

SINTERING-DATA-SHEET

DR. FRITSCH KG

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powder - code:	Diacob-4001
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main component:	Co	binder:	Dry	date:	09.01.02
machine type:	DSP-25	aver. Grain size	app. 5 µm	testperson:	Mö
utilisation:					

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

temperature:	<i>°C</i>	780	820	860	900	940	980	1020	1060
specific pressure:	<i>N/mm²</i>	35	==>						
machine pressure:	<i>bar</i>	55	==>						
sintering time:	<i>min</i>	3	==>						
bending strength:	<i>N/mm²</i>								
stretch at break:	<i>%</i>								
average hardness:	<i>HRB</i>	102	106	106	107	106	106	99	98
hardness scattering:	<i>HRB</i>	101-102	106-107	105-106	106-107	105-107	106-107	98-100	96-99
weight:	<i>g</i>	17	==>						
weight after sintering:	<i>g</i>	16,717	16,419	15,994	16,543	16,689	15,755	16,672	16,466

volume: V = G _s - G _w	<i>cm³</i>	1,969	1,871	1,829	1,884	1,9	1,796	1,901	1,873
density: D = G _s / V	<i>g/cm³</i>	8,49	8,77	8,75	8,78	8,78	8,77	8,77	8,79

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

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 !

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