

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

DR. FRITSCH GmbH & Co. KG

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powder - code:	Diaweld-3000
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main component:	Fe, Ni	binder:	2% alcohol	date:	17.05.1999
machine type:	DSP-25	aver. Grain size		testperson:	CW
utilisation:					

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

temperature:	°C	740	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	39	50	60	64	60	67	75	
hardness scattering:	HRB	33-46	47-56	59-63	62-66	59-61	63-70	73-77	
weight:	g	17	==>						
weight after sintering:	g	16,7482	16,603	16,746	16,739	16,37	16,226	16,676	

volume:									
V = G_s - G_w	cm ³	2,384	2,312	2,268	2,25	2,18	2,158	2,2	
density:									
D = G_s / V	g/cm ³	7,02	7,18	7,38	7,44	7,51	7,52	7,58	

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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