

KEY[®]LOS 1730M

Special Carbon steel for
small plastic moulds and
prototypes for dies industry

General characteristics

KeyLos[®] 1730M is a special Carbon steel suited designed for the manufacture of small sized dies, bolsters or prototypes for dies industry.

KeyLos[®] 1730M represents a good balance of:

- mechanical characteristics;
- high machinability and polishability;
- high micro-purity.

KeyLos[®] 1730M has been designed for prototype tooling cost reduction; in fact, shorter mould making and cycling times can be obtained, thanks to its very good machinability and its high thermal conductivity.

This steel is obtained through a special 'super clean' manufacturing process, which allows a high level of micro-cleanness to be achieved.

KeyLos[®] 1730M is supplied in the normalised condition with surface hardness up to 210 HB.

High levels of machinability and microstructural homogeneity are obtained thanks to a Calcium treatment process on the liquid steel and a careful heat treatment process.

KeyLos[®] 1730M is the option for the production of small plastic moulds and prototypes for die industry in special Carbon steel with thickness up to 300 mm.

In summary, KeyLos[®] 1730M offers the following advantages:

- excellent machinability;
- excellent suitability for photo-engraving;
- excellent suitability for polishing;
- excellent suitability for nitriding, in order to increase the wear resistance in surface;
- good wear resistance, due to the special fine pearlitic structure, if we consider that the hardness values are only around 210 HB;
- optimised manufacturing cycle: from steel block to mould, with no need for intermediate treatments;
- quite good weldability, in case of extreme repairing.

KeyLos[®] 1730M is 100% ultrasonically inspected, according to the most demanding of NDT standards.

KeyLos[®] 1730M is also designed with the aim to guarantee the minimum use of virgin materials, moving toward the use of scrap categories difficult to be recycled, that can become food for the steel making production of KeyLos[®] 1730M grade.

Chemical analysis

	Range	C [%]	Si [%]	Mn [%]
KEY[®]LOS 1730M	min	0,50	0,30	0,60
Alloying [% in weight]	max	0,60	1,00	1,00

Table for comparison of international classification

W. Nr.	≈ 1.1740
DIN	≈ C55W
AISI	≈ 1.050

Lucchini RS's tool steels have been researched and formulated in order to optimize the material performances.

The brand name identifies the Lucchini RS product and the number evokes the Werkstoff classification or other means of reflecting the characteristics of use.

Main applications

KeyLos[®] 1730M in the pre-hardened condition is suitable for the following applications:

Plastic moulding:

- small sized moulds for the automotive industry up to 300 mm;
- moulds for food industry products;
- moulds for rubber pressing;
- pressure moulds (SMC, BMC);
- bolsters for plastic moulds.

Physical and mechanical properties

Main physical properties

KEY[®]LOS 1730M	20°C	250°C	500°C
Modulus of elasticity [GPa] (1GPa=1000 MPa)	210	196	177
Coefficient of thermal expansion [10 ⁻⁶ /K]	-	12,6	14,4

Main mechanical properties

KEY[®]LOS 1730M	20°C
Ultimate Tensile strength (UTS) [MPa]	700
Yield stress (YS) [MPa]	620

These values are average values obtained from the middle of the section of a 300 thick bar, subjected to LRS heat treatment.

Heat treatments

KeyLos[®] 1730M is supplied in normalised condition. If it is necessary to obtain different hardness levels or if an other heat treatment cycle is necessary, the parameters in the following table are recommended.

The attached data are for information purposes only and must be varied dependent on the heat treatment facility and the thickness of the bar.

Soft annealing

Suggested temperature	700 °C
Soaking time	60 min every 25 mm thickness
Cooling	Slow in the furnace at max 20 °C/h to 600 °C , then at room temperature

Soft annealing is useful to improve machinability.

Stress Relieving

Suggested temperature	400 °C
Soaking time	60 min every 25 mm thickness
Cooling	Slow in the furnace at max 20 °C/h to 200 °C , then at room temperature

If the suggested temperature is lower than the tempering temperature, the stress relieving temperature will be 50° C lower than the tempering temperature previously applied.

Stress relieving is recommended where it is necessary to eliminate residual stresses induced by mechanical working or by a preceding heat treatment.

