

SINTERING-DATA-SHEET

DR. FRITSCH KG

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powder - code:	Diacob-4001
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main component:	Co	binder:	Dry	date:	09.01.02
machine type:	DSP-25	aver. Grain size	app. 5 µm	testperson:	Mö
utilisation:					

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

temperature:	°C	780	820	860	900	940	980	1020	1060
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	102	106	106	107	106	106	99	98
hardness scattering:	HRB	101-102	106-107	105-106	106-107	105-107	106-107	98-100	96-99
weight:	g	17	==>						
weight after sintering:	g	16,717	16,419	15,994	16,543	16,689	15,755	16,672	16,466

volume:									
V = G_s - G_w	cm ³	1,969	1,871	1,829	1,884	1,9	1,796	1,901	1,873
density:									
D = G_s / V	g/cm ³	8,49	8,77	8,75	8,78	8,78	8,77	8,77	8,79

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 !

Property of Dr. Fritsch KG. Transmission only allowed in explicit agreement with the management.