

# S I N T E R I N G - D A T A - S H E E T

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<b>powder - code:</b>	V6- 1087
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<b>main component:</b>	W	<b>binder:</b>	2% alcohol	<b>date:</b>	14.09.95
<b>machine type:</b>	DSP-25	<b>aver. Grain size</b>	<20 µm	<b>testperson:</b>	Ga
<b>utilisation:</b>					

<b>heating by</b>	<b>die:</b>	X	<b>temperature measure-</b>	<b>pyroscope:</b>	
	<b>punches:</b>		<b>ment by:</b>	<b>thermocouple:</b>	X

<b>temperature:</b>	°C	700	740	780	820	860			
<b>specific pressure:</b>	N/mm <sup>2</sup>	20	==>						
<b>machine pressure:</b>	bar	32	==>						
<b>sintering time:</b>	min	3	==>						
<b>bending strength:</b>	N/mm <sup>2</sup>								
<b>stretch at break:</b>	%								
<b>average hardness:</b>	HRB	104	107	107	108	111			
<b>hardness scattering:</b>	HRB	103-105	106-107	107-108	107-109	111-112			
<b>weight:</b>	g	17	==>						
<b>weight after sintering:</b>	g	16,545	16,132	15,354	14,7	13,963			

<b>volume:</b>									
<b>V = G<sub>s</sub> - G<sub>w</sub></b>	cm <sup>3</sup>	1,456	1,393	1,311	1,236	1,148			
<b>density:</b>									
<b>D = G<sub>s</sub> / V</b>	g/cm <sup>3</sup>	11,36	11,58	11,71	11,89	12,16			

<b>weight loss:</b>									
<b>G = G<sub>e</sub> - G<sub>s</sub></b>	g			1,65	2,3	3,04			
<b>rel. Weight loss:</b>									
<b>Gr = G * 100 / G<sub>e</sub></b>	%			9,68	13,53	17,86			

<b>notes:</b>	==> liquid
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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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