

S I N T E R I N G - D A T A - S H E E T

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	Diabro 901063
-----------------------	---------------

main component:	Cu	binder:		date:	08.04.99
machine type:	DSP-25	aver. Grain size	<63 µm	testperson:	CW
utilisation:					

heating by	die:	X	temperature measurement by:	pyroscope:	
	punches:			thermocouple:	X

temperature:	°C	540	580	620	660	700	740		
specific pressure:	N/mm ²	25	==>						
machine pressure:	bar	40	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	42	57	68	70	69	67		
hardness scattering:	HRB	39-47	56-58	67-70	69-70	68-70	66-69		
weight:	g	17	==>						
weight after sintering:	g	16,88	17,047	16,771	16,888	16,646	16,899		

volume: V = G _s - G _w	cm ³	2,03	1,997	1,903	1,899	1,868	1,898		
density: D = G _s / V	g/cm ³	8,31	8,54	8,81	8,89	8,91	8,9		

weight loss: G = G _e - G _s	g								
rel. Weight loss: Gr = G * 100 / G _e	%								

notes:	
---------------	--

Attention:

Depending on mould-geometry and type and place of temperature-measurement an increase up to 60 °C must be done to get the same result !

Property of Dr. Fritsch KG. Transmission only allowed in explicit agreement with the management.