

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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70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	V24-1080
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main component:	Cu	binder:	2% alcohol	date:	10.04.97
machine type:	DSP-25	aver. Grain size	20 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	640	680	720	760				
specific pressure:	N/mm ²	25	==>						
machine pressure:	bar	57	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	80	80	78	73				
hardness scattering:	HRB	81-83	81-82	78-79	72-75				
weight:	g	17	==>						
weight after sintering:	g	16,482	16,668	16,69	16,483				

volume:									
V = G_s - G_w	cm ³	1,853	1,875	1,892	1,884				
density:									
D = G_s / V	g/cm ³	8,89	8,89	8,82	8,75				

weight loss:									
G = G_e - G_s	g								
rel. Weight loss:									
Gr = G * 100 / G_e	%								

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 !

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