

LUCCHINI 2738

**PRE-HARDENED MOULD STEEL
WITH AN HIGH DEGREE OF THROUGH
HARDENING AND MACHINABILITY**

**FORGING
VALUES
IN TOOL
STEELS**

IMPROVEMENT PASSION &
COURAGE GROUP SPIRIT
PEOPLE CUSTOMER SUCCESS

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LUCCHINI RS

General characteristics

LUCCHINI 2738 is the special pioneer pre-hardened alloyed steel for moulds with an high degree of through hardening, machinability and polishability.

LUCCHINI 2738 has been developed for large dimension moulds with an high degree of through hardening in the section, thanks to the special calibration of the chemical analysis, particularly due to the adding up to 1.30% Nickel by alloying.

Delivery conditions

LUCCHINI 2738 is normally supplied in the pre-hardened condition in a wide dimensional range up to 1000 mm in thickness.

The surface hardness is 290-340 HB and the mid-thickness hardness value is guaranteed in section up to 1000 mm, according to the following correlation: $(HB_{\text{Surface, min required}} - HB_{\text{Core}}) \leq 20HB$

Main features

- excellent machinability;
- very good suitability for photo-engraving;
- very good suitability for polishing;
- excellent suitability for nitriding, in order to increase the wear resistance;
- good wear resistance in the whole section of the mould;
- internal homogeneous hardness on blocks with thickness up to 1000 mm in the whole section of the mould;

Main application

Plastic moulding:

- medium and big sized moulds for the automotive industry;
- moulds for food industry products;
- moulds for rubber pressing;
- pressure moulds (SMC, BMC);
- bolsters.

Extrusion:

- dies and gauges for PVC extrusion;
- mechanical parts for extrusion presses.

Chemical analysis

	Range	C [%]	Si [%]	Mn [%]	Cr [%]	Mo [%]	Ni [%]	V [%]
LUCCHINI 2738	min	0,35	0,20	1,40	1,80	0,15	0,90	0,35
Alloying [% in weight]	max	0,45	0,40	1,70	2,20	0,30	1,30	0,45

Comparison with international classifications:

W. Nr. 1.2738

DIN EN ISO 4957 40CrMnNiMo8.6.4

Physical and mechanical properties

Main physical properties

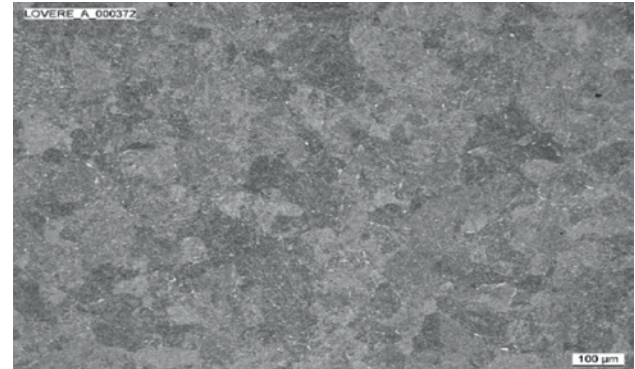
LUCCHINI 2738	20°C	250°C	500°C
Young modulus E [MPa]	210	196	177
Coefficient of linear thermal expansion α [10 ⁻⁶ /K]	-	12,7	14,3
Thermal conductivity λ [W/mK]	32,0	31,1	30,0

Main mechanical properties

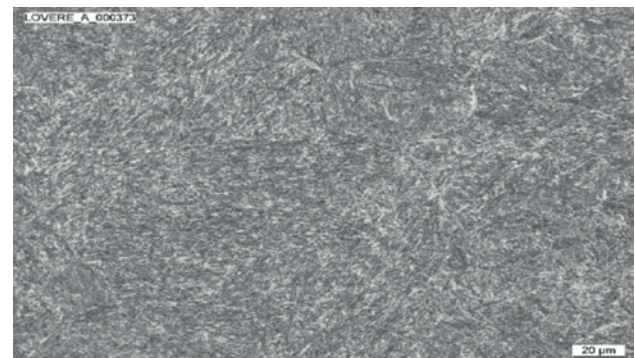
LUCCHINI 2738	20°C	200°C
Ultimate tensile strength UTS [MPa]	1.020	900
Yield strength YS [MPa]	880	750
Elongation A [%]	15	17
Reduction in area Z [%]	48	50

Microstructure

The main microstructure of LUCCHINI 2738 is tempered martensite.

