

I Buderus Plastic Mould Steel 2311 ISO-BM

	C	Si	Mn	P	S	Cr	Mo
Typical analysis	0.38	0.30	1.50	0.020	0.003	2.00	0.20
Chemical composition as per SEL	0.35–0.45	0.20–0.40	1.30–1.60	≤ 0.035	≤ 0.035	1.80–2.10	0.15–0.25

Figures in % by mass

Register of European Steels (SEL)	40 CrMnMo 7
DIN EN ISO 4957	40 CrMnMo 7
AFNOR	40 CMD 8
AISI	~ P 20
BS	~ P 20

Characteristics

Standard mould steel, economical to machine, easy to polish, hard chrome plateable, grain reliable, for dimensions ≤ 400 mm thick.

Where there is a requirement for

- I Higher hardness and better through-hardenability
- I Polishability > 320 grit
- I Sensitive etch designs (e.g. HNO₃)
- I Higher thermal conductivity

we recommend grade 2738mod.TS(HH).

Applications

Small and medium-sized injection moulds, press moulds and mould frames up to 400 mm thick.

Delivered condition

Quenched and tempered to 280–325 HB (Δ approx. 950–1100 MPa)*

Physical properties (reference values)

Thermal expansion coefficient (10 ⁻⁶ /K)	20–100 °C	20–250 °C	20–500 °C
	11.6	12.8	14.3
Thermal conductivity (W/mK)	20 °C	250 °C	500 °C
	34.0	33.5	33.0
Young's modulus (GPa)	20 °C	250 °C	500 °C
	212	197	175

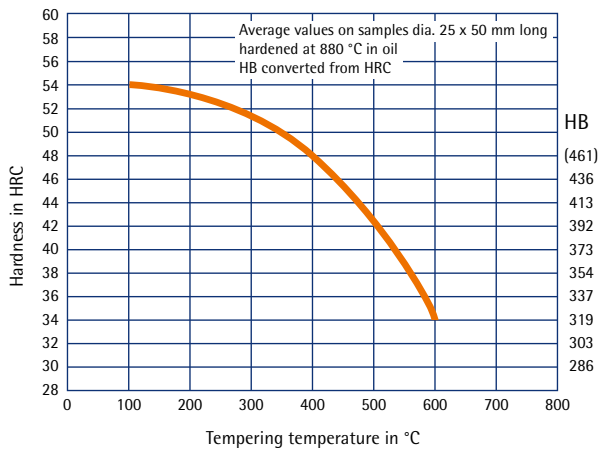
* Surface hardness in Brinell, converted to DIN EN ISO 18265, Table A.1

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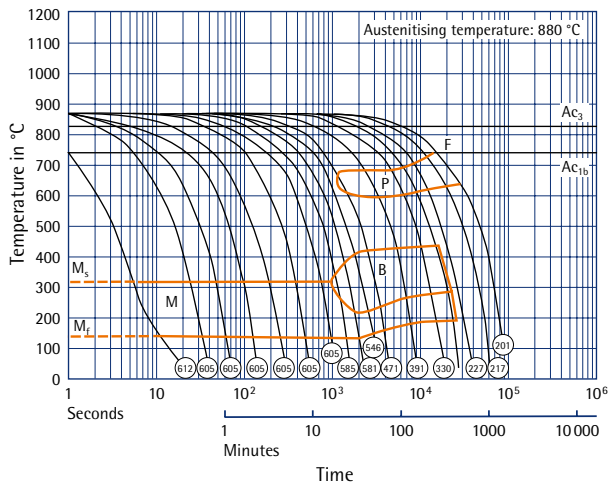
Heat treatment

Stress relieving	Temperature: Approx. 550 °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. 54 HRC in oil, hot bath or vacuum
Tempering	Temperature: See tempering curve Duration: 1 hour per 25 mm wall thickness Cooling: Air
Working hardness	280–325 HB

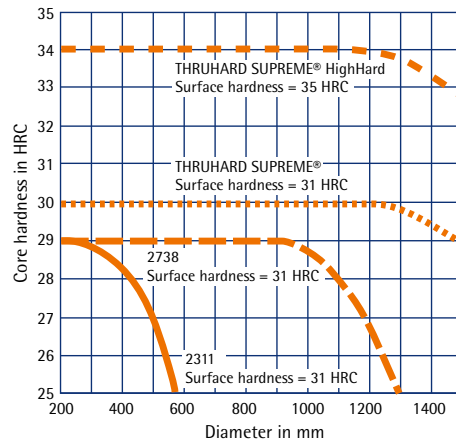
Tempering curve



TTT curve (continuous)



Through-hardenability (schematic)



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