

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

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	V10-881
-----------------------	---------

main component:	Co	binder:	2% alcohol	date:	01.12.88
machine type:	DSP-25	aver. Grain size		testperson:	Ga
utilisation:					

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

temperature:	°C	780	820	860	900	940			
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	98	100	100	98	97			
hardness scattering:	HRB	97-99	100-101	99-100	97-99	98-99			
weight:	g	20	==>						
weight after sintering:	g	19,464	19,253	18,672	18,022	19,506			

volume:									
$V = G_s - G_w$	cm ³	2,266	2,203	2,135	2,074	2,246			
density:									
$D = G_s / V$	g/cm ³	8,59	8,74	8,75	8,69	8,68			

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

notes:	
---------------	--

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.