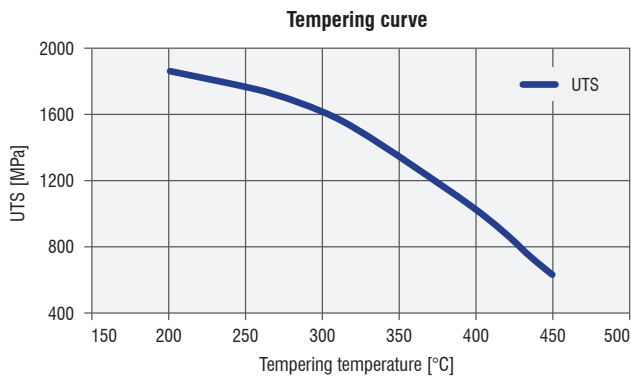
Hardening

Suggested temperature	830 °C
Soaking time	60 min every 25 mm thickness
Cooling	Polymer or water quench

We suggest to carry out hardening on material supplied in the annealed condition and tempering immediately afterwards.

Tempering

Suggested temperature	The tempering temperature to be applied to the material depends on the required mechanical properties. See following graph.
Soaking time	60 min every 25 mm thickness
Cooling	Room temperature



Tempering curve of a sample which has been austenitised at 830 °C.

After tempering, we always suggest carrying out stress relieving.

In any case, other properties can be analyzed and studied deeper by Lucchini RS on specific Customer request: please consult Lucchini RS specialists of MET Department.

Induction hardening

On this steel it is possible to carry out induction hardening.

We recommend cooling at room temperature and tempering after heat treatment.

Nitriding

KeyLos[®] 1730M is suitable for ionic and gas nitriding. This treatment is very useful for moulds or dies subjected to extremely stressful applications.

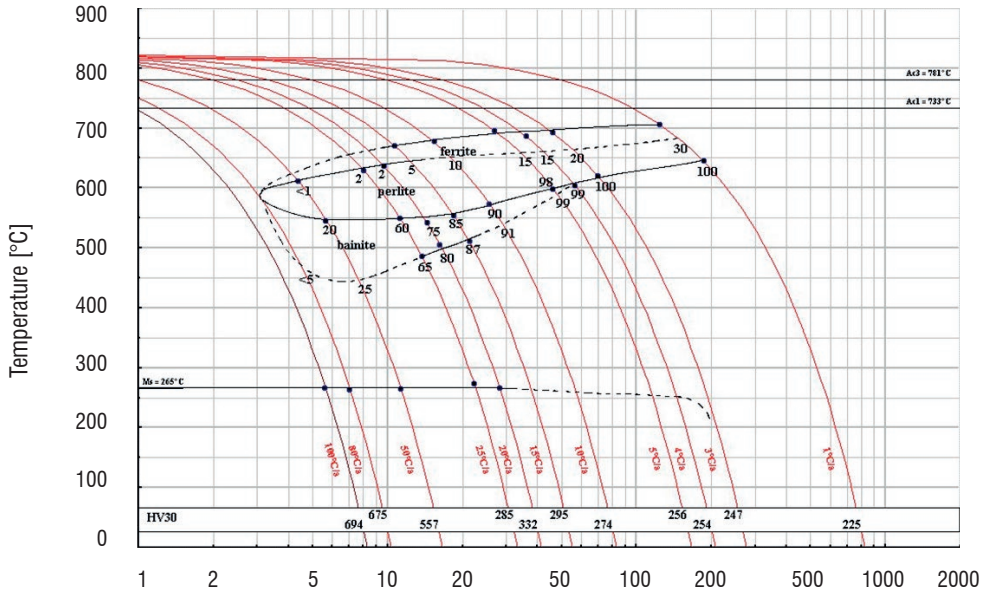
The increase of the surface hardness, following nitriding, lengthens the component life cycle. Modern nitriding processes allow the original dimensions of the component to be maintained.

We recommend heat treating the component in the finish machined condition.

