

SINTERING-DATA-SHEET

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powder - code:	V14- 305
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main component:	Fe	binder:	2% alcohol	date:	09.02.2007
machine type:	DSP-25	aver. Grain size		testperson:	OE
utilisation:	cheaper bond for granite				

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

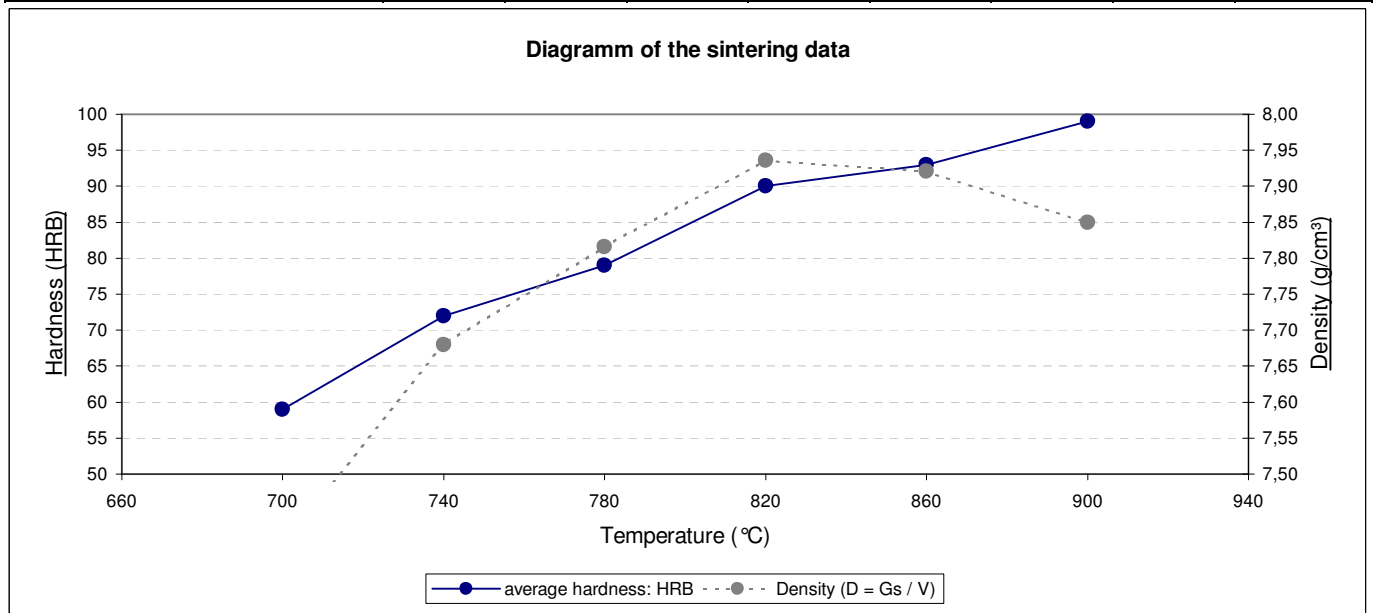
temperature:	°C	700	740	780	820	860	900		
specific pressure:	N/mm ²	35	==>						
sintering time:	min	3	==>						

bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	59	72	79	90	93	99		
hardness scattering:	HRB	56-64	69-76	76-81	89-91	92-95	98-100		
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	cm ³								
Density ($D = G_s / V$)	g/cm ³	7,40	7,68	7,82	7,94	7,92	7,85		

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($G_r = G * 10$)	%				11,01	18,94	20,28		

notes:				extrusion	==>				
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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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