

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:	V11-397
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main component:	Co	binder:	2% alcohol	date:	03.03.97
machine type:	DSP-25	aver. Grain size	1 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	700	740	780	820	860			
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	88	110	110	110	110			
hardness scattering:	HRB	86-90	110-111	110-111	110-111	110-111			
weight:	g	17	==>						
weight after sintering:	g	16,459	15,791	15,934	15,652	15,573			

volume: V = G _s - G _w	cm ³	2,015	1,647	1,664	1,632	1,624			
density: D = G _s / V	g/cm ³	8,17	9,58	9,58	9,59	9,59			

weight loss: G = G _e - G _s	g				1,35	1,43			
rel. Weight loss: Gr = G * 100 / G _e	%				7,94	8,41			

notes:	==> liquid
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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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