

# 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

<b>powder - code:</b>	V17-785
-----------------------	---------

<b>main component:</b>	WC	<b>binder:</b>	2% alcohol	<b>date:</b>	19.09.94
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>	10 µm	<b>testperson:</b>	Ga
<b>utilisation:</b>					

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

<b>temperature:</b>	°C	1100	1120	1160	1180				
<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	25	30	50	52				
<b>hardness scattering:</b>	HRC	24-27	28-31	48-50	50-55				
<b>weight:</b>	<i>g</i>	25	==>						
<b>weight after sintering:</b>	<i>g</i>	20,03	19,994	19,749	19,112				

<b>volume:</b> $V = G_s - G_w$	<i>cm<sup>3</sup></i>	2,017	1,91	1,71	1,625				
<b>density:</b> $D = G_s / V$	<i>g/cm<sup>3</sup></i>	9,93	10,47	11,55	11,76				

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

<b>notes:</b>	
---------------	--

**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.