

I Buderus Plastic Mould Steel Thruhard Supreme® 2738mod.TS(HHH)

	C	Si	Mn	P	S	Cr	Ni	Mo	V
Typical analysis	0.26	0.10	1.45	0.015	0.002	1.25	1.05	0.70	0.15

Figures in % by mass

Its higher hardness compared to Thruhard Supreme® HH is achieved by its optimised chemical composition

Characteristics

The HHH-Variant of Thruhard Supreme® distinguished from the HH-Variant by:

- I Higher hardness and better through-hardening
- I Polishability up to 1200 grit
- I Grain reliability even with sensitive etch-graining designs
- I Improved weldability
- I Higher thermal conductivity.

Nitridable, hard chrome plateable, flame hardenable as delivered; its higher basic hardness provides better support for surface finishing (such as PVD coating).

For high gloss polish requirements we recommend Thruhard Diamond®.

Applications

Compression and injection moulds to accommodate large dimensions such as bumpers, dashboards, chairs, rubbish bins, bottle crates, television cabinets, etc.

Delivered condition

- I Thruhard Supreme® HHH
Quenched and tempered to 355–400 HB (Δ approx. 1200–1350 MPa)*

Physical properties (reference values)

	20–100 °C	20–250 °C	20–500 °C
Thermal expansion coefficient ($10^{-6}/K$)	10.8	12.2	13.9
Thermal conductivity (W/mK)	20 °C 37.4	250 °C 41.3	500 °C 39.8
Young's modulus (GPa)	20 °C 204	250 °C 188	500 °C 160

* Surface hardness in Brinell, converted to DIN EN ISO 18265, Table A.1

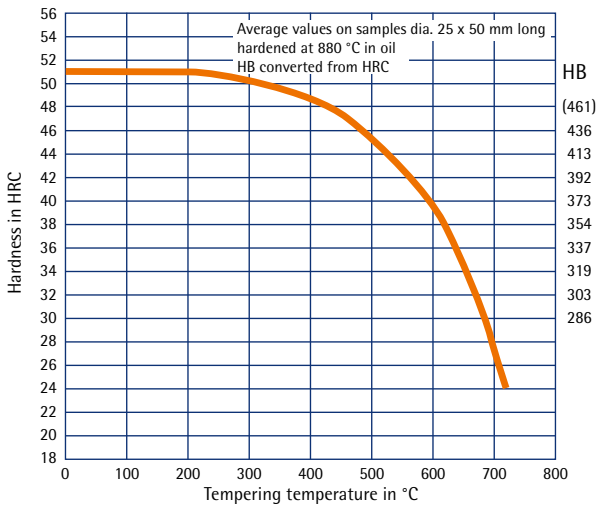


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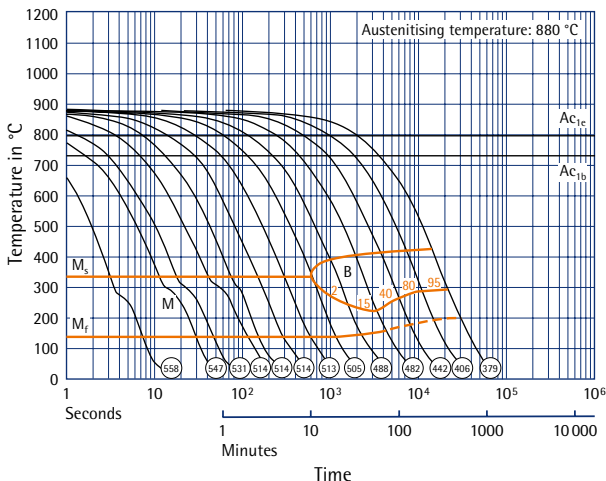
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Heat treatment	
Stress relieving	Temperature: Approx. 520 °C in the quenched and tempered state Duration: 1 hour per 50 mm wall thickness Cooling: Furnace
Soft annealing	Temperature: 720 °C Duration: 1 hour per 25 mm wall thickness Cooling: Furnace
Hardening	Temperature: 880 °C Duration: 1 minute per mm wall thickness
Quenching hardness	Max. 51 HRC in water, polymer, oil or vacuum
Tempering	Temperature: See tempering curve Duration: 1 hour per 25 mm wall thickness Cooling: Air
Working hardness	340–400 HB

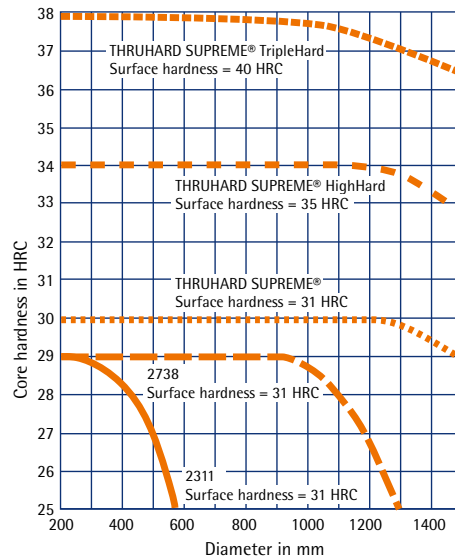
Tempering curve



TTT curve (continuous)



Through-hardenability (schematic)



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