



MD®Xtra

~AISI P20mod - 1.2738mod (HH)
**QUALITY PREHARDENED
 MOLD STEEL**

TYPICAL APPLICATIONS

- Injection molds of any size
- Grained or Textured molds
- Compression molds
- Long run molds
- Abrasive plastic injection molds
- Reinforced plastic injection molds
- Dies for non corrosive plastic extrusion

GENERAL:

Delivery Condition:

Hardened and tempered

Surface Hardness Range:

	BHN	HRC	N/mm ²
Regular	285-321	30-34	963-1082
High Hard	321-352	34-38	1082-1202
Super Hard	363-401	39-43	1255-1393

MD®Xtra is a new **patented** prehardened mold steel grade specially designed for through hardenability, ease of machining and simple post-production mold maintenance. It has high impact strength and **very high thermal conductivity**. The well-balanced chemistry assures homogeneous hardness and near no section hardness loss due to mass.

MD®Xtra is forged on our largest presses equipped with wide dies assuring maximum deformation during forging process.

MD®Xtra is forged using a special densifying process which assures optimum consolidation of centers.

Typical Chemical Analysis - % weight

C	Mn	Si	Ni	Cr	Mo	Other
0.26	1.00	0.35	0.60	1.45	0.55	Micro alloying

MD®Xtra is melted to a low sulphur content to enhance polishability.

MD®Xtra is quenched in water. Best properties in steel are produced with the highest achievable quench severity.

MD®Xtra is characterized by :

- Highest thermal conductivity
- Improved through hardenability
- Prehardened high strength steel
- Good polishability
- Excellent weldability
- Uniform hardness
- Superior texturing
- Improved wear resistance

MD®Xtra is 100 % ultrasonic tested to very stringent acceptance levels. It is defect free.

MD®Xtra high hardenability ensures hardness loss from surface to core of 3 HRC points, even on molds up to 45" (1150 mm) with deep impressions.

MD®Xtra is an excellent material for Photo-Etching & Texturing. The patented low alloy composition minimizes segregation.

®Finkl Steel Trademark

DATA SHEET

QUALITY PREHARDENED MOLD STEEL

MD[®]Xtra

MATERIAL CHARACTERISTICS

The benefits of high through hardness are:

- Stable and continued machining can be performed with (C.N.C.) automatic machines.
- A defect free machined surface can be obtained.
- Dimensional stability of parting lines.

Structure

After hardening and tempering, the structure of MD[®]Xtra consists of tempered martensite to fine bainite.

The benefits of the through hardness combined with a uniform and stable micro-structure are :

- For mold design, consistent properties are assured.
- The machining distortion is minimized in the finished mold.
- A uniform luster can be obtained upon surface polishing.

PROPERTIES MD[®]Xtra

• Cleanliness:

