

SINTERING-DATA-SHEET

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	DiaWeld-7200
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main component:	Co	binder:	2% alcohol	date:	31.08.2004
machine type:	DSP-25	aver. Grain size		testperson:	OE
utilisation:	Wear resistant laserweldable Backing				

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

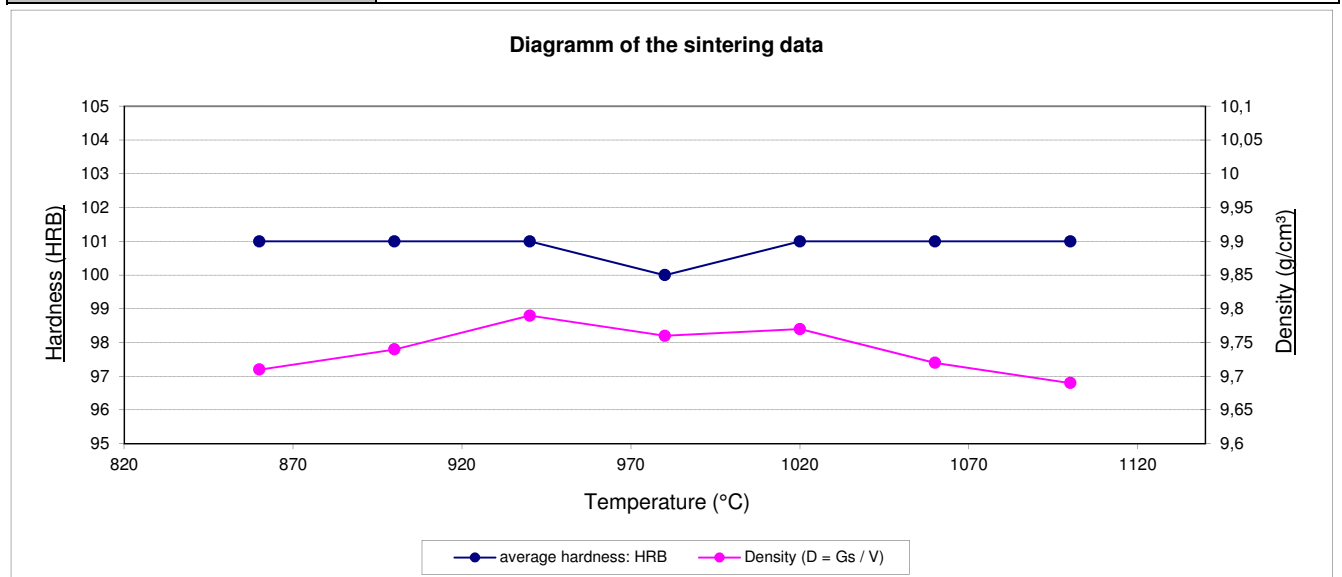
temperature:	$^{\circ}C$	860	900	940	980	1020	1060	1100	
specific pressure:	N/mm^2	35	==>						
sintering time:	min	3	==>						

bending strength:	N/mm^2								
stretch at break:	%								
average hardness:	HRB	101	101	101	100	101	101	101	
hardness scattering:	HRB	100-103	100-102	100-102	99-101	100-102	100-102	100-102	
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	cm^3								
Density ($D = G_s / V$)	g/cm^3	9,71	9,74	9,79	9,76	9,77	9,72	9,69	

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($Gr = G * 100$)	%								

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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