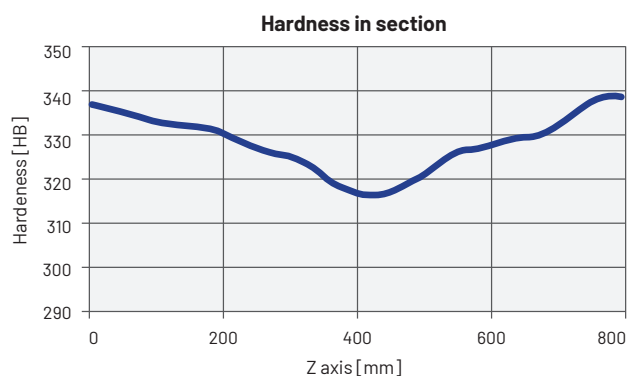
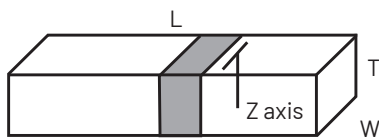


100x

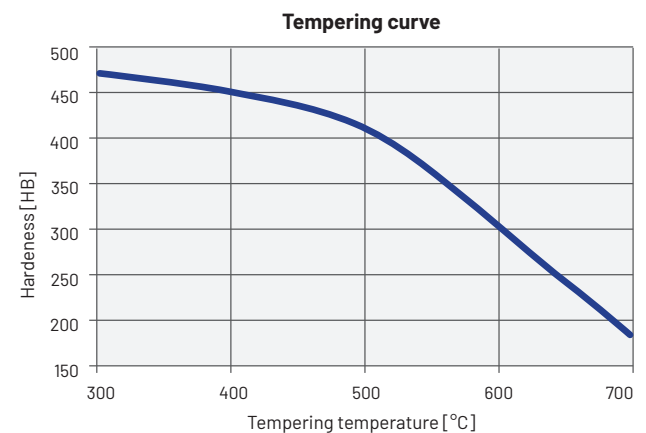


500x

Hardness profile



Surface hardness vs tempering temperature



Remark: the above data are representative of the typical behaviour of a 800 mm thick block made in LUCCHINI 2738 and are reported for information only

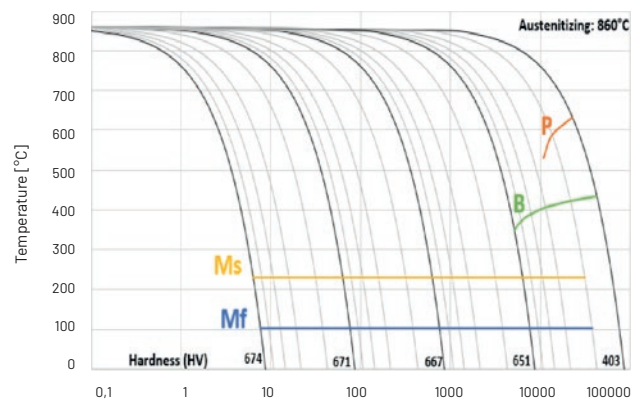
Heat treatment

LUCCHINI 2738 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	860 °C
Soaking time	60 min every 25 mm thickness
Cooling	Room temperature

Tempering

Suggested temperature	Depending on the required mechanical properties
Soaking time	120 min every 25 mm thickness
Cooling	Polymer or water quench

The tempering temperature should be selected from 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.

Induction hardening

LUCCHINI 2738 is suitable for induction hardening. We recommend cooling at room temperature and tempering after induction hardening.

Nitriding

LUCCHINI 2738 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.

Other properties can be deeper analysed against specific Customer request: please contact our Metallurgy Department.

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.

Polishing and photo-engraving

LUCCHINI 2738 is not suitable material when high polishing and photoengraving properties are needed.

Polishing for graining: 3 Very good

Suitability for medium gloss polishing: 3 Very good

Suitability for mirror polishing: 2 Good

Suitability for engraving: 3 Very good

Rating scale:

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

Guidance for machining

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

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

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)

LUCCHINI 2738 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

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	35 EVO	40 EVO
HB	Min	-	220	280	280	290	290	320	280	290	320	320	360
	Max	250	270	330	330	340	330	360	330	330	360	360	400
Maximum thickness [mm]		300	400	500	500	1.000	1.000	1.000	800	1.000	1.000	1.300	800
Wear Resistance		1	1	2	2	2	2	3	2	2	3	3	4
Through Hardening in the section		1	1	2	2	3	3	3	3	4	4	4	4
Toughness		1	2	2	2	2	2	2	2	3	3	3	3
Machinability		3	2	2	3	2	2	2	2	2	2	2	2
Polishing		1	1	2	0	2	2	2	2	3	3	3	3
Photo-engraving		2	2	3	0	3	3	3	3	4	4	4	4
Welding (reparing)		3	3	2	2	2	3	3	2	3	3	3	3

4 Excellent 3 Very Good 2 Good 1 Normal 0 Unsuitable

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