

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:	V3-1000
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main component:	Co	binder:	2% Alkohol	date:	28.09.01
machine type:	DSP-25	aver. Grain size		testperson:	Mö
utilisation:					

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

temperature:	°C	700	740	780	820	860			
specific pressure:	N/mm ²	35	==>						
machine pressure:	bar	55	==>						
sintering time:	min	3	==>						
bending strength:	N/mm ²	0							
stretch at break:	%	0							
average hardness:	HRB	105	111	110	107	106			
hardness scattering:	HRB	104-105	110-112	109-111	106-108	106-107			
weight:	g	17	==>						
weight after sintering:	g	16,38	16,191	16,281	15,06	14,731			

volume: V = G _s - G _w	cm ³	1,733	1,656	1,652	1,52	1,483			
density: D = G _s / V	g/cm ³	9,45	9,78	9,85	9,91	9,93			

weight loss: G = G _e - G _s	g				1,92	2,269			
rel. Weight loss: Gr = G * 100 / G _e	%				11,29	13,35			

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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