

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:	Diacobtuc 90/10
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main component:	Co	binder:	2% alcohol	date:	09.12.99
machine type:	DSP-25	aver. Grain size		testperson:	Mö
utilisation:					

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

temperature:	$^{\circ}\text{C}$	980	1020	1060	1100	1140			
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	102	103	103	103	99			
hardness scattering:	HRB	101-104	102-104	102-104	102-104	97-102			
weight:	g	20	==>						
weight after sintering:	g	19,498	19,043	19,16	19,324	19,333			

volume: $V = G_s - G_w$	cm^3	2,157	2,1	2,125	2,146	2,19			
density: $D = G_s / V$	g/cm^3	9,04	9,07	9,02	9	8,83			

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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