

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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Tel. 0711-518320; Fax 0711-5183210

powder - code:	V19-1099
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main component:	Co	binder:	2 % alcohol	date:	9.11.99
machine type:	DSP-25	aver. Grain size		testperson:	Mö
utilisation:					

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

temperature:	°C	780	820	860	900	940			
specific pressure:	N/mm ²	35	==>						
machine pressure:	bar	55	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²								
stretch at break:	%								
average hardness:	HRB	89	98	100	98	97			
hardness scattering:	HRB	87-92	95-99	99-101	97-99	96-97			
weight:	g	20	==>						
weight after sintering:	g	19,795	19,871	19,266	19,147	18,281			

volume: V = G _s - G _w	cm ³	2,209	2,123	2,038	2,024	1,936			
density: D = G _s / V	g/cm ³	8,96	9,36	9,45	9,46	9,44			

weight loss: G = G _e - G _s	g					1,719			
rel. Weight loss: Gr = G * 100 / G _e	%					8,6			

notes:	pearls
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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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