MD®Xtra
~AISI P20mod - 1.2738mod (HH)
QUALITY PREHARDENED MOLD STEEL

TYPICAL APPLICATIONS
- Molds for painted parts of any size
- Grained or Textured molds
- Mold for Chrome-Plated parts
- Compression molds
- Long run molds
- Abrasive or filled plastic injection molds
- Dies for non corrosive plastic extrusion

GENERAL
Delivery Condition:
Hardened and tempered
Surface Hardness Range:

<table>
<thead>
<tr>
<th></th>
<th>BHN</th>
<th>HRC</th>
<th>N/mm²</th>
</tr>
</thead>
<tbody>
<tr>
<td>Regular</td>
<td>285-321</td>
<td>30-34</td>
<td>963-1082</td>
</tr>
<tr>
<td>High Hard</td>
<td>321-352</td>
<td>34-38</td>
<td>1082-1202</td>
</tr>
<tr>
<td>Super Hard</td>
<td>363-401</td>
<td>39-43</td>
<td>1255-1393</td>
</tr>
</tbody>
</table>

MD®Xtra is a new patented pre-hardened 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 nearly no section hardness loss due to mass.

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

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

Typical Chemical Analysis* - % weight

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Ni</th>
<th>Cr</th>
<th>Mo</th>
<th>Other</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.26</td>
<td>1.00</td>
<td>0.35</td>
<td>0.60</td>
<td>1.45</td>
<td>0.55</td>
<td>Micro alloying</td>
</tr>
</tbody>
</table>

*Covered under one or more of the following U.S. Patents: 10,260,122; 10,294,538

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
- 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
MATERIAL CHARACTERISTICS

Uniform, high through-hardness assures:
- Stable and continued machining with with automatic (CNC) machines
- Defect-free machined surfaces
- Dimensional stability of parting lines

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

The benefits of through hardness combined with a uniform and stable microstructure 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

Microcleanliness

<table>
<thead>
<tr>
<th>Method</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM E45</td>
<td>≤ 1.5</td>
<td>≤ 1.0</td>
<td>≤ 0.5</td>
<td>≤ 1.0</td>
</tr>
<tr>
<td>DIN 50602</td>
<td>K4 ≤ 20</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Physical Properties

<table>
<thead>
<tr>
<th>Thermal conductivity</th>
<th>Thermal expansion coefficient ($10^6$ K⁻¹)</th>
<th>Thermal capacity (J/Kg*K)</th>
<th>Density</th>
</tr>
</thead>
<tbody>
<tr>
<td>W/m<em>K (BTU/hr</em>ft°F)</td>
<td>25-100 °C</td>
<td>25-300 °C</td>
<td>25-400°C</td>
</tr>
<tr>
<td>&gt;45 (26)</td>
<td>12.3</td>
<td>13.7</td>
<td>14.8</td>
</tr>
<tr>
<td></td>
<td></td>
<td>620</td>
<td>7.68</td>
</tr>
</tbody>
</table>

Mechanical Properties

Typical values for a 102mm (4") thick plate

<table>
<thead>
<tr>
<th>Hardness range</th>
<th>Hardness BHN (HRC)</th>
<th>Y.S. 0.2 MPa (KSI)</th>
<th>UTS MPa (KSI)</th>
<th>El (%)</th>
<th>Impact @RT J (Ft-lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Long.</td>
</tr>
<tr>
<td>285-321 BHN</td>
<td>311 (33)</td>
<td>827 (120)</td>
<td>979 (142)</td>
<td>&gt; 15</td>
<td>111 (82)</td>
</tr>
<tr>
<td>321-352 BHN</td>
<td>331 (36)</td>
<td>924 (134)</td>
<td>1062 (154)</td>
<td>&gt; 15</td>
<td>88 (65)</td>
</tr>
<tr>
<td>363-401 BHN</td>
<td>363 (39)</td>
<td>1007 (146)</td>
<td>1124 (163)</td>
<td>&gt; 15</td>
<td>34 (25)</td>
</tr>
</tbody>
</table>
DATA SHEET
QUALITY PREHARDENED MOLD STEEL
MD®Xtra

HEAT TREATMENT

Attainable Hardness of MD®Xtra
Quenched from 900 °C (1650 °F) and Tempered 4 hours
Size of section – 102mm X 102mm (4” X 4”)

Stress Relieving
To minimize risk of distortion in service or during maintenance (welding), it is recommended to stress relieve tooling after roughing stages. Heat uniformly to 850 to 900 °F (454-482 °C). Hold at temperature for one hour per inch (25.4 mm) of total thickness and air cool.

Tempering
Tempering treatments vary for different sizes and applications. To ensure through-tempering, heat uniformly at the selected tempering temperature and hold at temperature for one hour per inch (25.4 mm) of total thickness.

INDUCTION AND LASER HARDENING
MD®Xtra lends itself well 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 hours at 350 °F (180 °C) to avoid hydrogen embrittlement. When re-plating, the tool should be tempered after it has been acid stripped.

BALITHERM PRIMEFORM
The BALITHERM PRIMEFORM treatment has a significant influence on the surface hardness of MD®Xtra. An increase in surface hardness of more than 100% for all MD®Xtra delivery conditions is possible with no loss of base hardness, and for MD®Xtra Super Hard, values up to 66 HRC have been demonstrated. This hardness increase provides superior resistance to abrasive wear during the injection of long glass fiber thermoplastics and makes mirror polishing easier. As an added benefit, repair and retreatment of the mold is possible without stripping the surface treatment.
TEXTURING

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

POLISHING

Successful polishing requires talent, patience and experience. Some basic best practices include:

- 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 (800 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.)*

<table>
<thead>
<tr>
<th>Max weight</th>
<th>25000 kg</th>
<th>55000 lbs</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max section</td>
<td>1.55 m²</td>
<td>2400 sq in</td>
</tr>
<tr>
<td>Max width</td>
<td>2130 mm</td>
<td>84”</td>
</tr>
<tr>
<td>Max thickness</td>
<td>1245 mm</td>
<td>49”</td>
</tr>
</tbody>
</table>

### SIZE MD®Xtra SUPER HARD
*(As-forged / approx.)*

<table>
<thead>
<tr>
<th>Max weight</th>
<th>25000 kg</th>
<th>55000 lbs</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max section</td>
<td>1.55 m²</td>
<td>2400 sq in</td>
</tr>
<tr>
<td>Max width</td>
<td>1900 mm</td>
<td>75”</td>
</tr>
<tr>
<td>Max thickness</td>
<td>815 mm</td>
<td>32”</td>
</tr>
</tbody>
</table>

METALLURGICAL SERVICE

Finkl Metallurgical Laboratories provide standard mechanical properties testing for Tensile Testing (ASTM A370), Impact Testing (ASTM E23), Hardness Testing (ASTM E10, E18, A956), Macroetch Testing (ASTM E381), and other metallurgical testing with certification of results when requested.

Metallurgical facilities are made available to customers through your Sales Representative to assist in analysis of technical issues that may arise during processing or performance of Finkl forgings. Reports and consultation are offered as a service to customers with the aim of improving product performance.

**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.