

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:	Diabro 851563
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main component:	Cu	binder:	2% alcohol	date:	16.03.93
machine type:	DSP-25	aver. Grain size	<63 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	520	560	600	640	680	720		
specific pressure:	N/mm ²	35	==>						
machine pressure:	bar	80	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	86	88	88	88	86	84		
hardness scattering:	HRB	85-87	86-89	87-90	86-89	85-86	83-84		
weight:	g	20	==>						
weight after sintering:	g	19,261	19,913	20,006	19,955	19,893	19,932		

volume:									
V = G_s - G_w	cm ³	2,177	2,248	2,258	2,25	2,263	2,254		
density:									
D = G_s / V	g/cm ³	8,85	8,86	8,86	8,87	8,85	8,84		

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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