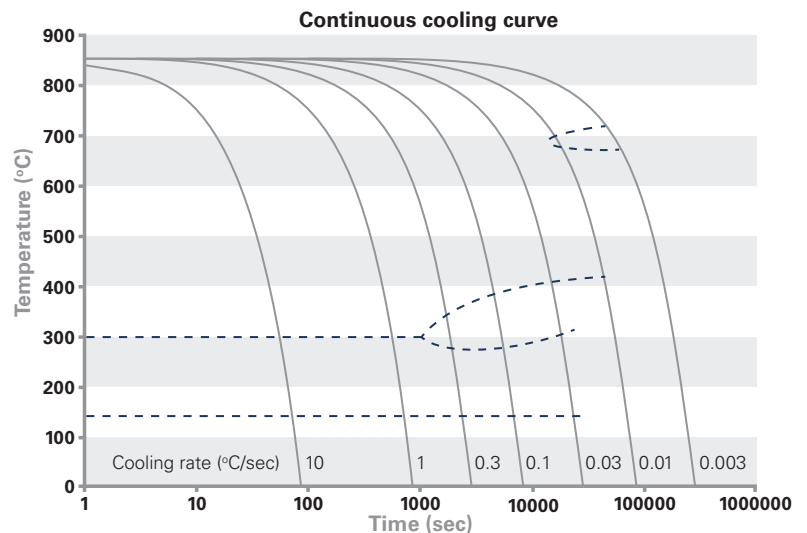
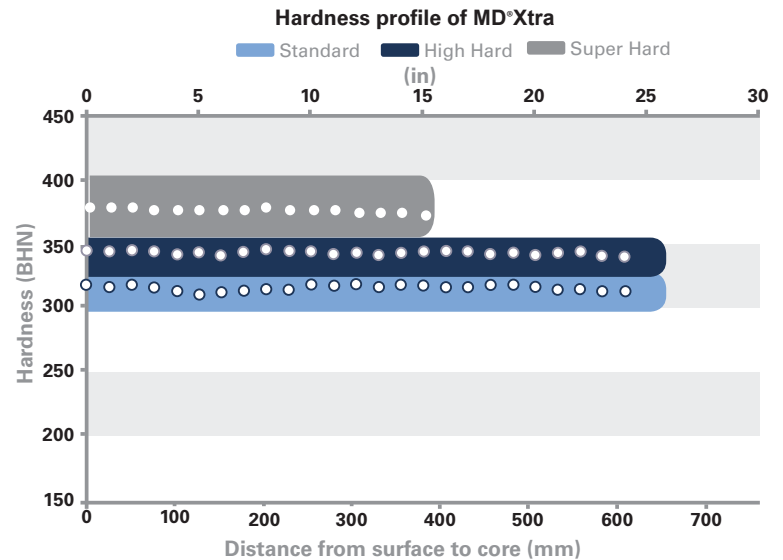
Method	A	B	C	D
ASTM E45	≤ 1.5	≤ 1.0	≤ 0.5	≤ 1.0
DIN 50602	K4 ≤ 20			

• Physical Properties:

Thermal conductivity	Thermal expansion coefficient (10 ⁻⁶ K ⁻¹)			Thermal capacity	Density
W/m*K (BTU/hr*ft*°F)	25-100 °C	25-300 °C	25-400°C	(J/Kg*K)	-
>45 (26)	12.3	13.7	14.8	620	7.68

• Mechanical Properties : Typical values for a 4" (101.6 mm) thick plate.

Hardness range	Hardness BHN (HRC)	Y.S. 0.2 MPa (KSI)	UTS MPa (KSI)	EI (%)	Impact@RT J (Ft-lb)	
					Long.	Trans.
285-321 BHN	311 (33)	827 (120)	979 (142)	> 15	111 (82)	108 (80)
321-352 BHN	331 (36)	924 (134)	1062 (154)	> 15	88 (65)	81 (60)
363-401 BHN	363 (39)	1007 (146)	1124 (163)	> 15	34 (25)	30 (22)



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MD[®]Xtra

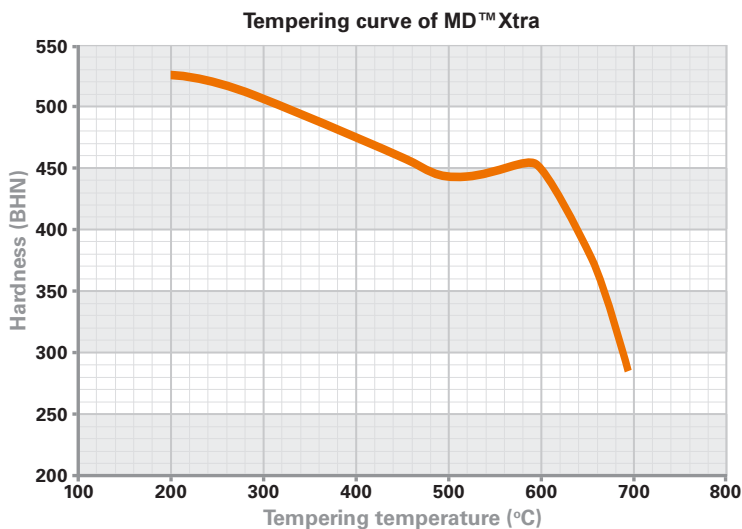
HEAT TREATMENT

Attainable Hardness of MD[®]Xtra

Quenched from 1650 °F (900 °C)

and Tempered 4 hours

(Size of section – 4" X 4" (101.6 mm X 101.6 mm))



