PLASTIC MOULD

KEYLOS®35

VALUE IN PERFORMANCE

THE CUSTOMISED SOLUTION FOR PLASTIC MOULDS

General characteristics

KEYLOS® 35 is Lucchini RS most recent and innovative tool steel for plastic moulds. If compared to the standard steel grades available on the market, such as AISI P20 mod. HH and WN 1.2738 mod. HH, KEYLOS® 35 can be considered an advanced solution dedicated to the plastic injection and compression moulds, especially for medium and big size.

The state-of-the art manufacturing process, together with the balanced chemical composition are key factors in ensuring the high quality and performances of KEYLOS® 35.

Thanks to special heat treatment process and suited chemical analysis KEYLOS® 35 is characterized by excellent hardenability across the block. The low carbon equivalent value improves the weldability and homogeneity.

Delivery conditions

KEYLOS® 35 is supplied in quenched and tempered condition in a wide dimensional range, from 200 mm up to 1000 mm in thickness.

The surface hardness is 320 – 360 HB and the mid-thickness hardness value is guaranteed in section up to 1000 mm, according to the following correlation: $(HB_{Surface,min\ required} - HB_{Core}) \leq 20HB$

The high hardness values throughout the block make KEYLOS® 35 steel grade particularly suitable for the most demanding application.

Main features

- Excellent hardness (at both sub-surface and mid-thickness)
- Excellent through-thickness homogeneity
- Excellent machinability
- Excellent toughness
- Excellent polishability and photo-engraving-ability
- Excellent thermal conductivity
- Excellent wear resistance
- Good weldability

Main application

KEYLOS® 35 is suitable for the manufacture of plastic moulds and frames of any size. It is recommended for use in plastic moulding of the most common polymers in medium and big sized moulds.

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Chemical analysis

	Range	C [%]	Si [%]	Mn [%]	Cr [%]	Mo [%]	Ni [%]	V [%]
KEYLOS®35 Alloying [% in weight]	min	0,27	-	-	-	-	-	-
	max	0,37	0,65	1,50	2,00	0,65	1,00	0,15

Comparison with international classifications:
W. Nr. 1.2738 mod. HH
AISI designation: P20 mod. HH

Physical and mechanical properties

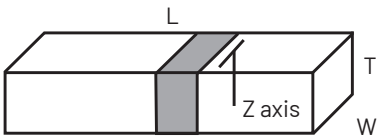
Main physical properties

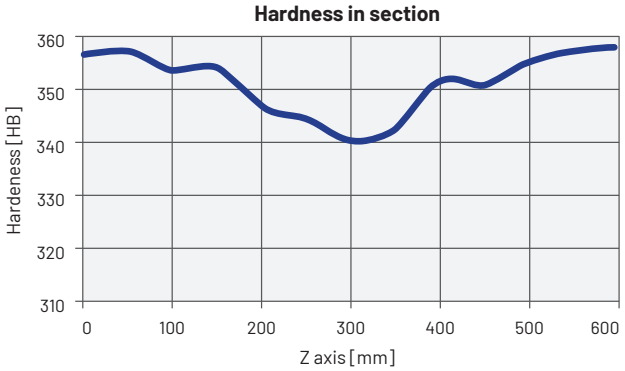
KEYLOS®35	20°C	200°C	400°C
Young modulus E [MPa]	209	192	178
Coefficient of linear thermal expansion α [10-6/K]	-	13.3	14.7
Thermal conductivity λ [W/mK] Compared to 1.2738	+15%	-	-

Main mechanical properties

KEYLOS®35	20°C	200°C
Ultimate tensile strength UTS [MPa]	1165	1025
Yield strength YS [MPa]	990	885
Elongation A [%]	17	21
Reduction in area Z [%]	52	58

