

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

powder - code:	V19-785
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main component:	WC	binder:	2% alcohol	date:	25.10.94
machine type:	DSP-25	aver. Grain size		testperson:	Ga
utilisation:					

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

temperature:	°C	1140	1180	1220				
specific pressure:	N/mm ²	20	==>					
machine pressure:	bar	32	==>					
sintering time:	min	3	==>					
bending strength:	N/mm ²							
stretch at break:	%							
average hardness:	HRC	60	65	70				
hardness scattering:	HRC	58-62	69-71	73-74				
weight:	g	20	==>					
weight after sintering:	g	19,725	18,122	17,048				

volume:								
$V = G_s - G_w$	cm ³	1,536	1,341	1,222				
density:								
$D = G_s / V$	g/cm ³	12,84	13,51	13,95				

weight loss:								
$G = G_e - G_s$	g		1,89	2,95				
rel. Weight loss:								
$Gr = G * 100 / G_e$	%		9,39	14,76				

notes:	
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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.