

# CORRAX®

## Precipitation Hardening Stainless Mold Steel

### Heat Treatment Recommendations

Hardness as a Function of Temperature, 4 hours at temperature		
Aging	Aging Temperature/Time*	Hardness
Heat tool from cold furnace to minimize distortion	975°F (525°C)/4hr	47-49 HRC
	1050°F (565°C)/4hr	45-47 HRC
	1075°F (580°C)/4hr	43-45 HRC
	1100°F (600°C)/4hr	39-42 HRC
	1150°F (620°C)/4hr	33-35 HRC

\*Holding time after the tool or part has fully heated through

Holding Time as a Function of Thickness	
Thickness	Aging Time Once Tool Comes to Temperature
1-6"	4 hours
6-10"	6 hours**
> 10"	8 hours**

\*\*Hardness of surface and core will be 1-2 HRC points less than shown for 4 hour aging time.

Dimensional Changes as a Function of Temperature, %				
Dimensional Changes	Aging	Longitudinal	Transverse	Short Transverse
As a function of temperature shrinkage will occur as shown, dependant on the aging temperature	975°F (525°C)/4h	-0.07	-0.07	-0.07
	1050°F (565°C)/4h	-0.08	-0.08	-0.08
	1075°F (580°C)/4h	-0.10	-0.10	-0.10
	1100°F (600°C)/4h	-0.14	-0.14	-0.14
	1150°F (620°C)/4h	-0.25	-0.25	-0.25

### **CORRAX - Precipitation hardening stainless mold steel**

- Extremely high corrosion resistance: low maintenance costs
- Simple heat treatment, 33-49 HRC: great flexibility
- High toughness, excellent stability: long-life molds

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should not therefore be construed as a warranty of specific properties of the products described or a warranty for fitness for a particular purpose.



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