

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

DR. FRITSCH GmbH & Co. KG

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powder - code:	Diafe 5000
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main component:	Fe	binder:		date:	26.04.94
machine type:	DSP-25	aver. Grain size	5 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	820	860	900	940	980	1020	1060	
specific pressure:	N/mm ²	35	==>						
machine pressure:	bar	55	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	66	68	58	60	59	60	64	
hardness scattering:	HRB	64-69	68-69	58-60	59-61	58-60	60-61	62-66	
weight:	g	20	==>						
weight after sintering:	g	19,503	19,667	19,659	19,497	19,667	19,46	19,623	

volume: V = G _s - G _w	cm ³	2,54	2,537	2,537	2,551	2,556	2,532	2,545	
density: D = G _s / V	g/cm ³	7,68	7,75	7,75	7,64	7,69	7,69	7,71	

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

notes:	
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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 !

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