



2767 MOULD STEEL

TYPICAL ANALYSIS				BS4659	BP30
C	Ni	Cr	Mo		
0.45	4.10	1.30	0.30	Werkstoff	1.2767

An air or oil hardening die steel of great strength and toughness.

2767 hardens uniformly through comparatively large masses and so with the ability to take a good polish the steel finds wide application as a steel for plastic moulding. The high strength of the steel also enables it to be used in a variety of engineering applications.

APPLICATIONS

Plastic moulding dies, zinc diecasting dies, extrusion die holders and press components, engineering components requiring high strength.

ANNEALING

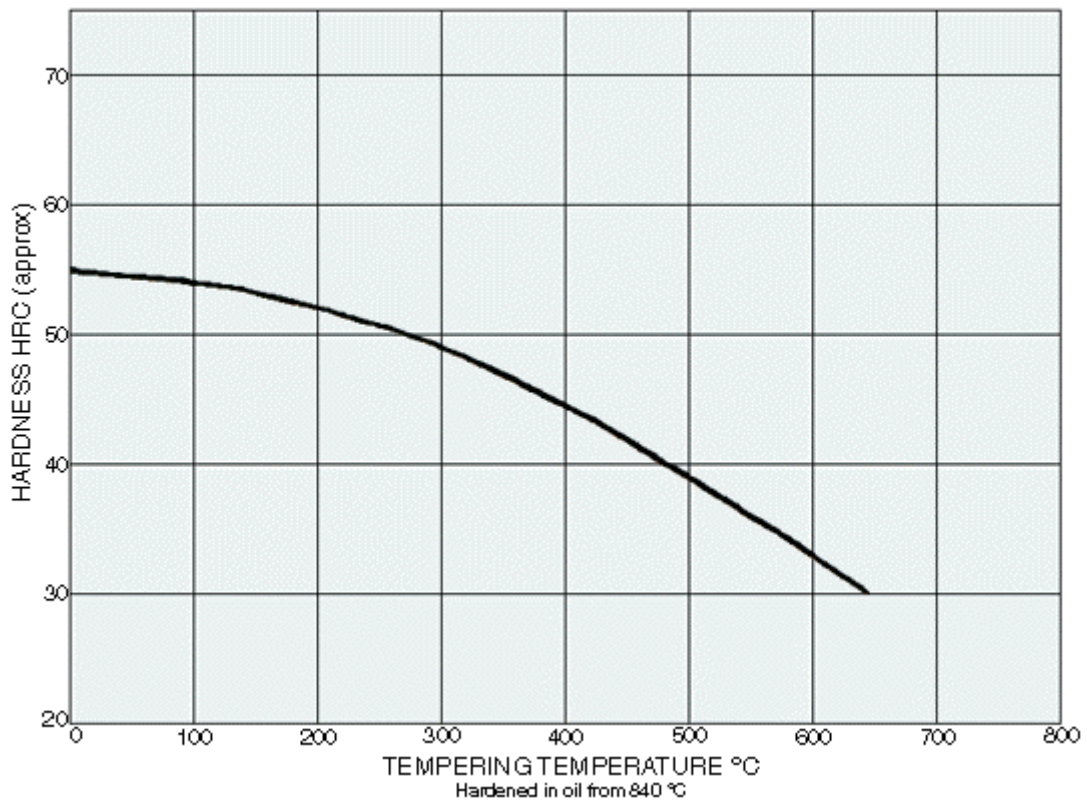
Heat slowly to 630°C / 650°C, soak thoroughly for six hours and furnace cool. The usual annealed hardness is up to 285 HB.

STRESS RELIEVING

Heat to 650°C / 750°C. Hold for 2-4 hours and furnace cool.

HARDENING

Before heat treatment, sufficient machining should be carried out to remove surface decarburisation. Preheat thoroughly to 650°C / 700°C, and then raise more rapidly to 830°C / 850°C in a controlled atmosphere furnace or preferably, a neutral salt bath. Air cool or quench in oil, the latter being advised for large masses when maximum hardness is required.



TEMPERING

Heat to the required temperature for a minimum of one hour and then air cool. A hot air circulation furnace may be used.

HARDNESS

Tempering Temperature	HV	HRC
140°C / 160°C	550 - 582	53 - 55
200°C / 220°C	507 - 550	50 - 53
500°C / 520°C	373 - 393	38 - 40
600°C / 620°C	274 - 305	26 - 30