

# 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

<b>powder - code:</b>	BD-126
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<b>main component:</b>	Co	<b>binder:</b>	2% alcohol	<b>date:</b>	10.07.92
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>	4 µm	<b>testperson:</b>	Ga
<b>utilisation:</b>					

<b>heating by</b>	<b>die:</b>	X	<b>temperature measurement by:</b>	<b>pyroscope:</b>	
	<b>punches:</b>			<b>thermocouple:</b>	X

<b>temperature:</b>	°C	860	900	940	980	1020			
<b>specific pressure:</b>	N/mm <sup>2</sup>	35	==>						
<b>machine pressure:</b>	bar	55	==>						
<b>sintering time:</b>	min	3	==>						
<b>bending strength:</b>	N/mm <sup>2</sup>								
<b>stretch at break:</b>	%								
<b>average hardness:</b>	HRB	97	101	102	101	101			
<b>hardness scattering:</b>	HRB	97-98	101-102	101-102	101-102	101-102			
<b>weight:</b>	g	20	==>						
<b>weight after sintering:</b>	g	19,275	18,251	18,82	19,512	18,651			

<b>volume:</b>									
<b>V = G<sub>s</sub> - G<sub>w</sub></b>	cm <sup>3</sup>	2,283	2,169	2,175	2,244	2,146			
<b>density:</b>									
<b>D = G<sub>s</sub> / V</b>	g/cm <sup>3</sup>	8,44	8,41	8,65	8,7	8,69			

<b>weight loss:</b>									
<b>G = G<sub>e</sub> - G<sub>s</sub></b>	g								
<b>rel. Weight loss:</b>									
<b>Gr = G * 100 / G<sub>e</sub></b>	%								

<b>notes:</b>	
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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.