

Steel and hardness recommendations

DIE PART	TIN/LEAD/ZINC	ALUMINIUM/MAGNESIUM	COPPER, BRASS
CLAMPING PLATES HOLDER PLATES	HOLDAX (prehardened) ~310 HB IMPAX SUPREME (prehardened) ~310 HB	HOLDAX (prehardened) ~310 HB IMPAX SUPREME (prehardened) ~310 HB	HOLDAX (prehardened) ~310 HB IMPAX SUPREME (prehardened) ~310 HB
DIE INSERTS	IMPAX SUPREME ~310 HB ORVAR SUPREME ORVAR SUPERIOR 46–52 HRC UNIMAX 52–56 HRC	DIEVAR 44–50 HRC ORVAR SUPREME ORVAR SUPERIOR VIDAR SUPERIOR 42–48 HRC UNIMAX**	QRO 90 SUPREME 40–46 HRC ORVAR SUPREME ORVAR SUPERIOR 40–46 HRC
FIXED INSERTS CORES	ORVAR SUPREME ORVAR SUPERIOR 46–52 HRC	DIEVAR 46–50 HRC ORVAR SUPREME ORVAR SUPERIOR VIDAR SUPERIOR 44–48 HRC QRO 90 SUPREME 42–48 HRC	QRO 90 SUPREME 40–46 HRC
CORE PINS	ORVAR SUPREME 46–52 HRC	QRO 90 SUPREME* 44–48 HRC QRO 90 HT*	QRO 90 SUPREME 42–46 HRC QRO 90 HT
SPRUE PARTS	ORVAR SUPREME 48–52 HRC	ORVAR SUPREME ORVAR SUPERIOR 46–48 HRC QRO 90 SUPREME 44–46 HRC	QRO 90 SUPREME 42–46 HRC
NOZZLES	STAVAX ESR 40–44 HRC ORVAR SUPREME 35–44 HRC	ORVAR SUPREME ORVAR SUPERIOR 42–48 HRC QRO 90 SUPREME 42–46 HRC	QRO 90 SUPREME 40–44 HRC ORVAR SUPREME ORVAR SUPERIOR 42–48 HRC
EJECTOR PINS	QRO 90 SUPREME ORVAR SUPREME 46–50 HRC (nitrided)	QRO 90 SUPREME ORVAR SUPREME 46–50 HRC (nitrided)	QRO 90 SUPREME ORVAR SUPREME 46–50 HRC (nitrided)
PLUNGER SHOT SLEEVES	ORVAR SUPREME 42–46 HRC (nitrided)	ORVAR SUPREME ORVAR SUPERIOR 42–48 HRC (nitrided) QRO 90 SUPREME 42–48 HRC (nitrided)	QRO 90 SUPREME 42–46 HRC (nitrided) ORVAR SUPREME ORVAR SUPERIOR 42–46 HRC (nitrided)

* Surface treatment is recommended

** For small Mg die inserts where a good erosion resistance is needed.