

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

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

<b>powder - code:</b>	V6-881
-----------------------	--------

<b>main component:</b>	Cu	<b>binder:</b>	2% alcohol	<b>date:</b>	11.12.90
<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- ment by:</b>	<b>pyroscope:</b>	
	<b>punches:</b>			<b>thermocouple:</b>	X

<b>temperature:</b>	°C	660	700	740	780	820	860	900	
<b>specific pressure:</b>	N/mm <sup>2</sup>	35	==>						
<b>machine pressure:</b>	bar	55	==>						
<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	86	88	89	90	90	86	83	
<b>hardness scattering:</b>	HRB	84-87	87-90	89- 90	90-91	90-91	86-87	82-83	
<b>weight:</b>	g	20	==>						
<b>weight after sintering:</b>	g	19,806	19,909	19,768	19,764	18,706	17,441	15,586	

<b>volume:</b> V = G <sub>s</sub> - G <sub>w</sub>	cm <sup>3</sup>	2,314	2,281	2,257	2,253	2,141	2,006	1,804	
<b>density:</b> D = G <sub>s</sub> / V	g/cm <sup>3</sup>	8,56	8,73	8,76	8,77	8,74	8,69	8,64	

<b>weight loss:</b> G = G <sub>e</sub> - G <sub>s</sub>	g					1,29	2,56	4,41	
<b>rel. Weight loss:</b> Gr = G * 100 / G <sub>e</sub>	%					6,5	12,8	22,1	

<b>notes:</b>	
---------------	--

**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 !

Property of Dr. Fritsch KG. Transmission only allowed in explicit agreement with the management.