

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

DR. FRITSCH KG

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powder - code:	DZ-6
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main component:	Ni	binder:	2% Alkohol	date:	14.11.01
machine type:	DSP-25	aver. Grain size		testperson:	Mö
utilisation:					

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

temperature:	$^{\circ}\text{C}$	780	820	860	900	940	980		
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	95	98	100	102	102	98		
hardness scattering:	HRB	95-96	98	100-101	100-103	102-103	95-99		
weight:	g	20	==>						
weight after sintering:	g	19,615	19,549	19,699	19,653	19,216	16,703		

volume:									
$V = G_s - G_w$	cm^3	2,351	2,322	2,335	2,327	2,275	1,967		
density:									
$D = G_s / V$	g/cm^3	8,34	8,42	8,44	8,45	8,45	8,49		

weight loss:									
$G = G_e - G_s$	g						3,297		
rel. Weight loss:									
$\text{Gr} = G * 100 / G_e$	%						16,49		

notes:	==> liquid
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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.