

High-frequency quenching of rolls

DHF has been successfully making and supply ing rolls which have high hardness, deep hardened and low distortion processed by the originally developed medium and high frequency IH quenching technology. And its technology is highly valued by the customers in various industries due to its quality rolls.



High-frequency quenching of large

We can offer the best specifications about hardness, hardened depth of roll depending upon materials and customers application condition, please feel to contact us.

Size capacity

Outer diameter (mm)	min ϕ 8 ~ max ϕ 1500
Length (mm)	max 12000mm
Weight (ton)	max 30ton

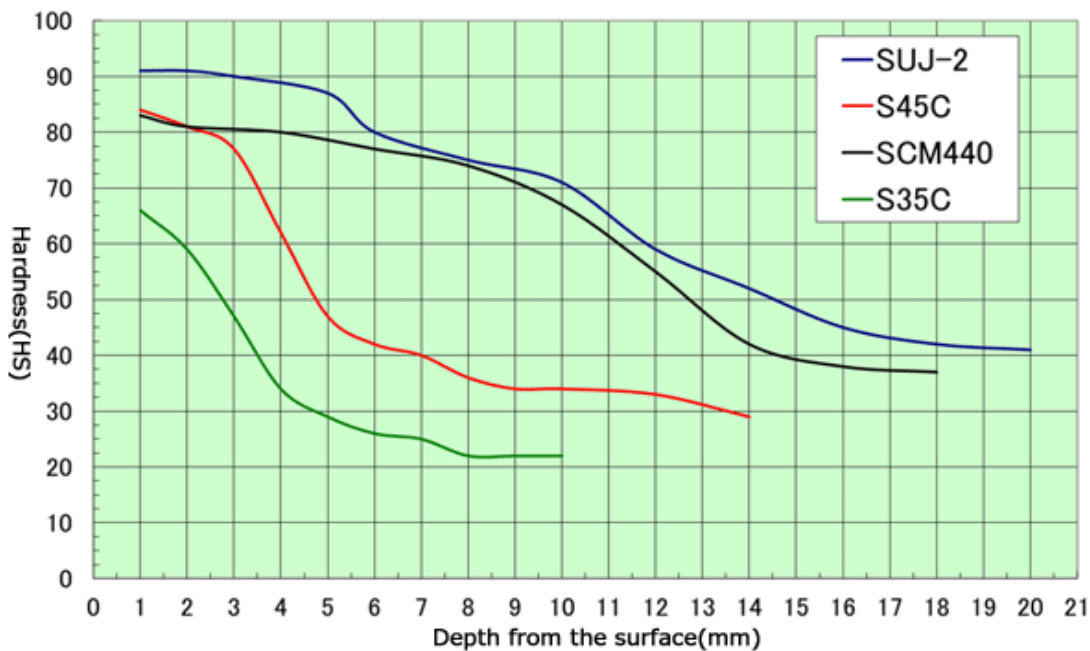
Hardness ranges of typical DHF's special steels

Steel type	Surface hardness (HS)				
	60	70	80	90	100
DHF-3				■	■
DHF-122				■	■
DHF-S1		■	■		
DHF-S2			■	■	
DHF-51				■	■

Hardness ranges of conventional steels for rolls

Steel type	Surface hardness (HS)				
	60	70	80	90	100
S45C		■	■		
SUJ-2				■	■
SCM435	■	■	■		
SCM440		■	■		
SUS420J2		■	■		
SUS440C			■	■	

The hardness of typical roll materials depending on the distance from surface



※The above figure shows just example not guaranteed, and actual values of them are varied depending on heat treatment history, size shape and weight.