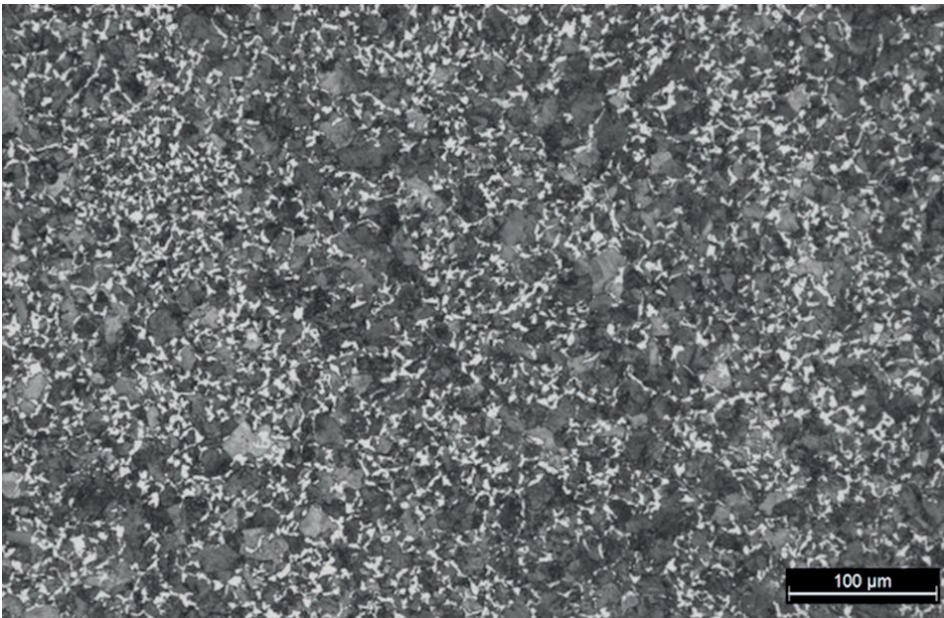
We recommend the following manufacturing cycle, in order to obtain the best results:

- rough machining;
- stress relieving;
- finish machining;
- nitriding.

CCT Curve



Microstructure of KEYLOS[®] 1730M



The microstructure of KeyLos[®] 1730M as delivered by Lucchini RS, detected about 20 mm under surface, consists of a fine lamellar pearlite and ferrite.

Quick comparison guide among the different grades

The following table shows a quick comparison among the most important characteristics of the pre-hardened grades normally applied in plastic moulding.

Lucchini RS Mould steel Family for plastics Industry																			
Special features and delivered conditions	Pre-hardened Not Corrosion Resistant Mould Steel Grades																		
	KEYLOS												ESKYLOS				BEYLOS		
	1730	1730 M	7225	ON	2312	2311	UP	2738 MSH	2738	PLUS	2738 MHH	2002	6959	2002	6959	2340	2365 M	2711	2714
HB in surface in Annealed condition	/	/	/	/	/	/	/	/	/	/	/	< 220	/	< 220	< 220	< 220	< 250	< 250	
HB in surface Pre-hardened	≤ 200	≤ 210	220-270	280-330	280-330	280-330	280-330	290-340	300-350	320-360	360-400	370-410	360-400	370-410	400-450	400-450	370-410	370-410	
Maximum thickness [mm]	300	300	500	500	600	600	800	800	1.000	800	1.200	1.200	500	500	500	500	500	500	700
Hardness and Wear Resistance	1	1	1	2	2	2	2	3	2	3	3	3	3	3	4	4	3	3	3
Degree of Through Hardening in the section	1	1	1	1	2	2	3	3	3	3	4	4	4	4	4	3	3	3	3
Toughness	1	1	2	2	1	3	3	3	2	3	3	3	4	3	4	3	2	4	4
Machinability after Annealing	/	/	/	/	/	/	/	/	/	/	/	/	3	/	3	3	3	3	3
Machinability after Hardening	3	3	2	1	4	2	2	2	2	2	2	2	1	2	1	1	1	1	1
Etch-Grainability	1	1	1	2	0	3	3	3	3	3	3	3	2	4	4	4	4	2	2
Polishability	2	2	2	2	0	3	3	3	3	3	3	3	2	4	4	4	4	3	3
Repair by Welding	1	1	1	0	0	1	1	2	1	2	2	2	1	2	1	1	1	1	1
Thermal Conductivity	3	3	2	2	2	2	2	3	2	3	3	3	2	3	2	1	1	2	2
Corrosion Resistance	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

4 Excellent 3 Very Good 2 Good 1 Normal 0 Unsuitable

The information and the data presented here are typical or average values and are not a guarantee of maximum or minimum values.

Applications specifically suggested for materials described herein and in the quick comparison guide among the different grades are made solely for the purpose of illustration to enable the reader to make his own evaluation and are not intended as warranties, either express or implied, of fitness for these or other purposes.

Guidance for machining

The following parameters are indicative only and must be adapted to the particular application and to the machinery employed.