Hardness profile





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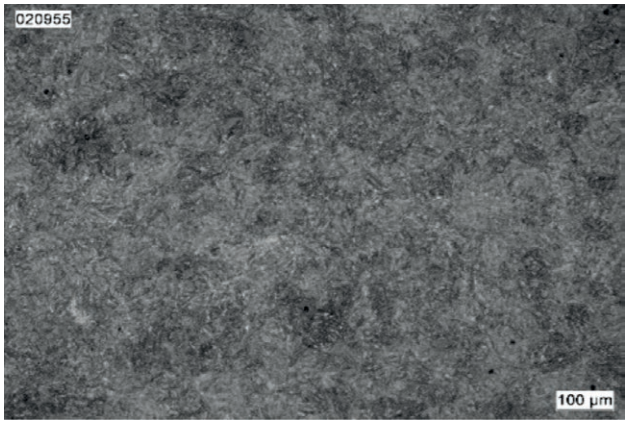
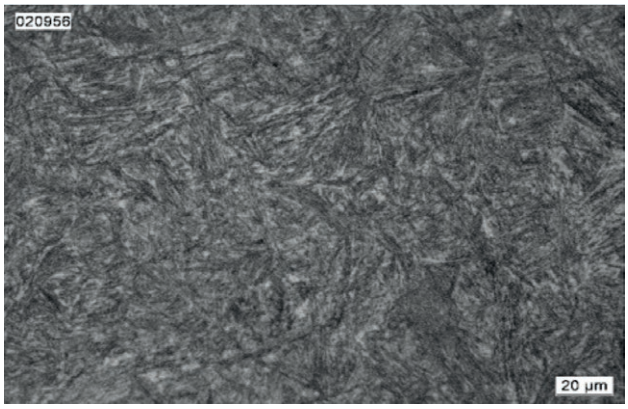
Microstructure

The main microstructure of KEYLOS® 35 is tempered martensite.

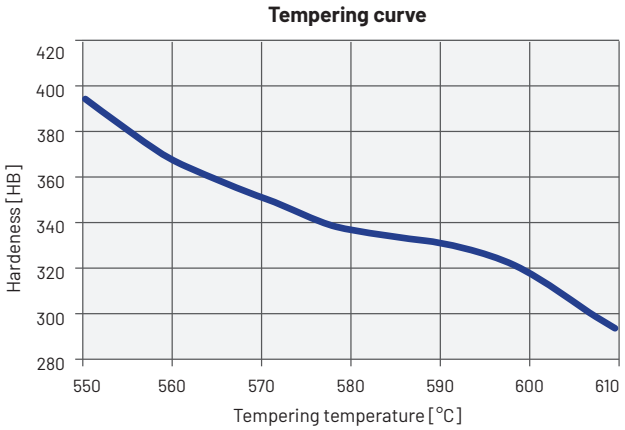


100x – Tempered martensite

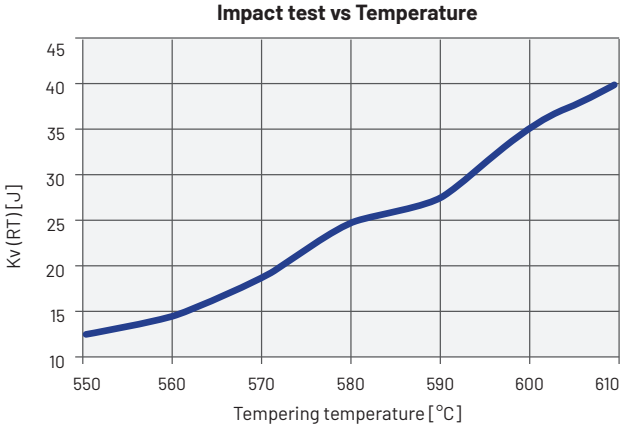


500x – Tempered martensite

Surface hardness vs tempering temperature



Toughness (Charpy V-notch test at 20°C) vs tempering temperature



Remark: the above data are representative of the typical behaviour of a 600 mm thick block made in KEYLOS® 35 and are reported for information only

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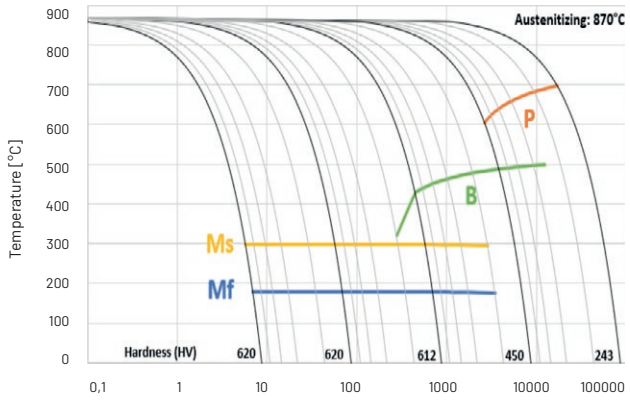
Heat treatment

KEYLOS® 35 is supplied in quenched and tempered conditions with no need for additional heat treatment operations.

However, if different hardness/heat treatment procedure are required, we recommend the following parameters.

Note that the reported data are for information purpose only and must be adjusted to the heat treatment facility and the dimensions of the block therefore, before carrying out any heat treatment operation, it is strongly recommended to contact Lucchini RS for help and support.

