

# 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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<b>powder - code:</b>	HO-14
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<b>main component:</b>	Co	<b>binder:</b>	2% alcohol	<b>date:</b>	29.08.97
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>	20 µm	<b>testperson:</b>	Ga
<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	680	720	760	800	840			
<b>specific pressure:</b>	N/mm <sup>2</sup>	35	==>						
<b>machine pressure:</b>	bar	55	==>						
<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	91	93	92	92	92			
<b>hardness scattering:</b>	HRB	91-92	92-93	92-93	92-93	92-93			
<b>weight:</b>	g	17	==>						
<b>weight after sintering:</b>	g	16,104	16,696	16,556	16,546	16,58			

<b>volume:</b> V = G <sub>s</sub> - G <sub>w</sub>	cm <sup>3</sup>	1,873	1,919	1,903	1,901	1,904			
<b>density:</b> D = G <sub>s</sub> / V	g/cm <sup>3</sup>	8,6	8,7	8,7	8,7	8,71			

<b>weight loss:</b> G = G <sub>e</sub> - G <sub>s</sub>	g								
<b>rel. Weight loss:</b> Gr = G * 100 / G <sub>e</sub>	%								

<b>notes:</b>	
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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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