

SINTERING-DATA-SHEET

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powder - code:	V14-315
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main component:	DSP-25	binder:	2 % alcohol	date:	24.04.2015
machine type:		aver. Grain size		testperson:	GK
utilisation:					

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

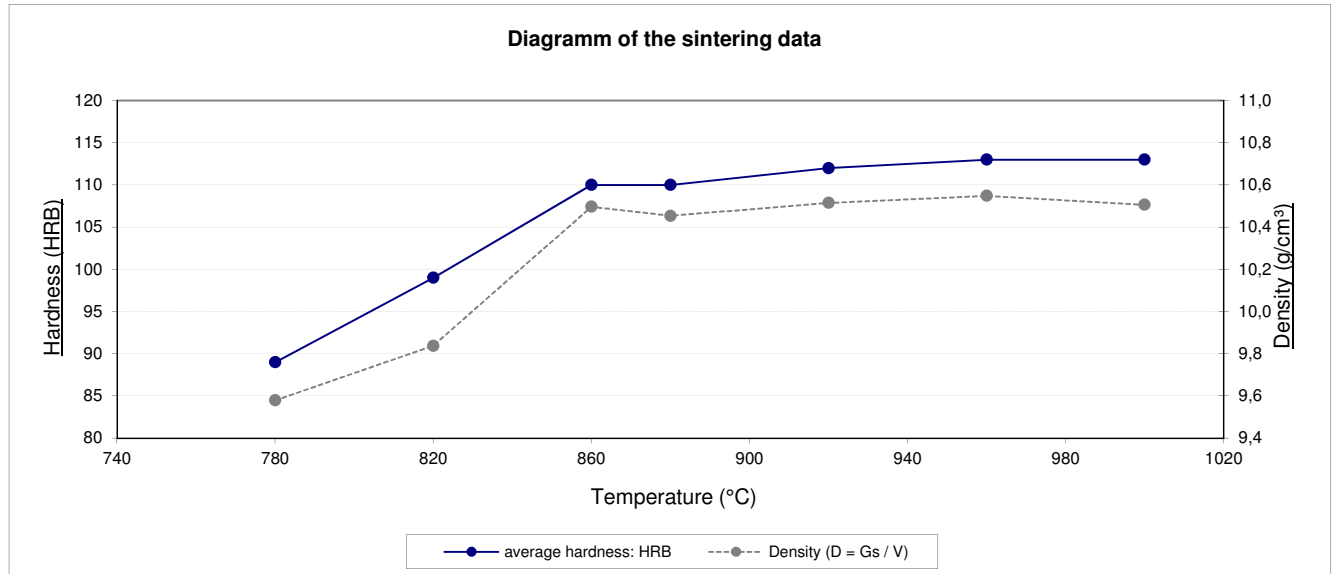
temperature:	$^{\circ}\text{C}$	780	820	860	880	920	960	1000	
specific pressure:	N/mm^2	35	==>						
sintering time:	min	3	==>						

bending strength:	N/mm^2								
stretch at break:	%								
average hardness:	HRB	89	99	110	110	112	113	113	
hardness scattering:	HRB	87-90	96-102	109-111	109-111	112-113	112-113	112-115	
average hardness:	HRC			37	37	41	43	41	
hardness scattering:	HRC			37	37	41	43	41	
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	cm^3								
Density ($D = G_s / V$)	g/cm^3	9,58	9,84	10,50	10,45	10,52	10,55	10,51	

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($Gr = G * 100$)	%							8,1	

notes:									
								extrusion	



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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