

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

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powder - code:	Diacob 1500
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main component:	Co	binder:	-	date:	15.01.2004
machine type:	DSP-25	aver. Grain size	FSSS = 1,2 - 1,6 µm	testperson:	OE
utilisation:					

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

temperature:	°C	660	700	740	780	820	860	900	940
specific pressure:	<i>N/mm²</i>	35	==>						
sintering time:	<i>min</i>	3	==>						

bending strength:	<i>N/mm²</i>								
stretch at break:	%								
average hardness:	HRB	95	103	107	108	110	106	103	99
hardness scattering:	HRB	94-95	102-104	106-108	107-109	109-110	104-107	103-104	98-99
weight:	<i>g</i>	17	==>						
weight after sintering:	<i>g</i>								

volume:	<i>cm³</i>								
V = G_s - G_w									
density:	<i>g/cm³</i>	7,9	8,4	8,64	8,71	8,73	8,75	8,75	8,75
D = G_s / V									

weight loss:	<i>g</i>								
G = G_e - G_s									
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 !
 In case of moulds with a high number of graphite punches a certain friction value needs to be considered. To obtain the detailed formula you are welcome to contact us.

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