

# 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>	Diabro 901063
-----------------------	---------------

<b>main component:</b>	Cu	<b>binder:</b>		<b>date:</b>	08.04.99
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>	<63 µm	<b>testperson:</b>	CW
<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	540	580	620	660	700	740		
<b>specific pressure:</b>	N/mm <sup>2</sup>	25	==>						
<b>machine pressure:</b>	bar	40	==>						
<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	42	57	68	70	69	67		
<b>hardness scattering:</b>	HRB	39-47	56-58	67-70	69-70	68-70	66-69		
<b>weight:</b>	g	17	==>						
<b>weight after sintering:</b>	g	16,88	17,047	16,771	16,888	16,646	16,899		

<b>volume:</b>									
$V = G_s - G_w$	cm <sup>3</sup>	2,03	1,997	1,903	1,899	1,868	1,898		
<b>density:</b>									
$D = G_s / V$	g/cm <sup>3</sup>	8,31	8,54	8,81	8,89	8,91	8,9		

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

<b>notes:</b>	
---------------	--

**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.