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DATA SHEET:
610 CW610N

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FREE MACHINING



Leaded Muntz Metal for mechanical machining.

It is called "Leaded Muntz Metal" and is characterized by a fair tool machinability and good hot formability. Thanks to its excellent mechanical characteristics and high copper content it is used for the production of parts used in heat exchangers.

NAME OF ALLOY

UNI EN: CW610N - CuZn39Pb0.5 **ASTM:** C36500 **DIN:** 2.0372 **BS:** CZ123-CZ137 **GOST:** LS60-1

CHEMICAL COMPOSITION UNI EN 12164 ED.2016

Cu	Pb	Sn	Fe	Ni	Al	Zn	Other elements
min. 59.0 max. 60.5 %	0.2 0.8 %	≤0.2 %	≤0.2 %	≤0.3 %	≤0.05 %	difference	≤0.2 %

HEAT TREATMENTS

STRESS RELIEVING

Enables the redistribution of tensions induced by mechanical processing of cold plastic deformation, reducing the risk of stress corrosion cracking. The treatment consists of heating the items to 200°C - 250°C for 2 hours and cooling within the furnace. The validation of the stress relieving treatment can be performed with the ISO 6957 test.

ANNEALING

Re-crystallizes the alloy, reducing its hardness and increasing its ductility. The temperature of the treatment varies from 450°C to 550°C for an amount of time relative to the required results. The high temperature can induce changes in the surface appearance and in the tolerance of the finished part.

MECHANICAL PROPERTIES UNI EN 12164 ED.2016

Condition of material	Diameter in mm		Hardness HB*		Rm	Rp _{0.2} N/mm ²		Elongation %
	from	to (included)	min.	max.	min.	min.	max.	min.
M	All		As a product					
R360	6(5)	80 (60)	-	-	360	-	300	20
H070	6(5)	80 (60)	70	100	-	-	-	-
R410	2	40 (35)	-	-	410	230	-	12
H100	2	40 (35)	100	145	-	-	-	-
R500	2	14 (10)	-	-	500	350	-	8
H120	2	14 (10)	120	-	-	-	-	-

*the hardness value is determined in the mid-range
The values in brackets refer to the hexagonal section bar.
The standard condition produced by Almag is R410 for Rm or H100 for hardness.
Any other conditions must be requested when ordering - subject to feasibility request.

TECHNOLOGICAL PROPERTIES			low	[Progressive bar]					excellent
Structure	$\alpha+\beta$	Machinability	[Progressive bar]						
Density	8.40 g/cm ³	Weldability	[Progressive bar]						
Electrical conductivity	28% IACS	Hot forming	[Progressive bar]						
Coeff. of thermal expansion	20.8 10 ⁻⁶ K	Cold forming	[Progressive bar]						
Thermal conductivity*	123 W/(mK)	Corrosion resistance**	Not resistant						
Specific heat	380 J/(kg K)								
Elasticity module	105 N/mm ²								
Melting point	885-900 °C								

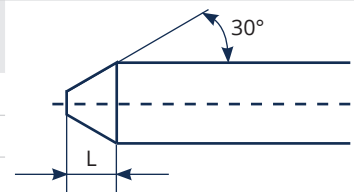
*at room temperature
**use care to ascertain compatibility with chemical substances

DIMENSIONS, TOLERANCES, AND STRAIGHTNESS UNI EN 12164 ED.2016							
ROUND section bar				HEXAGONAL and SQUARE			
Nominal Diameter (mm)		TOLERANCES			Nominal key (mm)		Tolerance mm
from	to included	Class A	Class B	Class C	from	to included	
6	10	0 - 0.06	0 - 0.036	0 - 0.025	6	10	0 - 0.09
10	18	0 - 0.07	0 - 0.043		10	18	0 - 0.11
18	30	0 - 0.08	0 - 0.052		18	30	0 - 0.13
30	50	0 - 0.16			30	50	0 - 0.16
50	80	0 - 0.19			50	60	0 - 0.19

The standard tolerance for the round bar is Class A. Any different tolerances must be agreed upon when ordering
Semi-finished products can be supplied from Ø63 to Ø80 mm with Class A tolerances

Diameter (mm)	Length of bar (mm)	Tolerance (mm)	Diameter or Key (mm)	Deviation from straightness in mm	
				Every 400 mm	Every m of length L ≥ 1
2	30	3000 o 4000	+/- 50		
30	50	3000 o 4000	+/- 100		
50	80	3000	+/- 100		
Round section bar					
10	50		0.4	1.0 x L	
Hexagonal and square section bar					
10	50		0.6	1.5 x L	

BAR FINISHING AND PACKAGING					
Diameter or Key (mm)		Chamfer Length L mm		Tip Length L mm	
5	10	0.2	1.5	2	7
10	20	0.2	2	3	10
20	30	0.2	3	4	12



Unless otherwise specified by the buyer, the shape of the ends of products larger than 30 mm is up to the supplier

Ends of round bars	finishing with chamfer and tip up to and including Ø40 mm finishing with chamfer and cut greater than Ø40 mm
Ends of hexagonal bars	finishing with chamfer and cut
Bar surface	pickled
Packaging	1000 kg bundle – 3/5 metal straps different bundle packagings and quantities are possible upon request
Identification	adhesive label on bundle strap
Stress relieving	the polygonal bar was subjected to stress relieving treatment

COMPANY WITH
MANAGEMENT SYSTEM
CERTIFIED BY DNV GL
= ISO 9001 =
= ISO 14001 =
= OHSAS 18001 =



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