Turning

Type of insert	Rough machining		Finish machining	
	P20-P40 coated	HSS	P10-P20 coated	Cermet
V _c cutting speed [m/min]	150 ÷ 190	(*)	190 ÷ 230	260 ÷ 320
a _r cutting depth [mm]	5	(*)	< 1	< 0,5

Milling

Type of insert	Rough machining		
	P25-P35 not coated	P25-P35 coated	HSS
V _c cutting speed [m/min]	120 ÷ 140	160 ÷ 180	(*)
f _z feed [mm]	0,15 ÷ 0,3	0,15 ÷ 0,3	(*)
a _r cutting depth [mm]	2 ÷ 4	2 ÷ 4	(*)

Type of insert	Pre-finishing		
	P10-P20 not coated	P10-P20 coated	HSS
V _c cutting speed [m/min]	140 ÷ 160	180 ÷ 200	(*)
f _z feed [mm]	0,2 ÷ 0,3	0,2 ÷ 0,3	(*)
a _r cutting depth [mm]	< 2	< 2	(*)

Type of insert	Finishing		
	P10-P20 not coated	P10-P20 coated	Cermet P15
V _c cutting speed [m/min]	200 ÷ 240	250 ÷ 270	300 ÷ 340
f _z feed [mm]	0,05 ÷ 0,2	0,05 ÷ 0,2	0,05 ÷ 0,2
a _r cutting depth [mm]	0,5 ÷ 1	0,5 ÷ 1	0,3 ÷ 0,5

(*) not advisable

Drilling

Type of insert	tip with interchangeable inserts	HSS	brazed tip
V_c cutting speed [m/min]	130 ÷ 160	(*)	90 ÷ 120
f_z feed per turn [mm/turn]	0,05 ÷ 0,15	(*)	0,15 ÷ 0,25

(*) not advisable

General formulae

Type of machining	Drilling	Milling
n: number of turns of mandrel	$V_c * 1000 / \pi * D_c$	$V_c * 1000 / \pi * D_c$
V_f : feed speed [m/min]	$V_f = f_z * n$	$V_f = f_z * n * z_n$
f_z feed per turn [mm/turn]	-	$f_n = V_f / n$
Note	D_c : Milling cutter or tip diameter [mm] V_c : cutting speed [m/min] f_z : feed [mm]	f_n : feed per turn [mm/turn] z_n : No. of milling cutter inserts

Approximate equivalent values between hardness and ultimate tensile strength.

HB	530	520	512	495	480	471	458	445	430	415	405	390	375
HRc	54	53	52	51,1	50,2	49,1	48,2	47	45,9	44,5	43,6	41,8	40,5
MPa	1.900	1.850	1.800	1.750	1.700	1.650	1.600	1.550	1.500	1.450	1.400	1.350	1.300

HB	360	350	330	320	305	294	284	265	252	238	225	209	195
HRc	38,8	37,6	35,5	34,2	32,4	31	29	27	--	--	--	--	--
MPa	1.250	1.200	1.150	1.100	1.050	1.000	950	900	850	800	750	700	650

Welding

Welding of KeyLos® 1730M can give quite good results if this procedure is observed:

Welding technique	TIG	MMA
Pre-heating at	250 ÷ 300 °C	
Recommended heat treatment	Stress relieving (see heat treatment paragraph)	

Process and materials selection for product recyclability

According to the potential of steel recycling, Lucchini RS is adopting a strategy for environmental excellence in designing and manufacturing of its tool steel grades, putting eco-effectiveness into practice.

The main adopted steps are:

- conducting an environmental assessment on processes and products, with the minimum use of virgin materials and non-renewable forms of energy;
- moving toward zero-waste manufacturing processes, considering that the ultimate destiny of a scrapped steel mould becomes food for the next steel making process, that is the “waste equals food” philosophy;
- conducting a life cycle assessment for each product and process, minimizing the environmental cost of product and service over its entire life cycles, from creation to disposal, that is the “Cradle to Cradle” philosophy.

Electrical Discharge Machining (EDM)

KeyLos® 1730M can be machined by EDM to obtain complex shape.

Afterwards it is advisable to stress relieving the material.

Photo-engraving

Thanks to modern production processes and to the low Sulphur content, KeyLos® 1730M is suitable for photo-engraving to obtain various patterns.

Polishing

KeyLos® 1730M is particularly suitable for polishing.



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