Stress Relieving

Heat at a rate of one hour per inch (25.4 mm) of maximum thickness to 850 to 900 °F (454-482 °C)

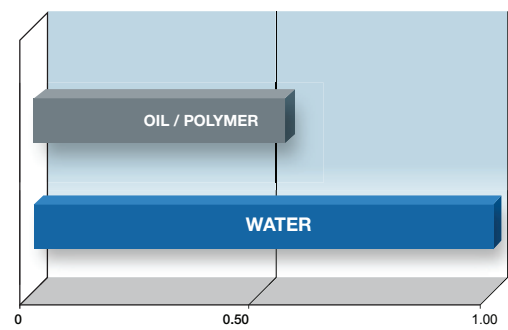
Hold at temperature for one hour per inch (25.4 mm) and air cool.

Tempering

Tempering treatments vary for different sizes and applications. The following instructions will provide through tempering:

Heat uniformly at the selected tempering temperatures and hold at temperature for one hour per inch (25.4 mm) of total thickness.

Relative Quenching Power:



INDUCTION AND LASER HARDENING

MD[®]Xtra lends itself to induction or laser hardening of selective surfaces creating a surface hardness of up to 60-63 HRC varying in depth from skin hardness up to 0.125" (3 mm).

EDM (ELECTRIC DISCHARGE MACHINING)

This method of machining is widely used on prehardened MD[®]Xtra. However, precaution should be taken since this method of machining leaves a rehardened surface layer (white layer) on the steel. It is advisable to remove this layer.

HARD-CHROMIUM PLATING

After hard-chromium plating, the tool should be tempered for a minimum of four (4) hours at 350 °F (180 °C) in order to avoid hydrogen embrittlement. In case of replating, the tool should be tempered after it has been acid stripped.

DATA SHEET

QUALITY PREHARDENED MOLD STEEL MD®Xtra

TEXTURING

MD®Xtra offers excellent response to texturing because of the great homogeneity of its structure and patented low alloy composition.

POLISHING

Successful polishing requires talent, patience and experience. But some known basics are:

- Practice extreme cleanliness between steps to avoid carryover of contaminant particles
- Use high quality consumables
- Over polishing is detrimental to the steel surface leading to so called orange-peeling and pitting

When the requirements for finish are particularly high (600 up to 1200 grit), it is recommended to use **MD®Xtra SuperHard**. For high gloss finish or SPI A1 and greater, it is recommended to use grade **MLQ®Xtra**.

SIZE MD®Xtra REGULAR AND HIGH HARD

(As forged / approx.)

Max weight	25 000 kg	55 000 lbs
Max section	1.55 m ²	2400 sq in
Max width	2 130 mm	84"
Max thickness	1 245 mm	49"

SIZE MD®Xtra SUPER HARD

(As forged / approx.)

Max weight	25 000 kg	55 000 lbs
Max section	1.55 m ²	2400 sq in
Max width	1 900 mm	75"
Max thickness	815 mm	32"

Surface Finish Chart

Steel Requirements	Finish	ISO	AISI Grit	P-Grade	RMS (microns)	Ra (nm)	SPI
Electric Arc - Vacuum Degassed and LMF Refined steel Hardened to Standard Hardness	Non Show Part		60	P60	250	-	
			80	P80	180	1140	
			120	P120	106	1050	
			180	P180	75	880	
			240	P220	63	300	
+ Hardened to Higher Hardness*	Painted Part	6	320	P360	40.5	230	B-3
		5	400	P800	25.8	120	B-2
		4	600	P1200	15.3	110	B-1
+ Remelted (ESR or VAR)	Technical Gloss	2	1200	P2400		100	A-3
	High Gloss	1		P4000		50	A-2
+ 2nd Remelt (VAR)	Optical Gloss	0				<25	-

**Depending on polishing technique it is possible to achieve finish with different hardness of material before changing quality level*

Note: Provided technical data and information in this data sheet are typical values. Normal variations in chemistry, size and conditions of heat treatment may cause deviations from these values. We suggest that information be verified at time of enquiry or order. For additional data or metallurgical assistance, please contact us.

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