

SINTERING-DATA-SHEET

DR. FRITSCH GmbH & Co. KG

Dieselstraße 8

70736 Fellbach

Tel. 0711-518320; Fax 0711-5183210

powder - code:	Diacutin 90/10
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main component:	Cu, Sn	binder:		date:	17.07.97
machine type:	DSP-25	aver. Grain size	<45 µm	testperson:	Ga
utilisation:					

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

temperature:	°C	600	640	680	720				
specific pressure:	N/mm ²	25	==>						
machine pressure:	bar	40	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	69	70	69	67				
hardness scattering:	HRB	69-70	69-71	68-70	66-67				
weight:	g	17	==>						
weight after sintering:	g	16,883	16,668	16,836	16,819				

volume:									
V = G_s - G_w	cm ³	1,914	1,875	1,893	1,894				
density:									
D = G_s / V	g/cm ³	8,82	8,89	8,89	8,88				

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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