Continuous cooling transformation curve (CCT)



Soft annealing

Suggested temperature	700 °C
Soaking time	60 min every 25 mm thickness
Cooling	Slow cooling in furnace (20°C/h)

Soft annealing is useful to improve machinability reducing hardness at 250 HB.

Stress relieving

Suggested temperature	500 °C
Soaking time	60 min every 25 mm thickness
Cooling	Slow cooling in furnace (20°C/h)

Stress relieving is recommended to reduce the tensions generated by certain manufacturing operations (e.g. machining) without affecting the hardness in the as-delivered conditions.

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.

Hardening

Suggested temperature	900 °C
Soaking time	60 min every 25 mm thickness
Cooling	Polymer or water quench

Tempering

Suggested temperature	Depending on the required mechanical properties
Soaking time	120 min every 25 mm thickness
Cooling	Still air

The tempering temperature should be selected form the graph “Tempering curve” reported above.

After tempering we suggest to carry out stress relieving at temperature 50 °C lower than the last tempering temperature.

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Induction hardening

KEYLOS® 35 is suitable for induction hardening.
We recommend cooling at room temperature and tempering after induction hardening.

Nitriding

KEYLOS® 35 is suitable for ionic and gas nitriding.
This treatment is very useful for moulds subjected to extremely stressful applications.

The increase of the surface hardness, following nitriding, extends the component life cycle.

Up-to-date nitriding procedures allow to minimize the dimensional variation of the piece.

In order to obtain the best results, we recommend the following manufacturing procedure:

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

Polishing and photo-engraving

KEYLOS® 35 is the suitable material when polishing and photoengraving are needed. Thanks to its integrated manufacturing process, those material manufactured by Lucchini RS are characterized by a high degree of purity.

Polishing for graining: 4 Excellent
Suitability for medium gloss polishing: 4 Excellent
Suitability for mirror polishing: 3 Very Good – SPI A2
Suitability for engraving: 4 Excellent

Rating scale:
4 Excellent – 3 Very good – 2 Good – 1 Normal – 0 Unsuitable

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Guidance for machining

The following parameters are approximate only and must be adjusted to the specific application and machine tool.

Turning

	Rough machining	Finish machining		
Type of insert	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

	Rough machining		
Type of insert	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	(*)

	Pre-finishing		
Type of insert	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	(*)

	Finishing		
Type of insert	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

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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

Welding

In order to obtain the best results, we recommend the following procedure:

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

Electrical Discharge Machining (EDM)

KEYLOS® 35 can be machined by EDM to obtain complex shape. Afterwards we advise to carry out the stress relieving procedure

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 its tool steel grades, putting eco-effectiveness into practice.

The main adopted steps are:

- to carry out an environmental assessment on processes and products, with the minimum use of virgin materials and non-renewable forms of energy;
- to move toward zero-waste manufacturing processes, considering that the ultimate destination of scrapped steel moulds becomes food for the next steel making process, that is the "waste equals food" philosophy;
- to carry out a life cycle assessment for each product and process, minimizing the environmental cost of product and service over its complete life cycles, from creation to disposal, that is the "Cradle to Cradle" philosophy

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Quick comparison guide among the different steel grades

The following table shows a quick comparison among the main characteristics of pre-hardened steel grades traditionally used in plastic moulding.

Tool Steels for plastic														
		LUCCHINI							KEYLOS					
		1730	7225	2311	2312	2738	P20	P20HH	UP	30	35	40	35 EVO	40 EVO
HB	Min	-	220	280	280	290	290	320	280	290	320	360	320	360
	Max	250	270	330	330	340	330	360	330	330	360	400	360	400
Maximum thickness [mm]		300	400	500	500	1.000	1.000	1.000	800	1.000	1.000	500	1.300	800
Wear Resistance		1	1	2	2	2	2	3	2	2	3	4	3	4
Through Hardening in the section		1	1	2	2	3	3	3	3	4	4	4	4	4
Toughness		1	2	2	2	2	2	2	2	3	3	2	3	3
Machinability		3	2	2	3	2	2	2	2	2	2	2	2	2
Polishing		1	1	2	0	2	2	2	2	3	3	3	3	3
Photo-engraving		2	2	3	0	3	3	3	3	4	4	4	4	4
Welding (reparing)		3	3	2	2	2	3	3	2	3	3	3	3	3

4 Excellent **3 Very Good** **2 Good** **1 Normal** **0 Unsuitable**

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