

SINTERING-DATA-SHEET

DR. FRITSCH GmbH & Co. KG

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powder - code:	V20- 592
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main component:	Cu	binder:	2% alcohol	date:	12.09.2008
machine type:	DSP-25	aver. Grain size	< 63 µm	testperson:	OM
utilisation:	bond for honing sticks				

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

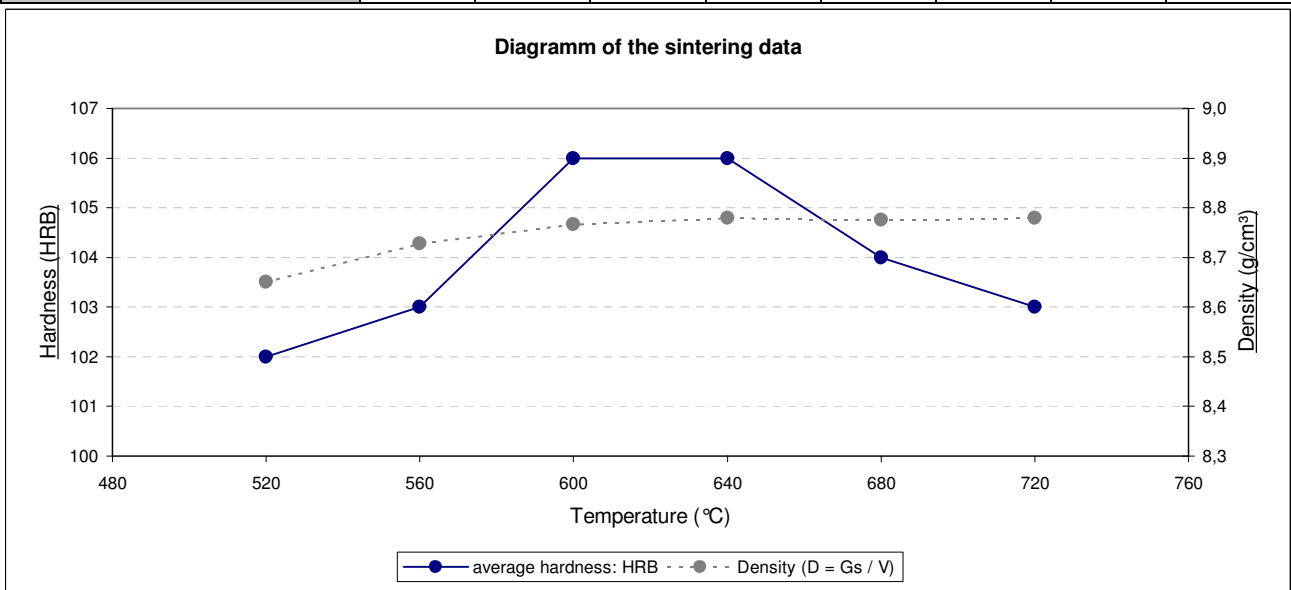
temperature:	°C	520	560	600	640	680	720		
specific pressure:	<i>N/mm²</i>	35	==>						
sintering time:	<i>min</i>	3	==>						

bending strength:	<i>N/mm²</i>								
stretch at break:	%								
average hardness:	HRB	102	103	106	106	104	103		
hardness scattering:	HRB	100 - 103	102 - 105	105 - 107	104 - 107	102 - 107	101 - 105		
average hardness:	HRC								
hardness scattering:	HRC								
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	<i>cm³</i>								
Density ($D = G_s / V$)	<i>g/cm³</i>	8,65	8,73	8,77	8,78	8,78	8,78		

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($G_r = G * 100 / G_s$)	%								

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 !
 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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