

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:	V28- 903
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main component:	Co	binder:	2% alcohol	date:	05.11.2003
machine type:	DSP-25	aver. Grain size	20 - 30 µm	testperson:	OE
utilisation:	Wire saw for granite, softer version from V 7- 103				

heating by	die:	X	temperature measure-	pyroscope:	
	punches:		ment by:	thermocouple:	X

temperature:	°C	660	700	740	780	820	860		
specific pressure:	<i>N/mm²</i>	35	==>						
sintering time:	<i>min</i>	3	==>						

bending strength:	<i>N/mm²</i>								
stretch at break:	%								
average hardness:	HRB	99	105	106	105	105	99		
hardness scattering:	HRB	94-100	104-106	106-107	105	103-106	98-99		
weight:	<i>g</i>	17	==>						
weight after sintering:	<i>g</i>								

volume:	<i>cm³</i>								
V = Gs - Gw									
density:	<i>g/cm³</i>	8,62	8,94	9,02	8,99	8,98	8,96		
D = Gs / V									

weight loss:	<i>g</i>								
G = Ge - Gs									
rel. Weight loss:	%					7,3	11,7		
Gr = G * 100 / Ge									

notes:	slight Extrusion Extrusion
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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 !
In case of moulds with a high number of graphite punches a certain friction value needs to be considered. To obtain the detailed formula you are welcome to contact us.

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