

SINTERING-DATA-SHEET

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DR. FRITSCH GmbH & Co. KG

powder - code: Fe3P with app. 16 % P

main component:	Fe	binder:	2% alcohol	date:	16.10.09
machine type:	DSP-25	aver. Grain size		testperson:	OE
utilisation:	Hardener for Iron				

heating by	die:	X	temperature measure-	pyroscope:	
	punches:		ment by:	thermocouple:	X

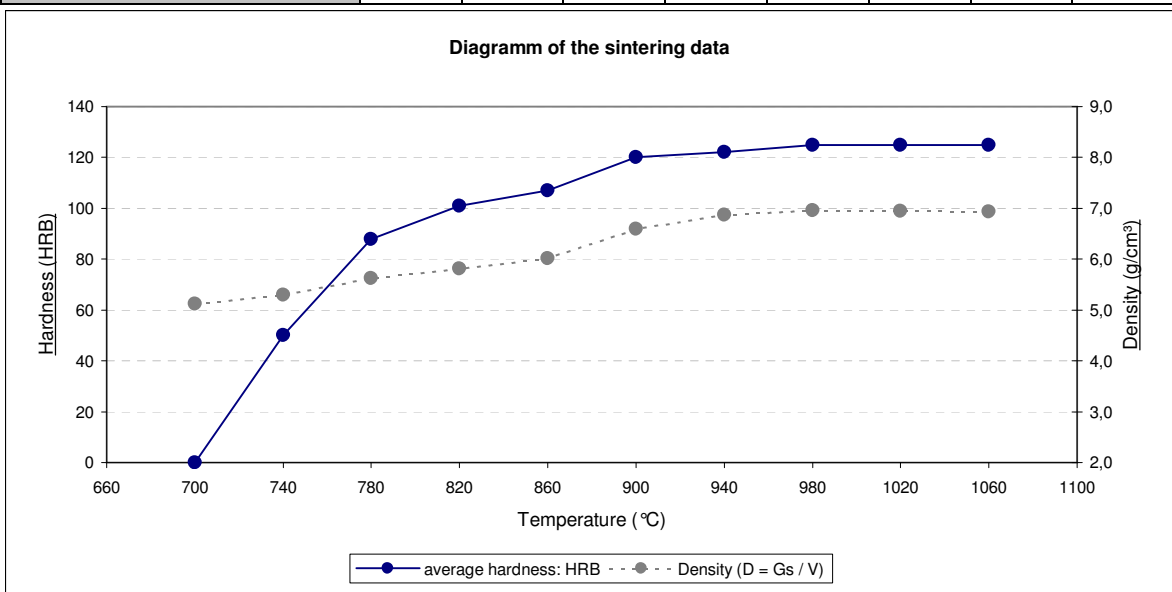
temperature:	°C	700	740	780	820	860	900	940	980	1020	1060
specific pressure:	N/mm ²	35	==>								
sintering time:	min	3	==>								

bending strength:	N/mm ²										
stretch at break:	%										
average hardness:	HRB	-	50	88	101	107	120	122	125	125	125
hardness scattering:	HRB	-	41-57	84-92	99-103	103-111	119-120	121-122	124-125	124-125	125
average hardness:	HRC										
hardness scattering:	HRC										
weight:	g	17	==>								
weight after sintering:	g										

Volume ($V = G_s - G_w$)	cm ³										
Density ($D = G_s / V$)	g/cm ³	5,12	5,30	5,63	5,82	6,01	6,60	6,87	6,96	6,95	6,93

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

notes: broken



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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