

# 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>	V15-785
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<b>main component:</b>	Co	<b>binder:</b>	2% alcohol	<b>date:</b>	01.05.94
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>		<b>testperson:</b>	Ga
<b>utilisation:</b>					

<b>heating by</b>	<b>die:</b>	X	<b>temperature measure-</b>	<b>pyroscope:</b>	
	<b>punches:</b>		<b>ment by:</b>	<b>thermocouple:</b>	X

<b>temperature:</b>	°C	1060	1100	1140				
<b>specific pressure:</b>	<i>N/mm<sup>2</sup></i>	25	==>					
<b>machine pressure:</b>	<i>bar</i>	40	==>					
<b>sintering time:</b>	<i>min</i>	3	==>					
<b>bending strength:</b>	<i>N/mm<sup>2</sup></i>							
<b>stretch at break:</b>	%							
<b>average hardness:</b>	HRC	28	43	45				
<b>hardness scattering:</b>	HRC	26-30	40-47	44-47				
<b>weight:</b>	<i>g</i>	20	==>					
<b>weight after sintering:</b>	<i>g</i>	19,699	19,847	19,325				

<b>volume:</b>								
$V = G_s - G_w$	<i>cm<sup>3</sup></i>	2,076	1,883	1,825				
<b>density:</b>								
$D = G_s / V$	<i>g/cm<sup>3</sup></i>	9,49	10,23	10,54				

<b>weight loss:</b>								
$G = G_e - G_s$	<i>g</i>			4,1				
<b>rel. Weight loss:</b>								
$Gr = G * 100 / G_e$	%			16,5				

<b>notes:</b>	==> 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 !

Property of Dr. Fritsch KG. Transmission only allowed in explicit agreement with the management.