

SINTERING-DATA-SHEET

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	V21-1113
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main component:	Fe	binder:		date:	10.12.2013
machine type:	DSP-25	aver. Grain size		testperson:	OE
utilisation:	Bond for Fickert - hard				

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

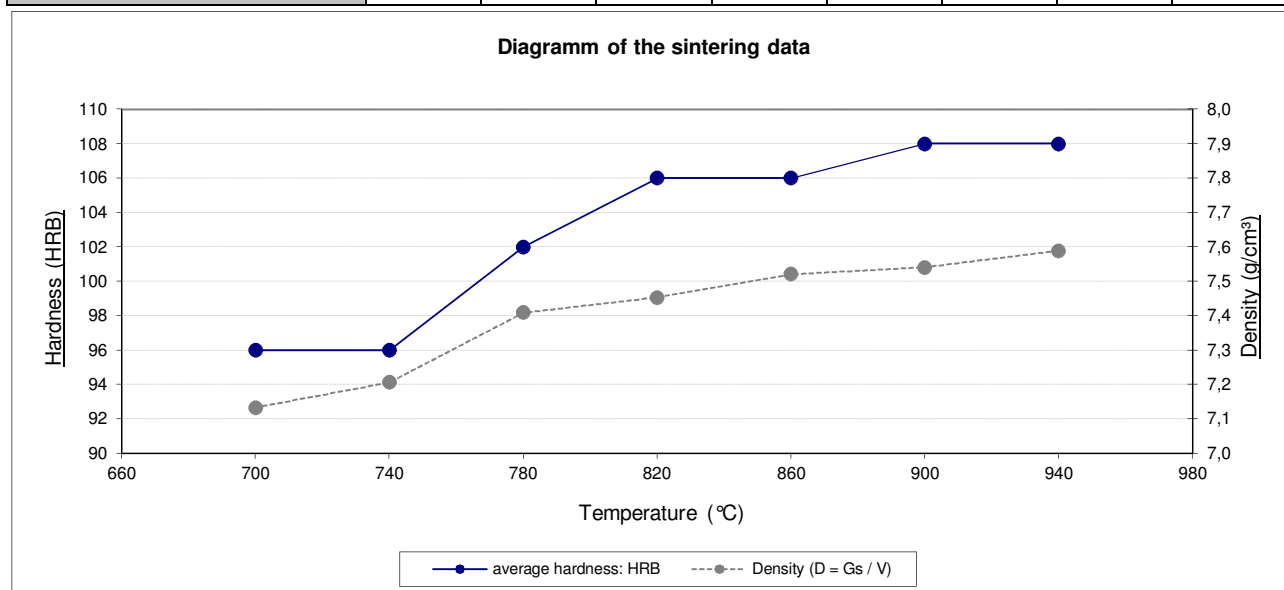
temperature:	°C	700	740	780	820	860	900	940	
specific pressure:	N/mm ²	35	==>						
sintering time:	min	3	==>						

bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	96	96	102	106	106	108	108	
hardness scattering:	HRB	89-101	93-98	100-103	105-107	105-107	106-108	107-110	
average hardness:	HRC								
hardness scattering:	HRC								
weight:	g	17	==>						
weight after sintering:	g								

Volume ($V = G_s - G_w$)	cm ³								
Density ($D = G_s / V$)	g/cm ³	7,13	7,21	7,41	7,45	7,52	7,54	7,59	

weight loss ($G = G_e - G_s$)	g								
rel. Weight loss ($G_r = G * 100 / G_s$)	%							12	

notes:								extrusion	
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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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