

Miilux Protection 380/400/450/500 Datasheet

Chemical composition content % maximum (ladle analysis)

Steel grade	Thickness	C	Si	Mn	P	S	Cr	Ni	Mo	B
Miilux® Protection 380	6–25 mm	0,13	0,40	1,40	0,020	0,010	1,50	0,40	0,40	0,005
Miilux® Protection 400	5–40 mm	0,20	0,70	1,70	0,030	0,015	1,50	0,40	0,50	0,004
Miilux® Protection 450	5–40 mm	0,26	0,60	1,50	0,030	0,015	1,50	0,70	0,50	0,005
Miilux® Protection 500	2,5–40 mm	0,30	0,70	1,70	0,030	0,015	1,50	0,80	0,50	0,004

Typical mechanical properties

Steel grade	Thickness	Yield strength Rp 0.2 N/mm ²	Tensile strength Rm N/mm ²	Elongation A5 %	Impact Charpy-V -40°C Kv	Hardness Range HBW
Miilux® Protection 380	6–25 mm	800	1000	12	20 J	320–370
Miilux® Protection 400	5–40 mm	1000	1250	10	30 J	360–420
Miilux® Protection 450	5–40 mm	1200	1450	8	30 J	420–480
Miilux® Protection 500	2,5–40 mm	1250	1600	8	20 J	480–540

Technical specification of Miilux® Protection 500

Class acc. to EN 1522	Thickness of the test (nominal)	Type of weapon	Calibre	Type of bullet	Weight of the bullet	Shooting distance	Speed of the bullet V2,5 (m/s)
FB3	2,5 mm	Revolver	357 Mag.	Fulljacket, coned bulled, soft core	10,2 g	5 m	430 ± 10 m/s
FB4	3,0 mm	Revolver	44 Rem. Mag.	Fulljacket, flat nose, soft core	15,6 g	5 m	440 ± 10 m/s
	4,2 mm	Rifle	7,62 x 39 mm	AK-47 M43	8,0 g	10 m	720 ± 10 m/s
FB5	6,0 mm	Rifle	5,56 x 45 mm	SS109 (M855)	4,0 g	10 m	950 ± 10 m/s
FB6	6,0 mm	Rifle	7,62 x 51 mm	M80 Nato Ball	9,5 g	10 m	830 ± 10 m/s
FB7	14,0 mm	Rifle	7,62 x 51 mm	P80 Nato AP	9,5 g	10 m	820 ± 10 m/s
Stanag 4569 Level 1	6,0 mm	Rifle	7,62 x 51 mm	M80 Nato Ball	9,5 g	30 m	833 ± 20 m/s
	6,0 mm		5,56 x 45 mm	SS109 (M855)	4,0 g	30 m	900 ± 20 m/s
	9,0 mm		5,56 x 45 mm	M193	3,5 g	30 m	937 ± 20 m/s
Stanag 4569 Level 2	12,0 mm	Rifle	7,62 x 39 mm	API BZ	7,7 g	30 m	695 ± 20 m/s
Stanag 4569 Level 3	24,0 mm	Rifle	7,62 x 51 mm	AP (WC core)	8,4 g	30 m	930 ± 20 m/s
	16,0 mm		7,62 x 54R mm	B32 API	10,3 g	30 m	854 ± 20 m/s

Above mentioned test results are according to EN 1522 and Stanag 4569, but we have tested also other classes e.g. MIL-A 46100D. Ask for more information about delivery-specific tests from technical customer service and sales.

Miilux Protection 380 | 400 | 450 | 500

BALLISTIC STEEL PLATES AND COMPONENTS FOR HUMAN PROTECTION

DELIVERY CONDITION

- Quenched

TOLERANCES

- Dimensions according to EN 10029 or EN 10051
- Thickness according to EN 10029 class C and flatness according to EN 10029 class N, steel type H

SURFACE CONDITION

- According to EN 10163-2 class B subclass 3

GENERAL TECHNICAL DELIVERY CONDITION

- According to EN 10021. Unless otherwise agreed.
Inspection documents EN 10204-2.2. Issued in English.

Dimensional tolerances according to EN 10029

Plate thickness in mm	Tolerances in mm
3 – 4	- 0,0 + 0,35
5 – 6	- 0,0 + 0,70
7 – 9	- 0,0 + 0,90
10 – 13	- 0,0 + 1,00
> 13	- 0,0 + 1,10

Other thickness tolerances by special agreement.



MACHINING

Miilux Protection products can be machined with rapid steel and hard metal (HSS) drills with a satisfactory service life if the drill advance and cutting speed are correspondingly accommodated.

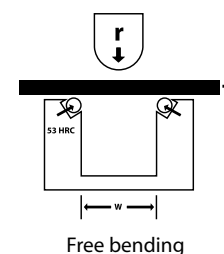
WELDING

Miilux Protection 380 and 400 can be welded well. Miilux Protection 450 and 500 are more limited with heat input and maximum welding energy. With Miilux Protection 380 and 400 preheating is needed when combined plate thickness is more than 40 mm and with Miilux Protection 450 and 500 when combined plate thickness is more than 20 mm. More information available in Miilux Protection welding brochure.

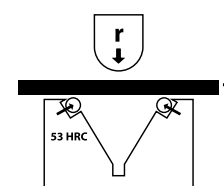
Cold forming Cold forming directive limits

Steel grade	Plate thickness (mm)	Free bending < 90° rounding radius of press/ plate thickness R/t Bending line to rolling direction		Free bending -Free hole width/plate thickness W/t		Bottoming 90° -Free hole width/ plate thickness W/t
		Transverse	Longitudinal	Transverse	Longitudinal	
Miilux® Protection 380	6 – 20	2,5	3,0	9,0	9,0	~ 15,0
Miilux® Protection 400	5 – 20	3,0	4,0	9,0	11,0	~ 15,0
Miilux® Protection 450	5 – 20	4,0	5,0	11,0	13,0	~ 15,0
Miilux® Protection 500	2,5 – 20	~ 10,0	~ 12,0	23,0	27,0	-

Bending should be done with one press | Slow pressing speed is recommended | Lower tool should be roller-type (see drawings)



Free bending



Bottoming



Miilux Ltd

Ruonankatu 1, 92100 Raahe, Finland

Tel. +358 8 2113 500

Fax. +358 8 2113 692

www.miilux.fi

www.miiluxprotection.fi

Veikko Kyllönen

Export Director

Mob: +358 40 773 8562

veikko.kyllonen@miilux.fi



ISO 9001
ISO 14001
ISO 3834-2
OHSAS 18001

