



ATT 2085 MOD (2085)

CHEMICAL ANALYSIS (PERCENTAGE BY MASS)

	C	Si	Mn	P	S	Cr	Ni
Guide analysis	0.34	0.30	0.95	0.025	0.100	15.0	
Standard	0.28 - 0.38	≤1.00	≤1.40	≤0.030	0.050-0.100	15.00 - 17.00	≤1.00

CHARACTERISTICS

Corrosion-resistant mold steel with higher sulfur content compared with ATT 2316 MOD for very good machining properties.

SEL	X33CrS16
AFNOR	~Z33CS16
AISI	~422 + S

APPLICATION

Mold frames and mold assemblies for corrosion-resistant injection molding dies.

Not suitable for contour-giving mold parts.

DELIVERED CONDITION

Quenched and tempered to 265 - 310 HB.*

PHYSICAL PROPERTIES

Thermal Conductivity (W/m.K) at	20°C	250°C	500°C
	23.0	24.0	25.0
Thermal Expansion (µm/m) from 20°C to	100°C	250°C	500°C
	10.0	12.0	13.2
	20°C	250°C	500°C
Young's modulus (GPa)	20°C	250°C	500°C
	215	203	180

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

The information contained herein is intended to provide general knowledge on our products and their uses. It should not be construed as a warranty of specific properties of the products described, or a warranty of fitness for a particular purpose. Each user of products from Advanced Tooling Tek (Shanghai) Co Ltd ("ATT") is responsible for making its own determination as to the suitability of ATT's products and services.



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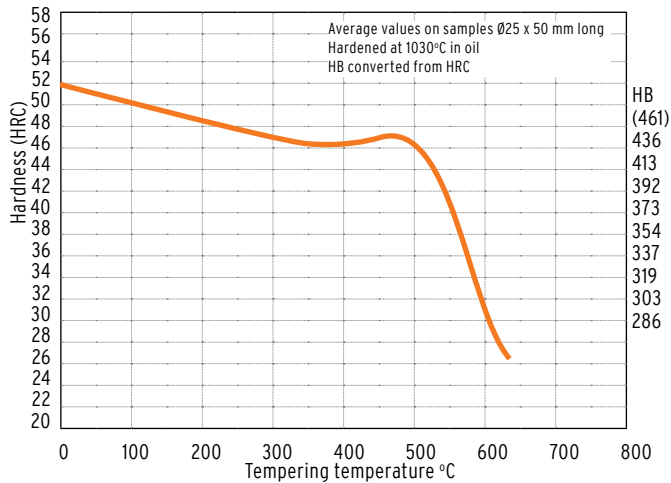


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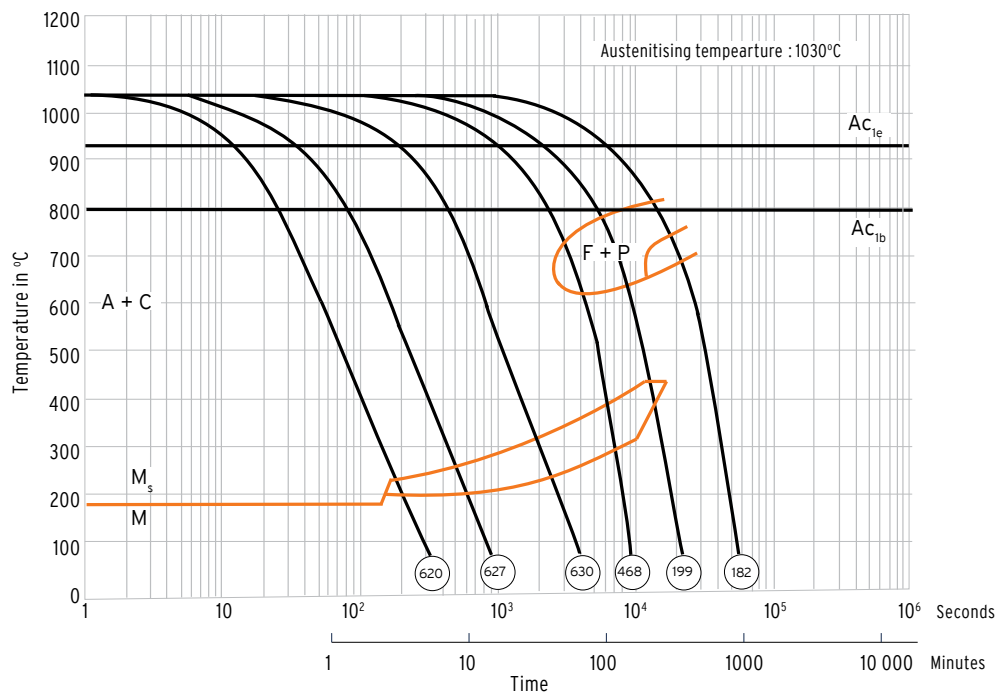
HEAT TREATMENT

Stress relieving	Temperature	Approx. 500°C in the quenched and tempered state
	Duration	1 hour per 50 mm wall thickness
	Cooling	Furnace
Soft annealing	Temperature	820°C
	Duration	1 hour per 25mm wall thickness
	Cooling	Furnace
Hardening	Temperature	1030°C
	Duration	1 min per mm wall thickness
Quenching hardness	Max. 48 HRC	in oil or vacuum
	Temperature	See tempering curve
Tempering	Duration	1 hour per 25 mm wall thickness
	Cooling	Air
Working hardness	265-310 HB	

Tempering curve



TTT curve (continuous)



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