

CHANGZHOU  
CHANGHONG  
MOULD

**CCM**



CCM ( Changzhou Changhong Moulds )  
is recognized as one of the premier  
producer of copper moulds in China,  
been manufacturing and supplying  
copper moulds for the last 20 years.

One of the few manufacturers  
that is capable of machining dies and  
moulds in-house which shortens  
supply chain downtime.



2011



2009

1995







	SQUARE / RECTANGULAR TUBES	ROUND / OVAL TUBES	NON- STANDARD / BEAM BLANK TUBES
SIZE	50 X 50 ~ 650 X 650 / (100 - 500) X 650	D110 - D1500	535 - 150 X 120 - 70
CAMBER RADIUS	3000 ~ 17000 (ALSO STRAIGHT)	5000 - 17000 (ALSO STRAIGHT)	6000 - 14000
THICKNESS	6 - 50	10 - 50	12 - 50
LENGTH	602 - 1100	602 - 900	700 - 1016

# MOULD TUBES





	SLAB	BEAM BLANK	RECTA NGULAR	THIN SLAB	ULTRA THIN SLAB
LENGTH	350 - 3800	350 - 900	700 - 900	1200 - 2000	1530
WIDTH	700 - 1000	300 - 1000	200 - 3000	1100 - 1200	1100
THICKNESS	30 - 75	35 - 300	30 - 70		
MATERIAL	Cr-Zu-Cu, CuAg				
COATING	Ni-Co, Cr, Ni-Fe			Ni-Co, Cr	

# MOULD PLATES



# MOULD MATERIALS

	TEMP	UNIT	CuHDP	CuAg0.1	CuCrZr
			P0.015~0.040	Ag0.08~0.12 P0.004~0.012	Cr0.30~1.20 Zr0.03~0.20
ELECT.CONDUCTIVITY	20	%IACS	83	95	80
THERMAL.CONDUCTIVITY	20	W/(m.K)	340	372	330
COEFFICIENT OF THERMAL RECRYSTALLISATION TEMP.	20-300	10 <sup>-6</sup> /K	17.1	17.1	17.2
MODULUS OF ELASTICITY	20	10 <sup>3</sup> MPa	120	123	126
MELTING POINT		C	1083	1083	1078
SPECIFIC GRAVITY		g/cm <sup>3</sup>	8.9	8.9	8.9
MAX. TENSILE STRENGTH	20	MPa	240-310	240-310	375-445
MAX. TENSILE STRENGTH	100	MPa	190-270	230-270	365-425
MAX. TENSILE STRENGTH	200	MPa	140-190	205-240	365-410
MAX. TENSILE STRENGTH	300	MPa		175-210	335-375
MAX. TENSILE STRENGTH	400	MPa		145-160	315-350
0.2 YIELD POINT STRENGTH	20	MPa	190-250	200-225	280-355
0.2 YIELD POINT STRENGTH	100	MPa	185-260	195-240	270-345
0.2 YIELD POINT STRENGTH	200	MPa		180-225	260-330
0.2 YIELD POINT STRENGTH	300	MPa		165-215	250-320
0.2 YIELD POINT STRENGTH	400	MPa		130-145	240-290
ELONGATION	20	%	25-10	16-10	20-13
HARDNESS	20	HB	80-95	110-125	115-130

\*\* TP2 ( GB/T5231-2001 ) = SF-Cu / DHP-Cu ( DIN1787 )

# QUALITY ASSURANCE





CHANGZHOU  
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MOULD



**CCM**

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