

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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powder - code:	V4-881
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main component:	Cu	binder:	2% alcohol	date:	01.04.88
machine type:	DSP-25	aver. Grain size	20 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	660	680	700	740	780	800		
specific pressure:	<i>N/mm²</i>	35	==>						
machine pressure:	<i>bar</i>	55	==>						
sintering time:	<i>min</i>	3	==>						
bending strength:	<i>N/mm²</i>								
stretch at break:	%								
average hardness:	HRB	80	84	86	86	84	84		
hardness scattering:	HRB	78-83	82-85	85-86	85-87	83-85	82-84		
weight:	<i>g</i>	20	==>						
weight after sintering:	<i>g</i>	19,512	19,748	19,698	19,293	19,623	19,161		

volume:									
V = G_s - G_w	<i>cm³</i>	2,269	2,255	2,244	2,196	2,247	2,196		
density:									
D = G_s / V	<i>g/cm³</i>	8,6	8,76	8,78	8,79	8,76	8,73		

weight loss:									
G = G_e - G_s	<i>g</i>								
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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