5,5.5,6,7,8,9,10,11,12,13,14,15,16,17,18,19,20,21,22,24,25,28,30,32,34,35,36,38,40,42,44,45,50,55,60,65,70,75,80,85,90,100,110,120,130
		Hexagonal Bar	Opposite side H	3,5,6,7,8,9,10,11,12,13,14,17,19,21,22,23,24,26,27,29,30,32,35,36,38,41,46,50,54,55,58,60,63,65,67,70,71,75,77,80,85,90,95,100,115
		Round Bar	D	2,3,4,5,6,7,8,9,10,11,12,13,14,15,16,17,18,19,20,21,22,23,24,25,26,27,28,29,30,31,32,33,34,35,36,37,38,40,42,43,44,45,46,48,50,55,60,65,70,75,80,85,90,95,100,105,110,115,120,130,140,150,160,170,180,190,200
Cold-Rolled Steel Plate	SPCC	Steel Plate	t	0.4,0.5,0.6,0.7,0.8,1.1,1.2,1.6,2.2,3,3.2
Hot-Rolled Steel Plate	SPHC	Steel Plate	t	(1.2),1.6,2.3,2.6,3.2,4.5
Carbon Steel for Machine Structure	S45C-D (Polished)	Round Bar	D	2,2.5,3,3.5,4,4.5,6,7,8,9,9.5,10,11,12,13,14,15,16,17,18,19,20,21,22,23,24,25,26,27,28,29,30,32,33,34,35,36,38,40,42,44,45,46,48,50,55,60,65,70,75,80,85,90,95,100,105,110,115,120,125,130
		Flat Bar	t	6,9,5,12,7,13,16,19,22,25,27,32,38,45,50,55,65,75,85,95,105,115,125,135,145,155, (165), (175), (185), (205)
	S50C	Square Bar	□	12,7,13,16,19,25,28,32,38,44,50,55,65,75,90,100,110,120,130,155
Carbon Tool Steel	SKS93	Flat Bar	t	2,3,4,5,6,7,8,9,10,12,13,16,19,22,25,27,32,38,43,50,53,65,75,90,105,130,155
		Square Bar	□	10,13,16,19,22,25,28,32,38,45,50,55,65,75,90,105,130, (155), (210)
		Round Bar	D	2,3,4,5,6,7,8,9,10,11,12,13,14,15,16,17,18,19,20,22,23,24,25,26,28,30,32,36,38,40,42,45,48,50,55,60,65,70,75,80
Alloy Tool Steel	SKS3	Flat Bar	t	2,3,4,5,6,7,8,9,10,12,13,16,19,22,25,27,32,38,43,50,53,65,75,90,105,130,155, (160)
		Square Bar	□	10,13,16,19,22,25,28,32,36,38,45,50,55,65,75,90,105,130, (155), (210)
		Round Bar	D	13,16,19,22,25,28,32,38,42,46,50,55,60,65,70,80,85,90,100,110,120,130,150,160,180
Chrome Molybdenum Steel	SCM435	Hexagonal Bar	Opposite side H	6,7,8,9,10,11,12,13,14,17,19,21,22,23,24,26,27,30,32,35,36,38,41,46,50,54,55
		Round Bar	D	4,5,6,7,8,9,10,11,12,13,14,15,16,17,18,19,20,21,22,23,24,25,26,27,28,30,32,34,35,36,38,40,42,45,46,48,50
Sulfur and Sulfur Compound Free Cutting Steel	SUM24L	Round Bar	D	3,4,5,6,7,8,9,10,11,12,13,14,15,16,17,18,20,22,23,24,25,26,28,30,32,34,35,36,38,40
High-Carbon Chrome Bearing Steel	SUJ2	Round Bar	D	13,16,19,22,25,28, (30),32, (34),36,38,42, (44),46, (48),50,55,60,65,70,75,80,85,90,95,100,110,120,130,140,150, (160), (170), (180), (190), (200), (210), (220), (230), (240), (250)