

1214 Free machining

Typical Analysis (Ave. values %)	C	Si	Mn	P	S
	0.015	0.10	1.0	0.07	0.30
NEAREST STANDARD	AS	AISI	BS	DIN	
	1214	~1213	220M07 EN1A	1.0715 95Mn28	

DESCRIPTION	1214 is cold finished (drawn or turned and polished) free machining low tensile 370 - 750 MPa mild steel. Generally used in the as supplied condition.
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APPLICATIONS	A large range of machined products where high volume is required from automatics.
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MECHANICAL PROPERTIES (Ave. values)	Condition	Tensile Strength MPa	Yield Strength MPa	Elongation %
	Cold drawn	400-750	290-580	7-9
	Turned & Polished	370-510	230-300	18

HEAT TREATMENT	Carburize	900-920°C. Furnace or Air cool
	Harden	780-800°C Water quench.
	Temper	180-210°C air cool

WELDING	Not Recommended
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SIZE RANGE	Round	3.18 to 152.4 mm
	Square	6 to 101.6 mm
	Hexagon	6.35 to 101.6 mm A/F