

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

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	BD-11
-----------------------	-------

main component:	Co	binder:	2% alcohol	date:	9.03.01
machine type:	DSP-25	aver. Grain size		testperson:	CW
utilisation:					

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

temperature:	°C	740	780	820	860	900	940		
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	104	106	106	106	104	99		
hardness scattering:	HRB	104-105	105-107	105-106	106-107	102-105	98-101		
weight:	g	17							
weight after sintering:	g	16,544	15,628	16,264	16,307	16,232	16,658		

volume:									
V = G_s - G_w	cm ³	1,893	1,785	1,857	1,862	1,852	1,900		
density:									
D = G_s / V	g/cm ³	8,74	8,75	8,76	8,76	8,76	8,77		

weight loss:									
G = G_e - G_s	g								
rel. Weight loss:									
Gr = G * 100 / G_e	%								

notes:	
---------------	--

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.