

SINTERING-DATA-SHEET

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powder - code:	Diafe 7500
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main component:	Fe	binder:	2% alcohol	date:	07.02.2007
machine type:	DSP-25	aver. Grain size		testperson:	OE
utilisation:					

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

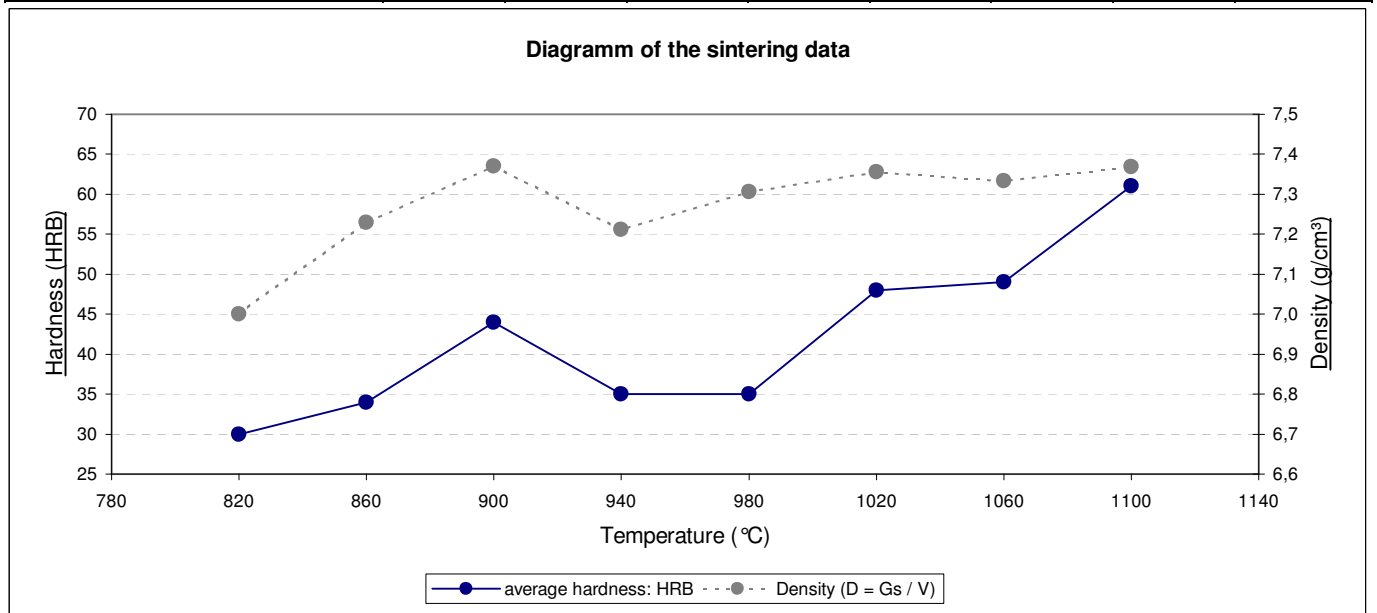
temperature:	$^{\circ}\text{C}$	820	860	900	940	980	1020	1060	1100
specific pressure:	N/mm^2	35	==>						
sintering time:	min	3	==>						

bending strength:	N/mm^2								
stretch at break:	%								
average hardness:	HRB	30	34	44	35	35	48	49	61
hardness scattering:	HRB	24-36	36-44	39-50		24-40	42-55	45-56	55-69
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	cm^3								
Density ($D = G_s / V$)	g/cm^3	7,00	7,23	7,37	7,21	7,31	7,36	7,33	7,37

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($G_r = G * 10$)	%			6,83					

notes:			extrusion	==>					
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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 !
 In case of moulds with a high number of graphite punches a certain friction value needs to be considered. To obtain the detailed formula you are welcome to contact us.

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